3M

Instructions and Parts List

3M-Matic™

200a Type 40800

Adjustable Case Sealer

with AccuGlide™ 3 Taping Heads

Serial No._____

For reference, record machine serial number here.

Parts 800-344-9883 1/6/16 TF.

3M

3M Industrial Adhesives and Tapes
3M Center, Building 220-5E-06
St. Paul, MN 55144-1000

Important Safety Information

BEFORE INSTALLING OR OPERATING THIS EQUIPMENT
Read, understand, and follow all safety and operating instructions.

Spare Parts

It is recommended you immediately order the spare parts listed in the "Spare Parts/Service Information" section. These parts are expected to wear through normal use, and should be kept on hand to minimize production delays.

Replacement Parts and Service Information

To Our Customers:

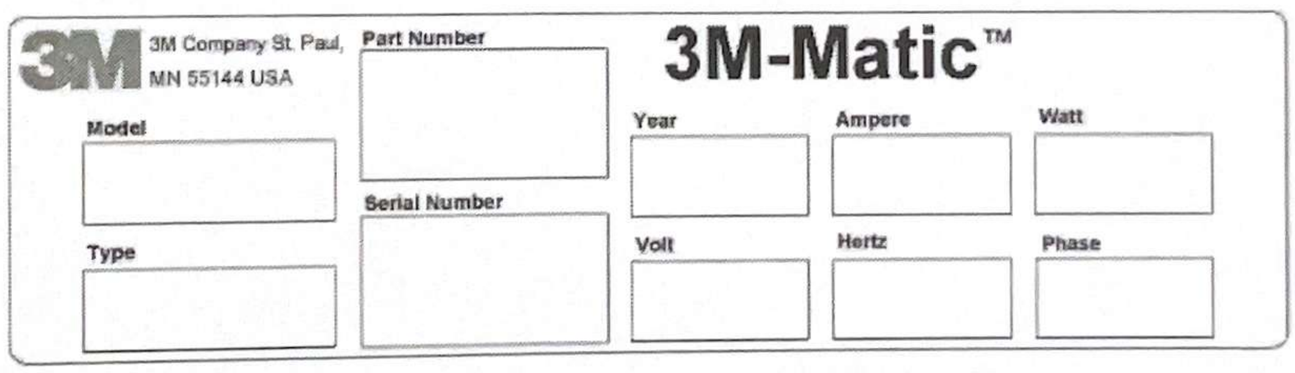
This is the 3M-Matic™/AccuGlide™/Scotch® equipment you ordered. It has been set up and tested in the factory with Scotch® tapes. If technical assistance or replacement parts are needed, call or fax the appropriate number listed below.

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

Technical Assistance / Replacement Parts and Additional Manuals:

Contact your local service provider. Provide the customer support coordinator with the model/machine name, machine type, and serial number that are located on the identification plate (For example: Model 700a - Type 40800 - Serial Number 13282).

Identification Plate



Minimum billing on parts orders will be $25.00. Replacement part prices available on request.
$10.00 restocking charge per invoice on returned parts

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St. Paul, MN 55144-1000

Printed in U.S.A.

TABLE OF CONTENTS - MANUAL 1: 200a Adjustable Case Sealer
(For Taping Head Information - See MANUAL 2: AccuGlide™ 3 Taping Heads - 2 inch)

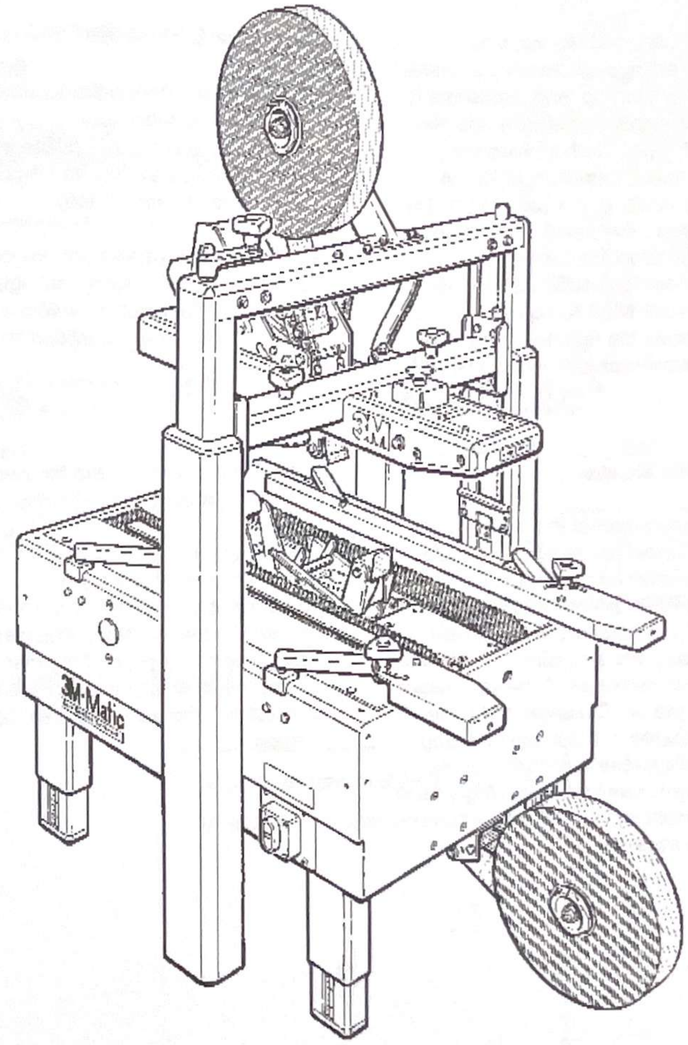
200a Adjustable Case Sealer **Page**

LIST OF ABBREVIATIONS, ACRONYMS

3M-Matic	- Trademark of 3M St. Paul, MN 55144- 1000
AccuGlide	- Trademark of 3M St. Paul, MN 55144-1000
Scotch	- Trademark of 3M St. Paul, MN 55144-1000
Drw.	- drawing
Ex.	- for example
Fig.	- exploded view figure no. (spare parts)
Figure	- Illustration
Max.	- maximum
Min.	- minimum
Nr.	- number
N/A	- not applicable
OFF	- machine not operating
ON	- machine operating
PLC	- Programmable Logic Control
PP	- Polypropylene
PTFE	- Polytetraflourethelene
PVC	- Poly-vinyl chloride
W	- Width
H	- Height
L	- Length

1.1 Manufacturing Specifications / Description / Intended Use

The **3M-Matic™ 200a Adjustable Case Sealer** with **AccuGlide™ 3** Taping Heads is designed to apply a "C" clip of **Scotch®** pressure-sensitive film box sealing tape to the top and bottom center seam of regular slotted containers. The 200a is manually adjustable to a wide range of box sizes (see "Specifications Section – Box Weight and Size Capacities").



3M-Matic™ 200a Adjustable Case Sealer, Type 40800

Note – Shown above is the lower tape supply roll and bracket assembly in the alternate location.

3.12 Component Locations

Refer to **Figure 3-9** below to acquaint yourself with the various components and controls of the case sealer. Also refer to Manual 2 for taping head components.

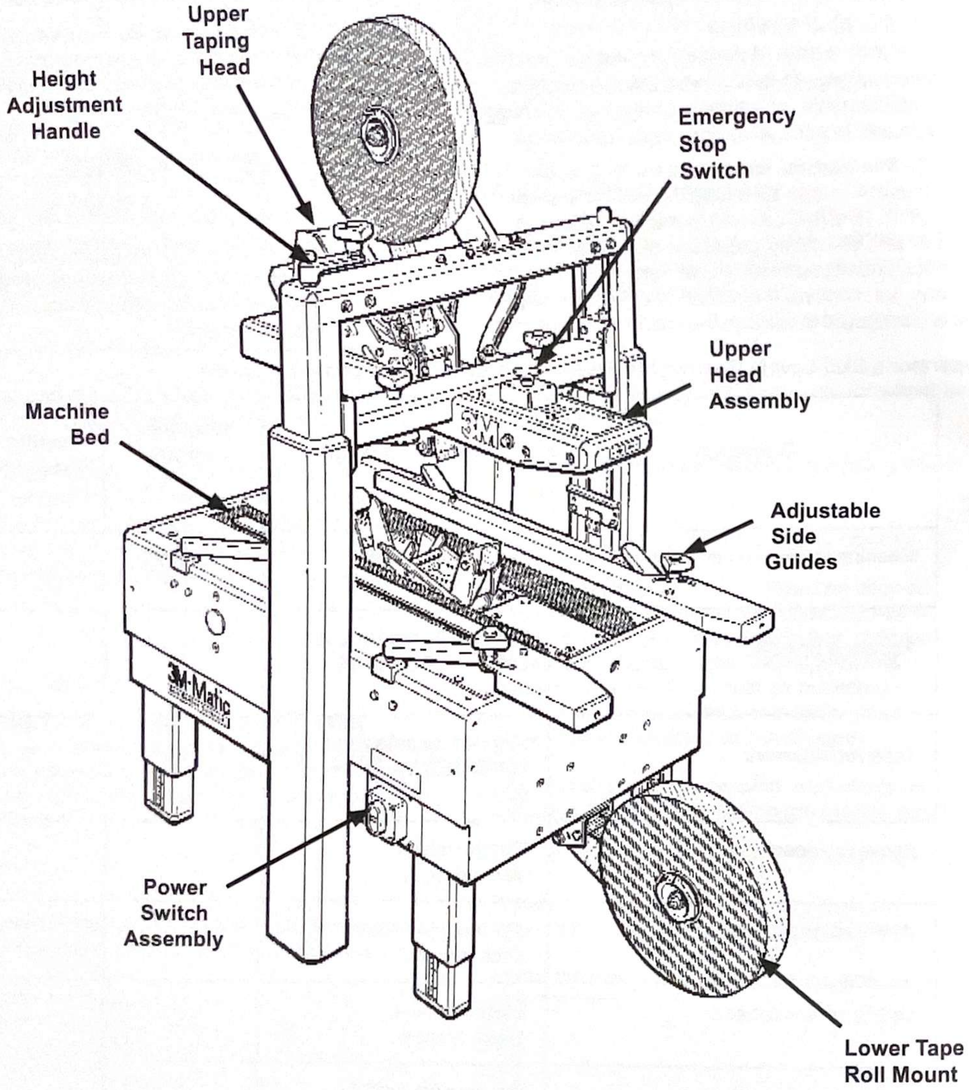


Figure 3-9—200a Case Sealer Components (Left Front View)

3.13 Table of Warnings and Replacements Labels (continued)

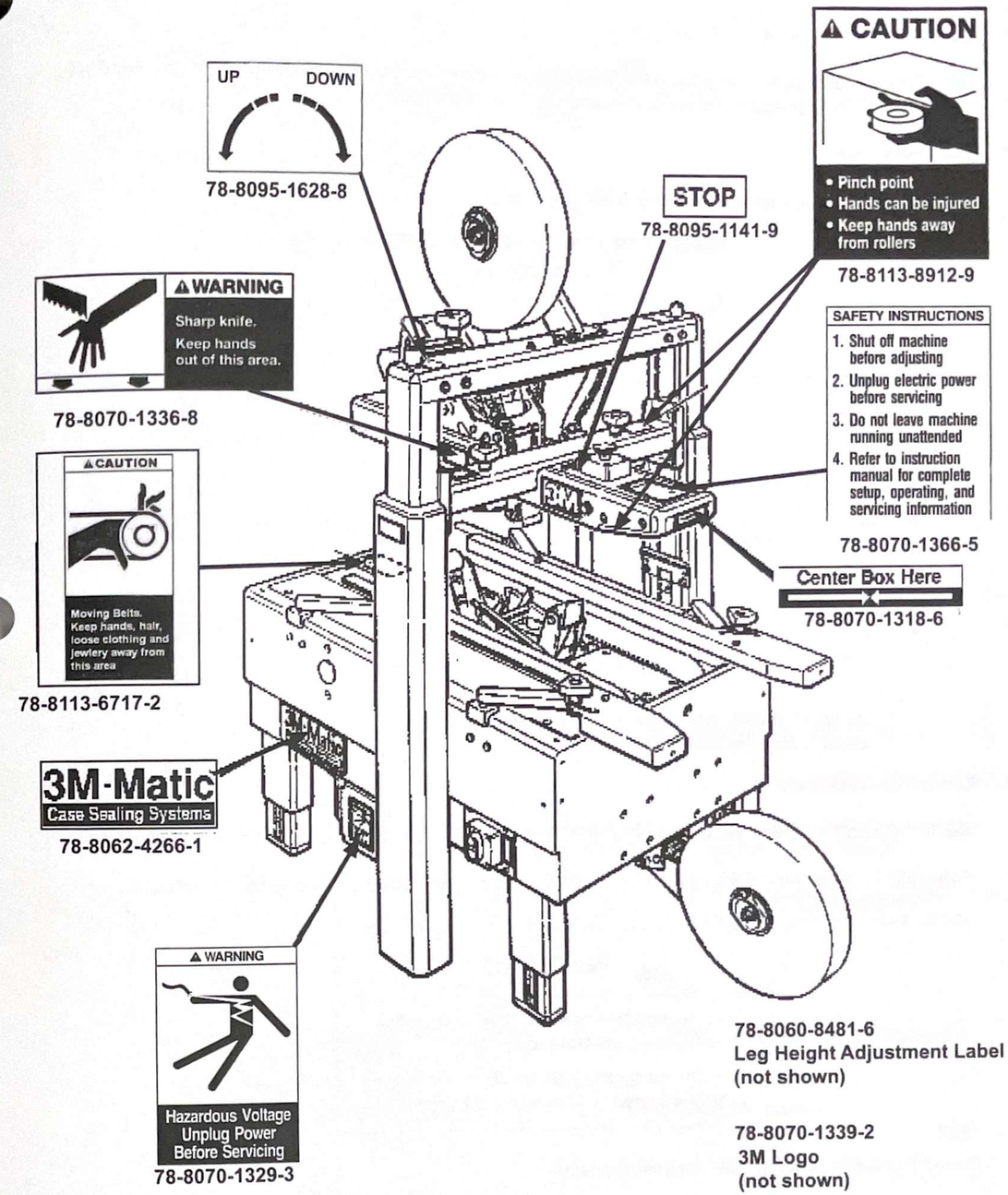


Figure 3-10 - Replacement Labels / 3M Part Numbers

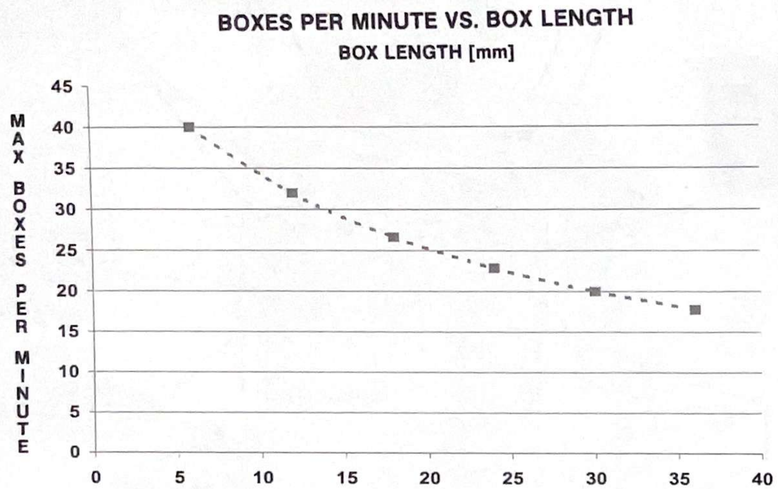
1. **Power Requirements**

   Electrical: 115 Volt,60Hz, 1.9 A (220 watts)

   The machine is equipped with a 2.4m [8 foot] standard neoprene covered power cord and a grounded plug. Contact your 3M Representative for power requirements not listed above.

2. **Operating Rate**

   Box drive belt speed is approximately 0.5 m/s [100 feet per minute].



   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 4.4° C to 48.9° C [40° F to 120° F] with clean, dry boxes.

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

> **⚠ WARNING**
>
> - **To reduce the risk associated with fire and explosion hazards:**
>
>   – Do not operate this equipment in potentially flammable or explosive environments.

4. **Tape**

   Scotch® pressure-sensitive film box sealing tapes.

5. **Tape Width**

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

Specifications

6. **Tape Roll Diameter**

   Up to 405mm [16 inch] maximum on a 76.2mm [3 inch] diameter core.

   (Accommodates all system roll lengths of **Scotch®** film tapes.)

7. **Tape Application Leg Length – Standard**

   70 mm ± 6mm [2.75 inch ±. 25 inch]

   Tape Application Leg Length – Optional
   50 mm ± 6mm [2 inch ±. 25 inch]
   (See "Removing Taping Heads Procedure – Changing the Tape Leg Length")

8. **Box Board**

   Style – regular slotted containers – RSC
   125 to 275 P.S.I. bursting test, single wall or double wall B or C flute.
   23-44 lbs. per inch of width Edge Crush Test (ECT)

9. **Box Weight and Size Capacities**

   A. Box Weight, filled: 5 lbs.–65 lbs. [2.3 kg–29.5 kg]. Contents must support flaps.

   B. Box Size:

	Minimum	Maximum
Length –	150mm [6.0 inch]	Unlimited
Width –	150mm [6.0 inch]*	550mm [21.5 inch]
Height –	120mm [4.75 inch]** ***	620mm [24.5 inch] ***

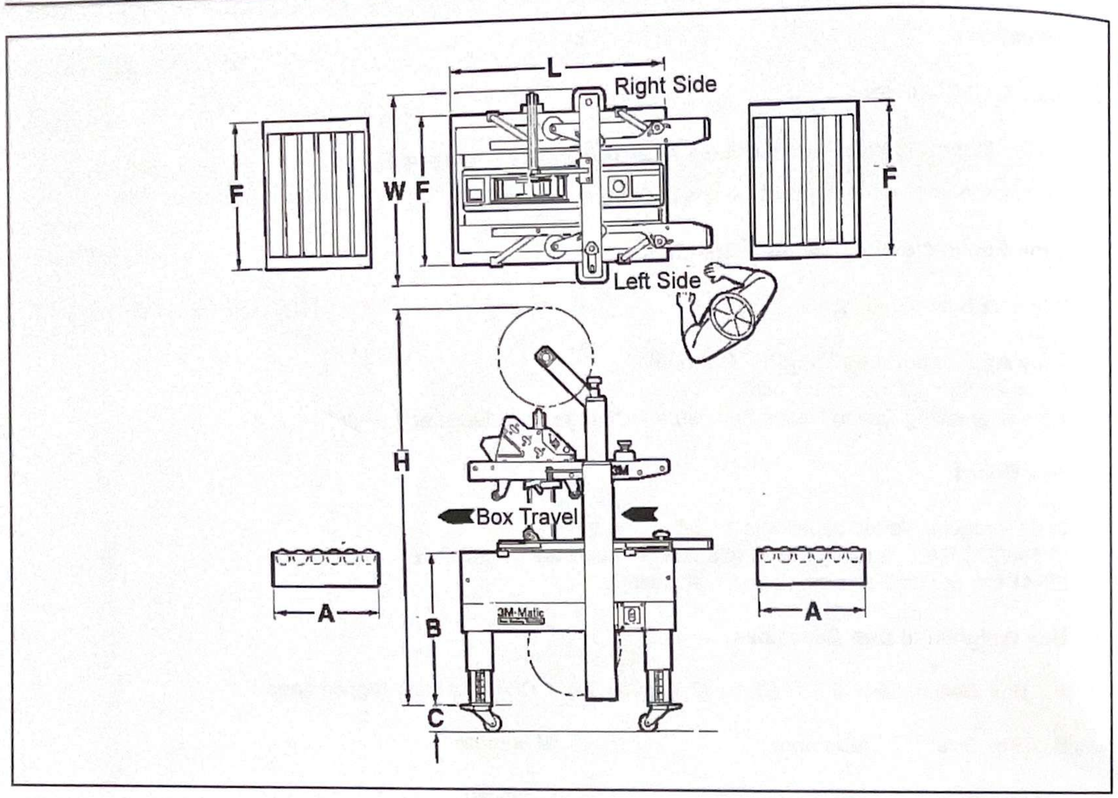
   * Cartons narrower than 250mm [10 inch] in width may require more frequent belt replacement because of limited contact area.
   ** 90mm [3.5 inch] height with heads adjusted to apply 50mm [2 inch] tape leg lengths. (See "Special Setup Procedure—Changing the Tape Leg Length".)
   *** 165mm [6.5 inches] minimum to 725mm [28.5 inches] maximum height with columns adjusted to upper position. (See "Special Set-Up Procedure – Box and Machine Bed Height Range".)

Note: The case sealer can accommodate most boxes within the size range listed above. However, if the box length (in direction of seal) to box height ratio is 0.6 or less, test run several boxes to ensure proper machine performance.

DETERMINE THE BOX LIMITATIONS BY COMPLETING THIS FORMULA:

$$\frac{\text{BOX LENGTH IN DIRECTION OF SEAL}}{\text{BOX HEIGHT}} = \text{SHOULD BE GREATER THAN 0.6}$$

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



10. Machine Dimensions

	W	L	H	A*	B	C**	F
Minimum							
mm	790	930	1350	460	610	100	620
[Inches]	[31]	[36 1/2]	[53]	[18]	[24***]	[4]	[24 1/2]
Maximum							
mm			2185		890		
[Inches]	--	--	[86***]	--	[35***]	--	--

* Infeed/Exit conveyors are optional
** Casters are optional
*** When columns are adjusted to upper position, "B" minimum/maximum dimension decreases by 90 mm [3 1/2 inches] and "H" maximum dimension increases by 100 mm [4 inch]. (See "Special Set-Up Procedure – Box and Machine Bed Height Range".)

Weight – 145.6 kg [320 lbs] crated (approximate)
123.4 kg [280 lbs] uncrated (approximate)

11. **Machine Noise Level:** Acoustic pressure measured at a distance of 1m. from machine with Scotch PVC adhesive tape in operation; 78dB Acoustic radiation pressure at 1.6m. height with Scotch PVC adhesive tape in operation; 73dB Measurement taken with appropriate instrument: (Type SPYRI-MICROPHON 11).

12. **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.

5.1 Shipment and Handling of Packed Machine

- The machine is fixed on the pallet with four (4) bolts and can be lifted by using a fork truck.
- The package is suitable to travel by land and by air.
- Optional sea freight package is available.

Packaging Overall Dimensions (Figure 5-1)

See Specifications.

During the shipment it is possible to stack a maximum of 2 machines **(Figure 5-2).**

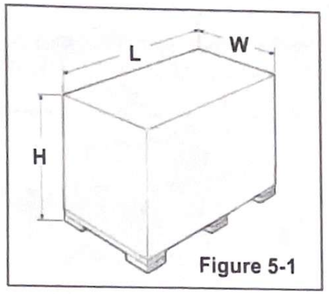


Figure 5-1

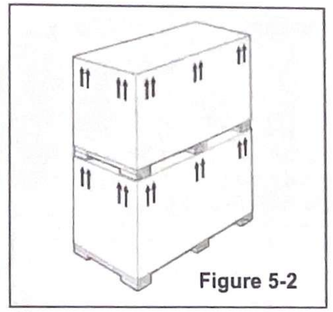


Figure 5-2

5.2 Packaging for Overseas Shipment (Optional - Figure 5-3)

The machines shipped by sea freight are covered by an aluminum/polyester/polythene bag which contains dehydrating salts.

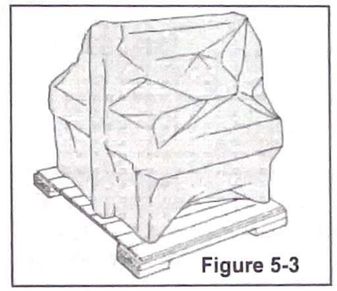


Figure 5-3

5.3 Handling and Transportation of Uncrated Machine

The uncrated machine should not be moved except for short distances and indoors ONLY. Without the supporting pallet, the machine is exposed to damage and may cause injuries. To move the machine use belts or ropes, paying attention to place them in the points indicated using care to not interfere with the lower taping head **(Figure 5-4).**

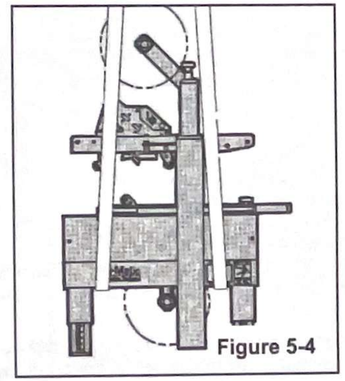


Figure 5-4

5.4 Storage of the Packed or Unpacked Machine

If the machine is not used for a long period, please take the following precautions:

- Store the machine in a dry and clean place.
- If the machine is unpacked it is necessary to protect it from dust.
- Do not stack anything over the machine.
- It is possible to stack a maximum of 2 machines (if they are in their original packing).

6.1 Uncrating

The envelope attached to the shipping box contains the uncrating instructions of the machine **(Figure 6-1)**.

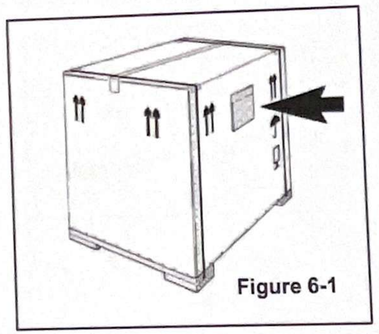


Figure 6-1

Cut straps. Cut out staple positions along the bottom of the shipping box (or remove staples with an appropriate tool - **Figure 6-2)**

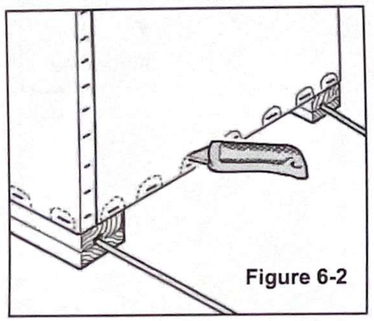


Figure 6-2

After cutting out or removing the staples, lift the shipping box in order to clear the machine (two persons required).

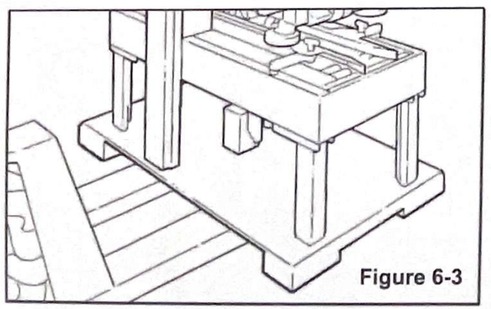


Figure 6-3

Transport the machine with a fork-lift truck to the operating position. Lift the pallet at the point indicated in **Figure 6-3** (weight of machine + pallet = 145.6 kg).

Removal of Pallet

Loosen and remove nuts and brackets using the open end spanner supplied in the tool box **(Figure 6-4)**.

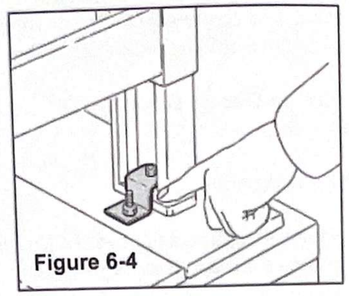


Figure 6-4

A cardboard box is located under the machine body. Retrieve the instruction manual for additional procedures of the set up. The box also contains parts removed for shipping, spare parts and tools **(Figure 6-5)**.

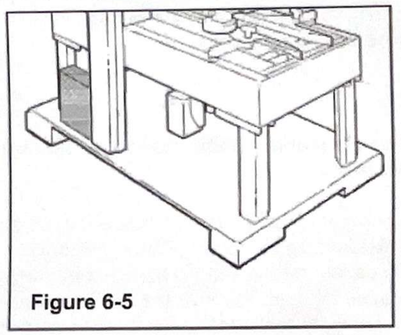


Figure 6-5

6.2 Disposal of Packaging Materials

The 200a-NA package is composed of:

- Wooden pallet
- Cardboard shipping box
- Wooden supports
- Metal fixing brackets
- PU foam protection
- PP plastic straps
- Dehydrating salts in bag
- Special bag of laminated polyester/aluminium/ Polyethylene (sea freight package only)
- Polyethylene protective material

For the disposal of the above materials, please follow the environmental directives or the law in your country.

7.1 Operating Conditions

The machine should operate in a dry and relatively clean environment (See Specifications).

7.2 Space Requirements for Machine Operation and Maintenance Work

Minimum distance from wall **(Figure 7-1)**:

A = 1000mm.
B = 700mm.
Minimum height = 2700mm.

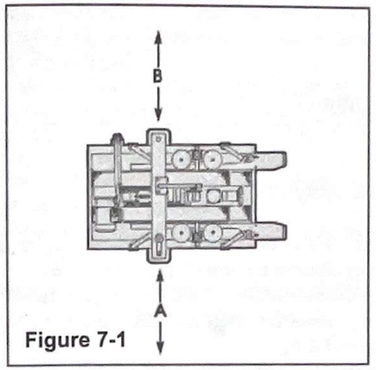


Figure 7-1

7.3 Tool Kit Supplied with the Machine

A tool kit containing some tools are supplied 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.

⚠ WARNING

- **To reduce the risk associated with mechanical and electrical hazards:**
  - Allow only properly trained and qualified personnel to operate and service this equipment.

⚠ WARNING

- **To reduce the risk associated with muscle strain:**
  - Use the appropriate rigging and material handling equipment when lifting or repositioning this equipment.
  - Use proper body mechanics when removing or installing taping heads that are moderately heavy or may be considered awkward to lift.

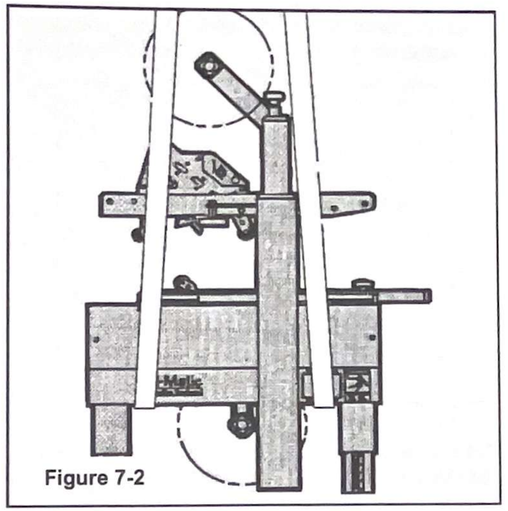


Figure 7-2

7.4 Machine Set-Up / Bed Height

Adjust machine bed height. The case sealer is equipped with four (4) adjustable legs that are located at the corners of the machine frame. The legs can be adjusted to obtain different machine bed heights from 520mm [20 1/2 inches] minimum to 785mm [31 inches] maximum.

Refer to **Figure 7-3** 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 (2) M8 x 1.25 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 (4) legs equally.

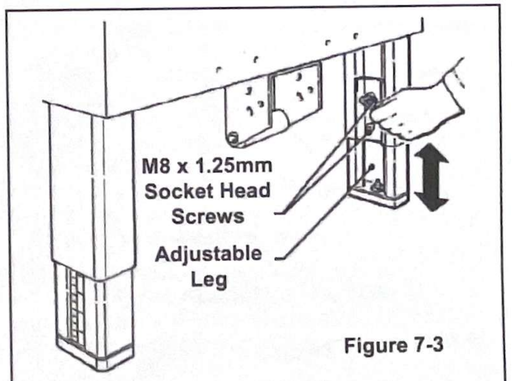


Figure 7-3