

## Instructions and Parts List

# 3M-Matic™

## 7000a-I / 7000a3-I Pro

Type 11700

# Adjustable Case Sealer with AccuGlide™ 3 Taping Heads

Serial #: \_\_\_\_\_  
*For reference, record machine serial number here.*

### Important Safety Information

BEFORE INSTALLING OR OPERATING THIS EQUIPMENT

Read, understand and follow all safety and operating instructions.

### Spare Parts

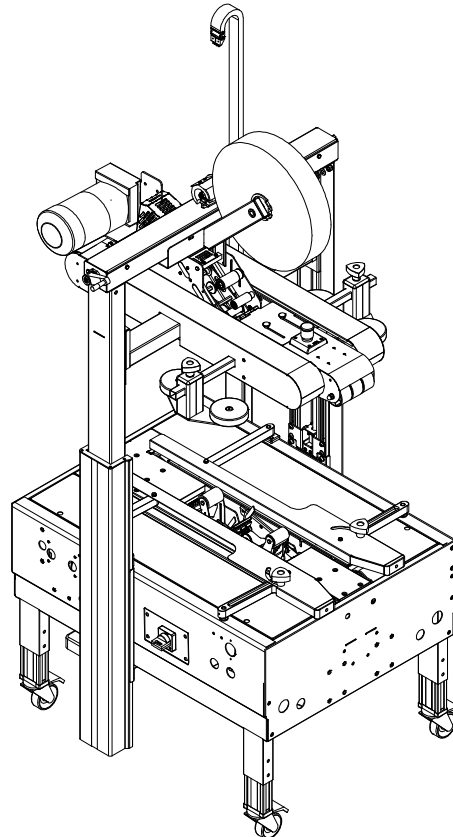
It is recommended you immediately order the spare parts listed in the “Spare Parts/Service Information” section. These parts are expected to wear through normal use, and should be kept on hand to minimize production delays.

# 1. Introduction

## 1.1 Manufacturing Specifications / Description / Directives / Intended Use

### The 3M-Matic™ 7000a-I / 7000a3-I Pro 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 **7000a-I / 7000a3-I Pro Pro** is manually adjustable to a wide range of box sizes (see “Specifications Section – Box Weight and Size Capacities”). The 3M-Matic™ case sealing machines have been designed and manufactured in compliance with the legal requirements at the date of inception.



**3M-Matic™ 7000a-I / 7000a3-I Pro  
Adjustable Case Sealer  
Type 11700**

The 3M-Matic™ case sealing machines have been designed and manufactured following the Machinery Directive: 2006/42/EC EMC Directive: 2014/30/EU RoHS Directive: 2011/65/EU in compliance with the legal requirements at the date of inception.

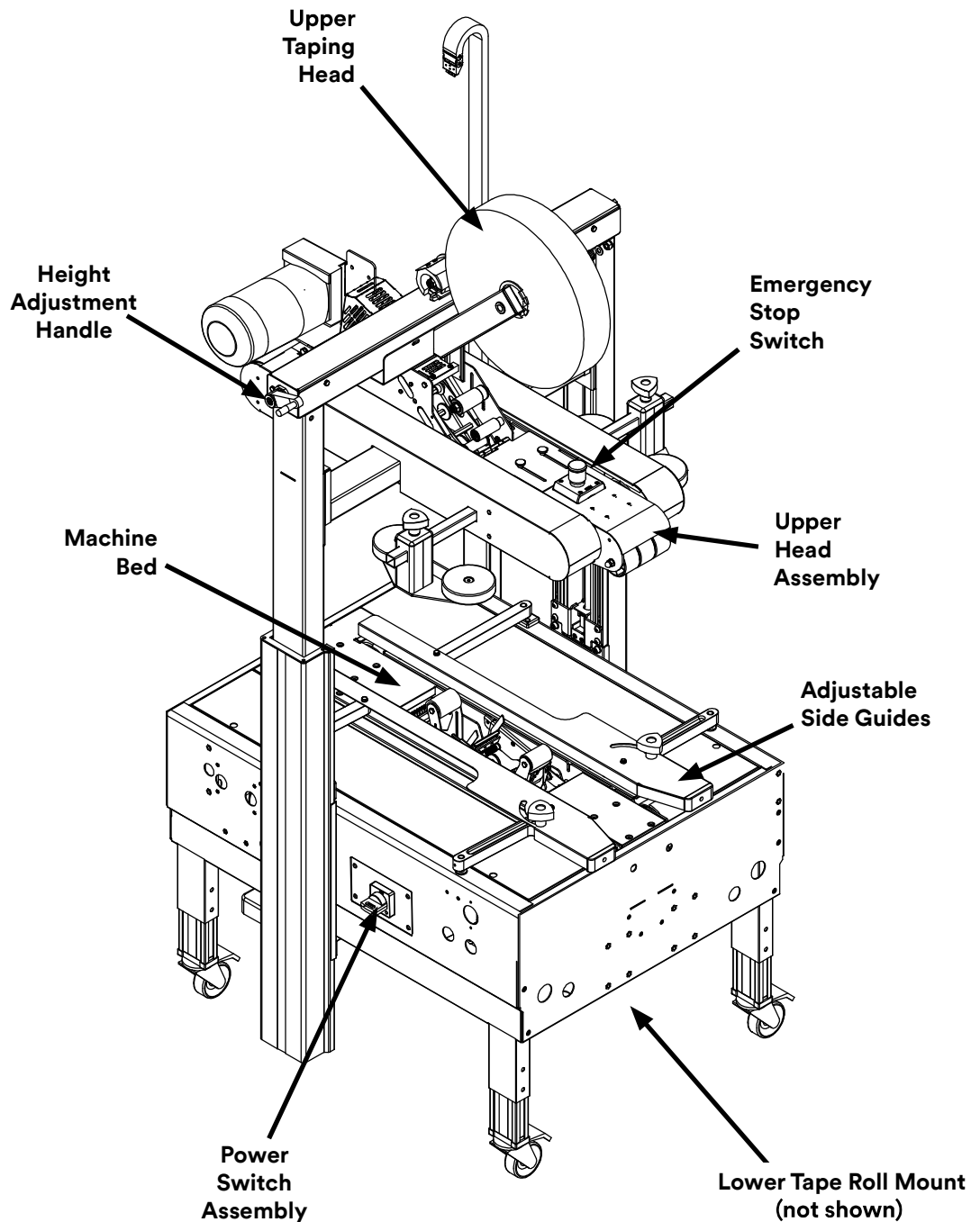
#### Reference Documents - Safety:

EN ISO 12100	Safety of machinery. General principles for design. Risk assessment and risk reduction
EN 60204 1	Safety of machinery. Electrical equipment of machines. General requirements
EN ISO 13849 1	Safety of machinery. Safety related parts of control systems. Part 1. General principles for design
EN ISO 11202	Acoustics —Noise emitted by machinery and equipment. Determination of emission sound pressure levels at a work station and at other specified positions – w/corrections
EMC:	
EN 61000 6 2	Electromagnetic compatibility (EMC). Generic standards. Immunity standard for industrial environments
EN 61000 6 4	Electromagnetic compatibility (EMC). Generic standards. Emission standard for industrial environments

## 3. Safety (continued)

### 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 or 3 for taping head components.



**Figure 3-9: 7000a-I / 7000a3-I Pro Case Sealer Components (Left Front View)**

### 3. Safety (continued)

#### 3.13 Table of Warnings and Replacements Labels

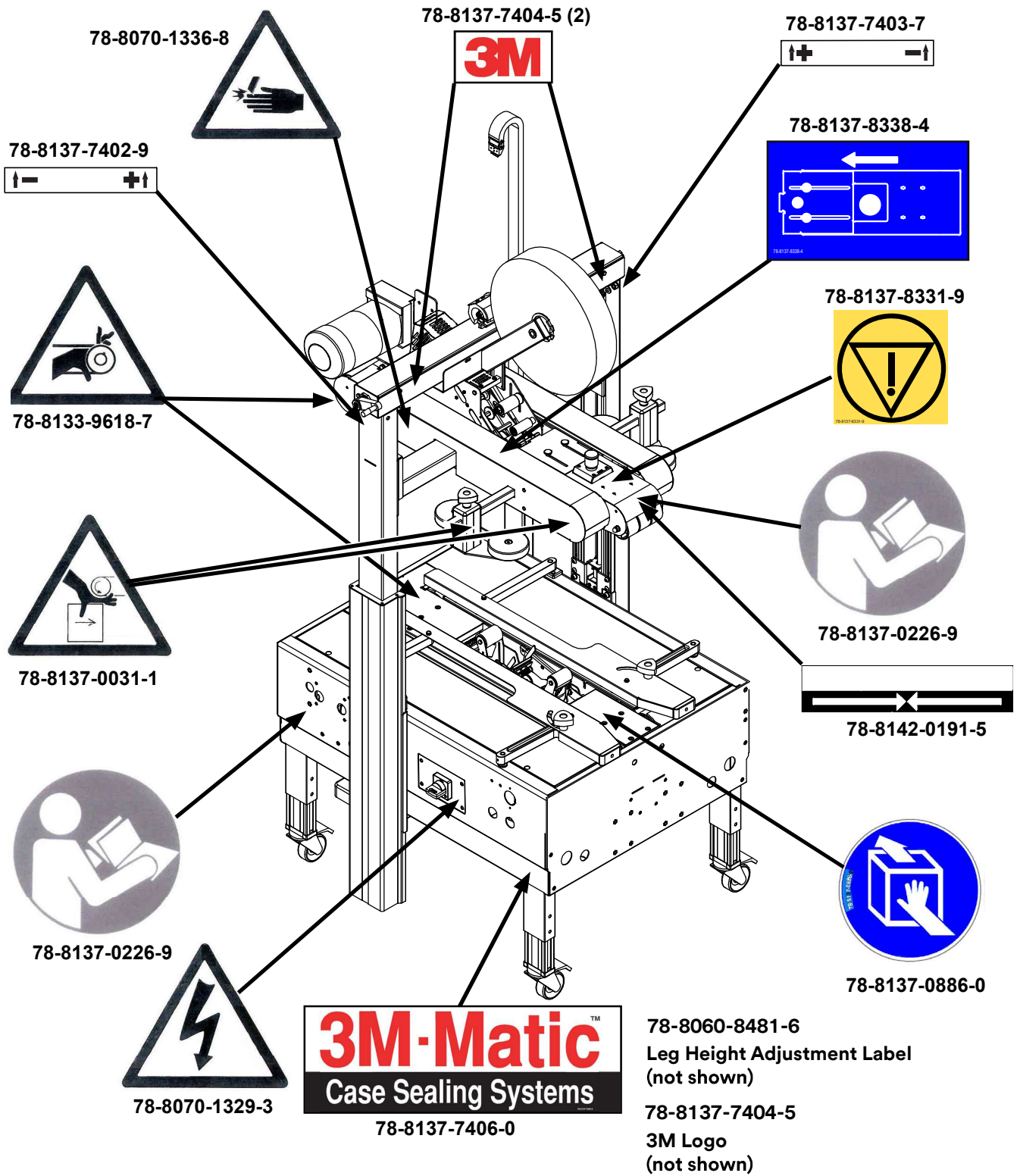


Figure 3-10: Replacement Labels / 3M Part Numbers

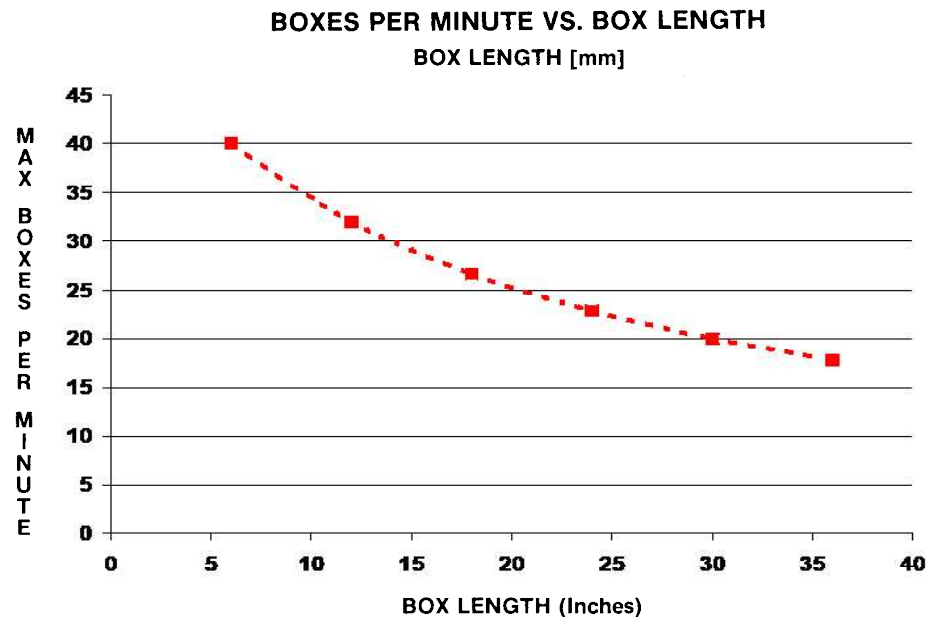
## 4. Specifications

### 4.1 Power Requirements:

Electrical – 230/400 Volt, 50 Hz., SCCR: 5kA

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

### 4.2 Operating Rate: Belt speed is 0.5m/s [100 F.P.M.]



Actual production rate is dependent on operator's dexterity.  
Boxes must be 18 inches (457mm) apart minimum.

### 4.3 Operating Conditions

Ingress protection: IP4X. Use in an indoor dry, relatively clean environment, 50% Relative Humidity, 5° C to 40° C [40° F to 104° F], maximum elevation of 1000 meters (3281 ft) with clean, dry boxes.

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

	<b>WARNING</b>
<ul style="list-style-type: none"><li>• <b>To reduce the risk associated with fire and explosion hazards:</b><ul style="list-style-type: none"><li>- Do not operate this equipment in potentially flammable or explosive environments.</li></ul></li></ul>	

## 4. Specifications *(continued)*

4.4 Machine Noise Level (measured at workplace):	Under Load	Idling
Weighted emission sound pressure level/workplace	81,2db	68.0db
Uncertainty	3db	3db
A-Weighted sound power level	92,6db	79,4db
Uncertainty	3db	3db

Hearing Protection Recommended

**Note:** Noise levels will vary and are dependent on the pressure sensitive tape used in the application. The sum of measured value of noise plus its associated uncertainty represents an upper limit of range of values. Idling refers to machine running in rest position (no boxes). Under Load refers to machine running and box taping using adhesive tape 3M-Scotch 75mm (3") Accuglide - Bottom Taping Head.

### 4.5 Set-Up Recommendations:

- Machine must be level.
- Observe Center of Gravity when lifting and moving machine.
- Avoid floor with greater than 10 degree slope.
- Customer supplied optional infeed and exit conveyors (if used) should provide straight and level box entry/exit.
- Optional exit conveyor (powered or gravity) can help move sealed boxes away from machine. Powered exit conveyor should match belt speed of case sealer.

4.6 Tape - Scotch® pressure-sensitive film box sealing tapes.

4.7 Tape Width - 50mm [2 inch] minimum to 72mm [3 inch] maximum.

### 4.8 Tape Roll Diameter

Up to 406.4mm [16 inch] maximum on a 76.2mm [3 inch] diameter core.  
(Accommodates all system roll lengths of **Scotch®** film tapes)

### 4.9 Tape Application Leg Length – Standard

70mm ± 6mm [2.75 inch ±. 25 inch ]

### Tape Application Leg Length – Optional

50mm ± 6mm [2 inch ±. 25 inch]

(See “Removing Taping Heads Procedure – Changing the Tape Leg Length”)

### 4.10 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).

### 4.11 Box Weight and Size Capacities

A. Box Weight, filled: 5 lbs.– 85 lbs. [2.3 kg–38.6 kg]. Contents must support flaps.

B. Box Dimensions for 7000a and 7000a3 Machines: Inches [mm]

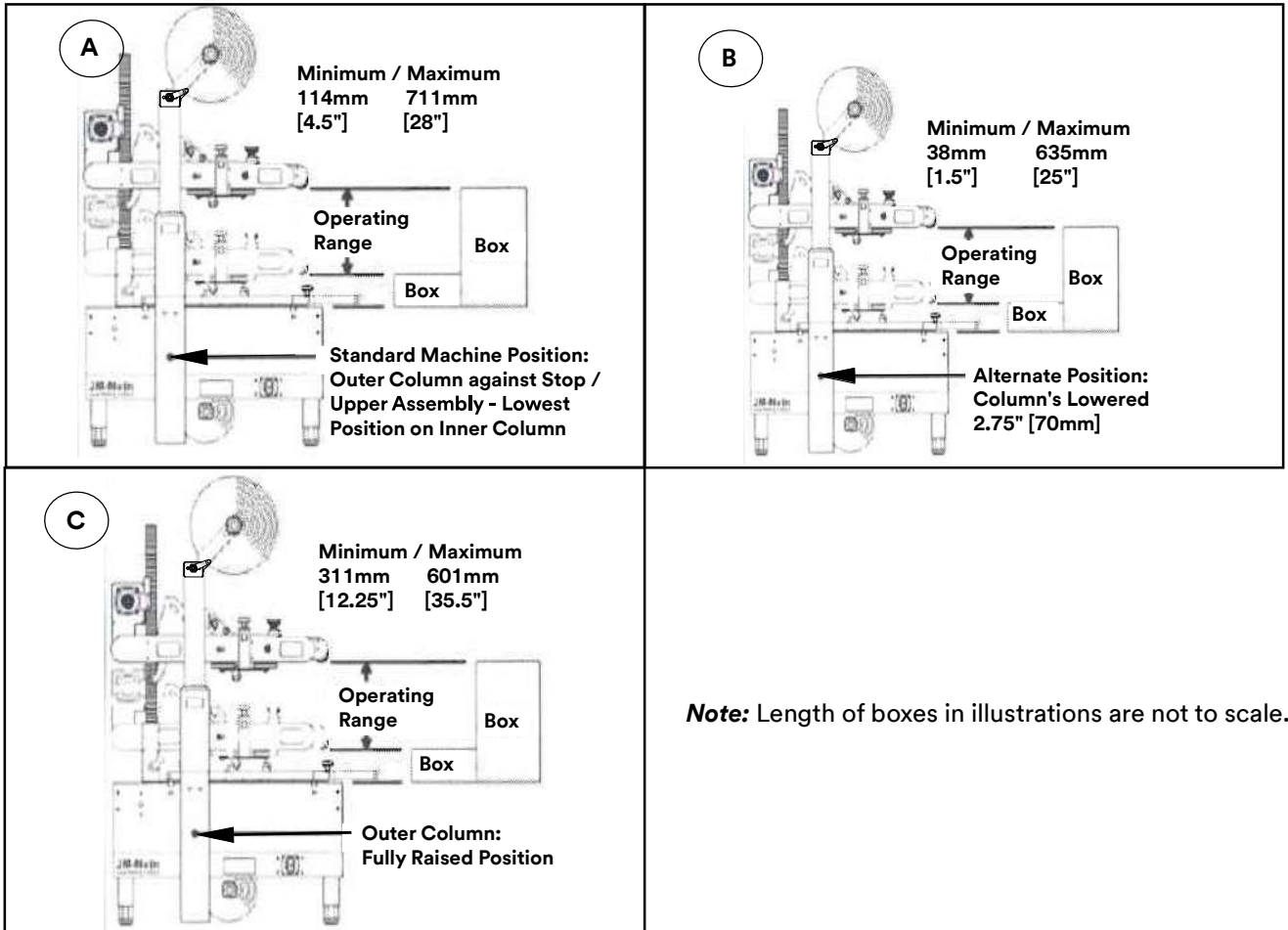
	Length	Width	Ⓐ Standard Pos. AG 3 Tape Leg (i.e. 2.75" [70])	Ⓑ Alternate Pos.	Ⓒ Fully Raised Pos. LHB Tape Leg (i.e. 1.38" [35])
Minimum	6" [152]	6.5" [165]*	4.5" [114]	1.5" [38]	12.25" [311]
Maximum	N/A	26" [660]	28" [711]	25" [635]	35.5" [601]

\* Boxes narrower than 10 inches [250mm] may require more frequent belt replacement because of limited contact area.

## 4. Specifications *(continued)*

### Minimum/Maximum Box Height Combinations

(To relocate upper frame or outer columns, see "Special Set-Up Procedure")



**Note:** Length of boxes in illustrations are not to scale.

#### Case Height Range Illustration:

- A. Standard Machine Position:** Outer Columns positioned against Stop with Upper Drive Assembly set to Lowest Position on Inner Columns. Tape Leg Length - 2.75" [70mm].
- B. Alternate Machine Position:** Lowest possible Box Height for LHB - Alternate Position (i.e. Outer columns lowered 2.75" [70mm] from Standard Position [A]). LHB Tape Leg Length - 1.38" [35mm].
- C. Raised Machine Position:** Maximum Box Height (i.e. Outer Columns and Upper Drive Assy in Highest Position - See Special Set-Up Procedure). Tape Leg Length - 2.75" [70mm].

\* Boxes narrower than 8" [200mm] may require more frequent belt replacement because of limited contact area.

\*\* Alternate Position "C" / LHB Alternate Position requires lower machine production speed.

The case sealer can accommodate most boxes within the size range listed above.

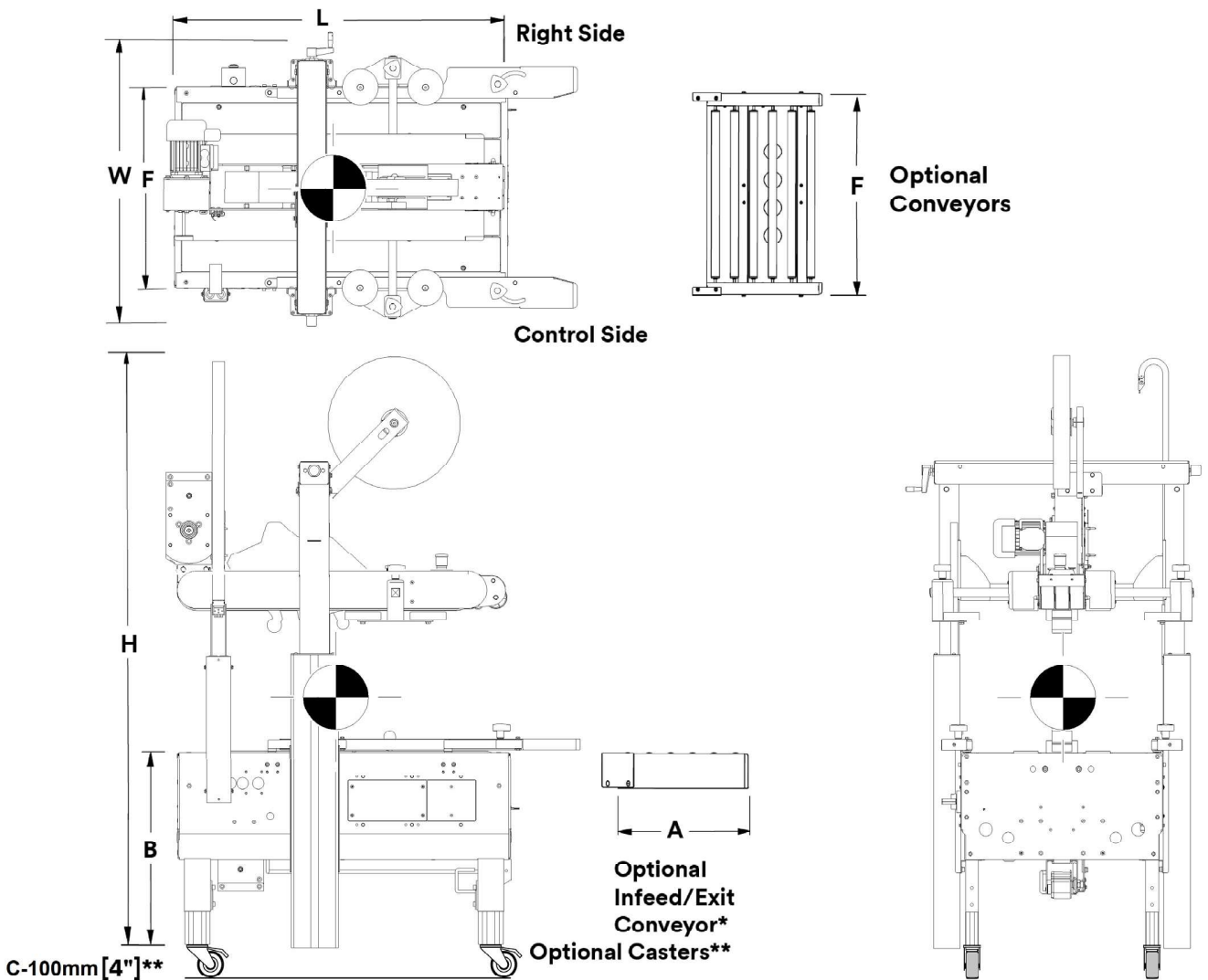
**Special modifications may be available for carton sizes not listed on previous page. Contact your 3M Representative for information.**

However, if the box length (in direction of seal) to box height ratio is .6 or less, then several boxes should be test run to assure proper machine performance. Any box ratio approaching this limitation should be test run to assure performance.

**DETERMINE THE BOX LIMITATIONS BY COMPLETING THIS FORMULA:**

**$\frac{\text{BOX LENGTH IN DIRECTION OF SEAL}}{\text{BOX HEIGHT}} = \text{SHOULD BE GREATER THAN } .6$**

## 4. Specifications (continued)



### 4.12 Machine Dimensions:

	W	L	H	A*	B***	C	F
<b>Minimum</b>							
mm	940	1030	1420	460	520	100	770
[Inches]	[37]	[40.6]	[56]	[18]	[20.5]	[4]	[30.31]
<b>Maximum</b>							
mm	--	--	2210	--	889	--	--
[Inches]	--	--	[87]	--	[35]	--	--

\* Infeed/Exit conveyors are optional

\*\* Casters are optional

\*\*\* Columns must be adjusted upward to reach minimum bed height

### Packaged Machine Dimensions:

Height (H) - 49.5" [1257]  
 Length (L) - 51" [1295]  
 Width (W) - 42" [1067]

### Weight:

Crated Weight - 190 kg [425 pounds] (approximate)  
 Uncrated Weight - 170 kg [375 pounds] (approximate)

