



Instructions and Parts List

3M-Matic™ 8000a-8000a3

Type 11600

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

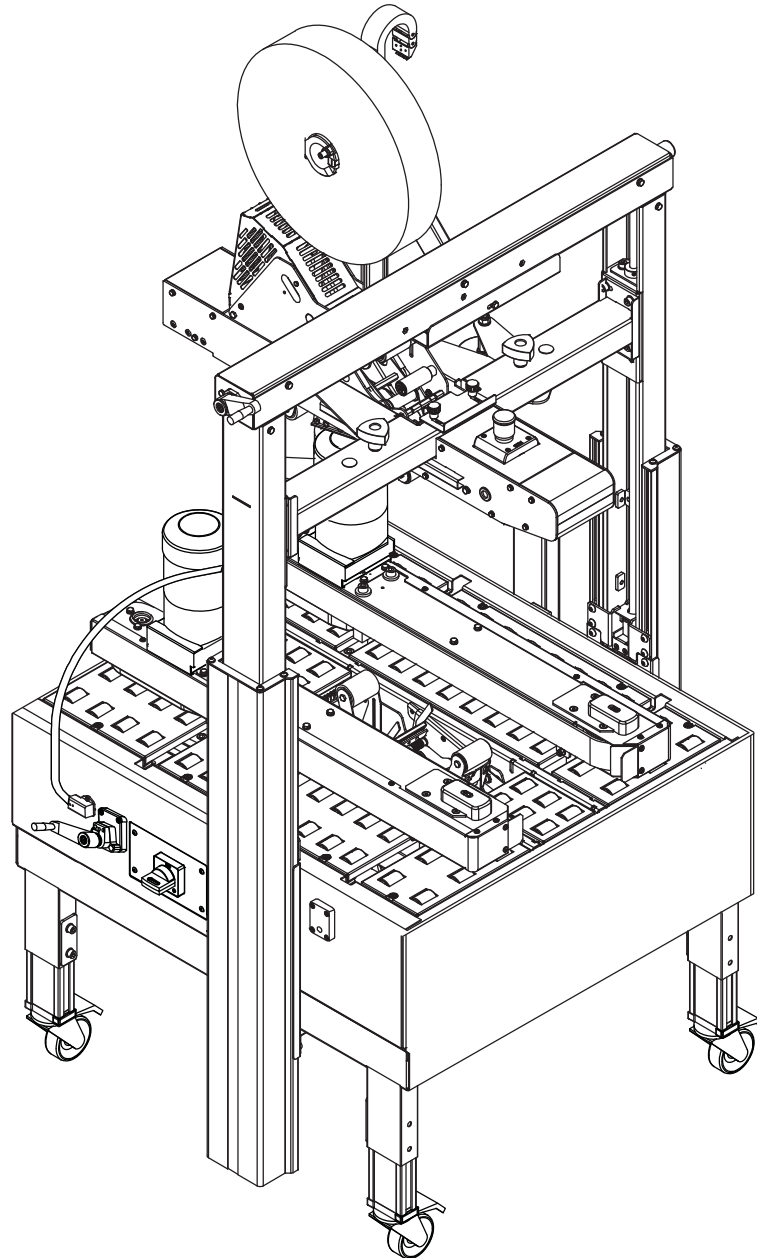
It is recommended you immediately order the spare parts listed in the “Spare Parts/Service Information” section. These parts are expected to wear through normal use, and should be kept on hand to minimize production delays.

1. Introduction

1.1 Manufacturing Specifications / Description / Intended Use

The **3M-Matic™ 8000a-8000a3 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 **8000a-8000a3** 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™ 8000a-8000a3 Adjustable Case Sealer, Type 11600

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 for taping head components.

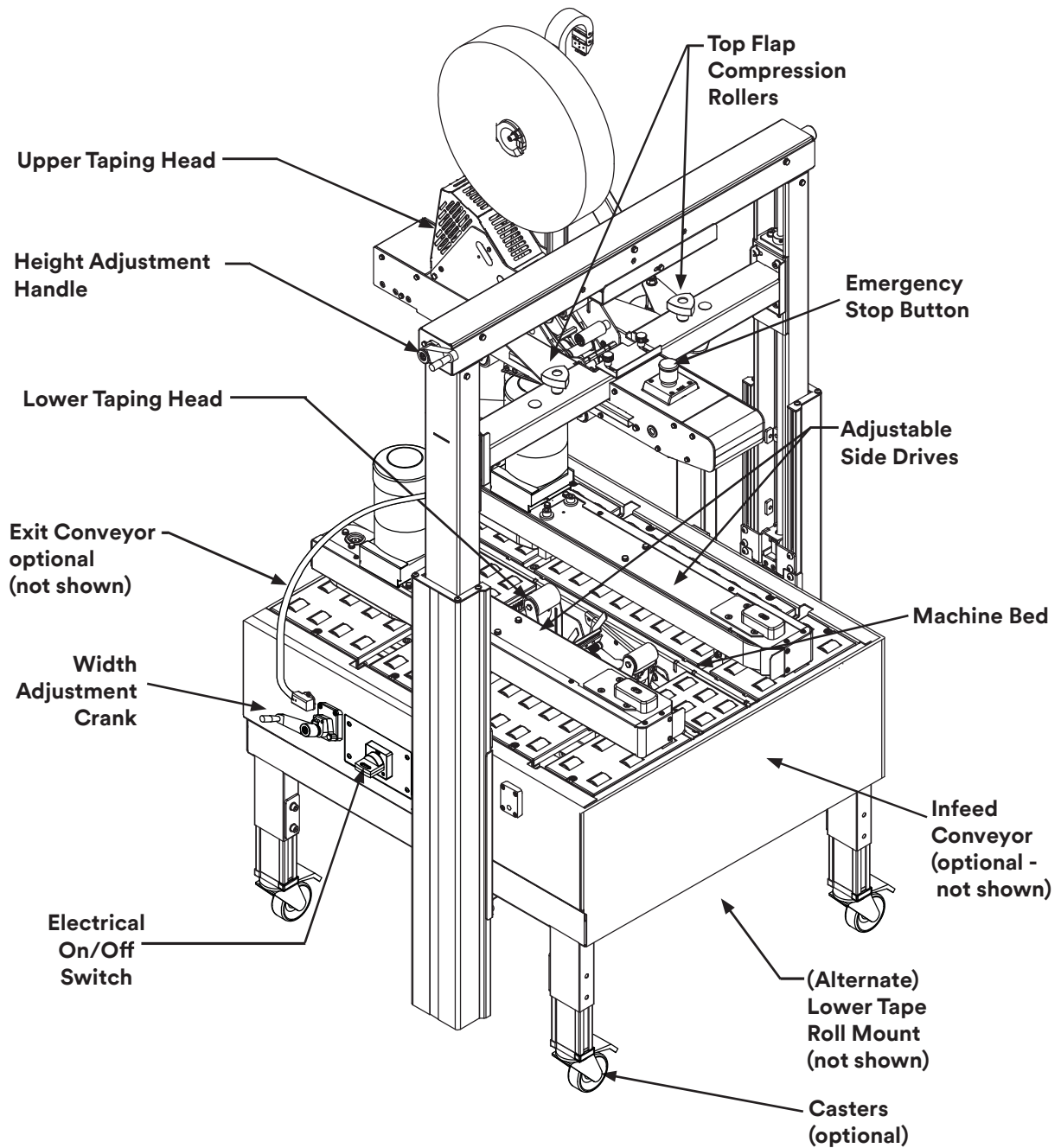


Figure 3-9 8000a-8000a3 Case Sealer Components (Left Front View)

3. Safety (continued)

3.13 Table of Warnings and Replacements Labels (continued)

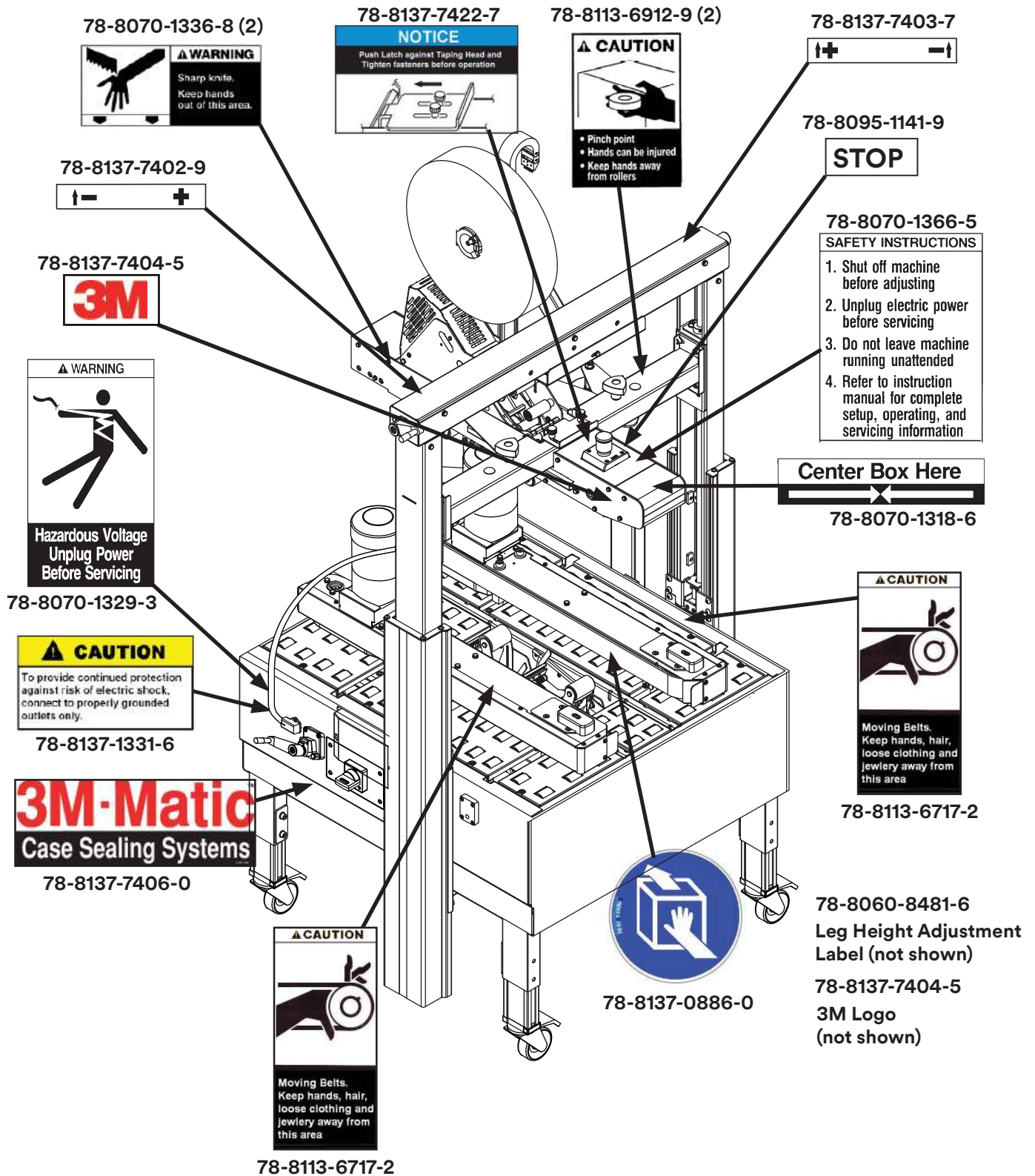


Figure 3-10 Replacement Labels / 3M Part Numbers

4. Specifications

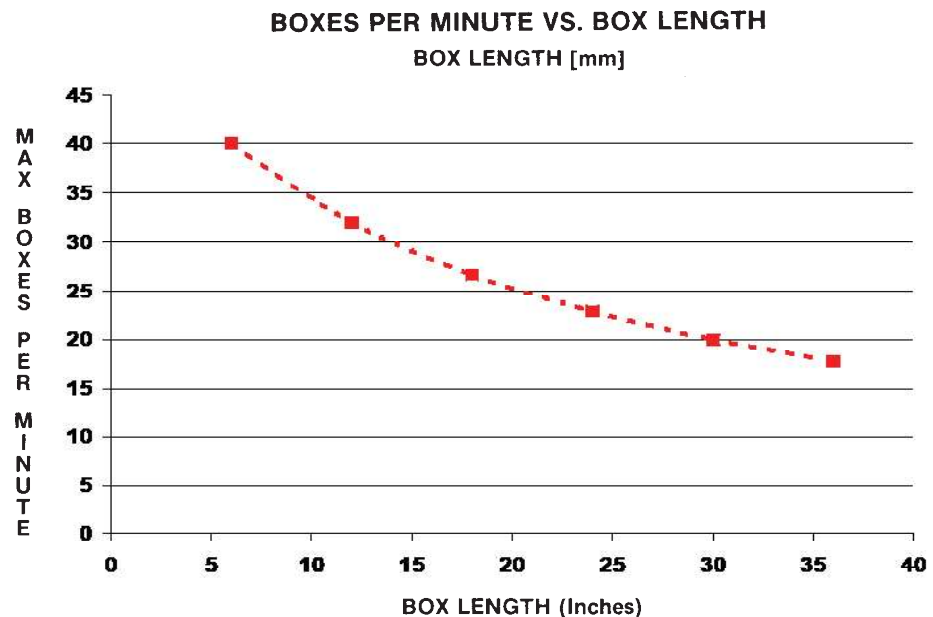
4.1 Power Requirements:

Electrical – 120 VAC, 60 Hz, 3.25A, 390 Watt

The machine is equipped with two 1/6 HP gearmotors and comes 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.

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

Use in dry, relatively clean environments at 5° C to 50° 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.

4.4 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).

4. Specifications *(continued)*

4.5 Set-Up Recommendations:

- Machine must be level.
- 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 (100 feet per minute).

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 8000a and 8000a3 Machines: Inches [mm]

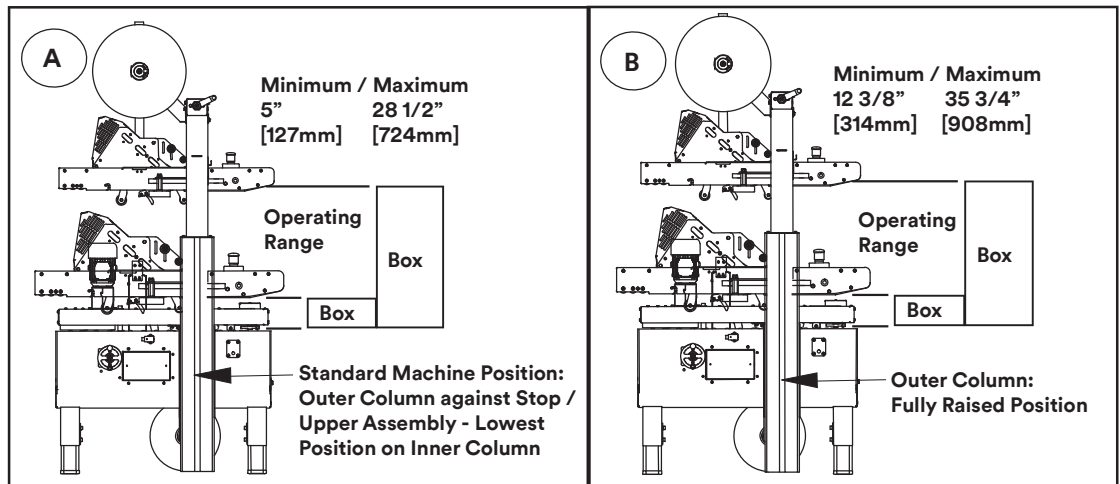
	Length	8000a Width	8000a3 Width	(A) Standard Pos. AG 3 Tape Leg (i.e. 2 3/4" [70])	(B) Fully Raised Pos.
Mínimum	6" [152]	4 1/2" [114]	5 1/2" [140]	5" [127]	12 3/8" [314]
Máximum		21 1/2" [546]	21 1/2" [546]	28 1/2" [724]	35 3/4" [908]

To accommodate smaller or larger boxes, machine upper taping head frame and/or outer column assemblies can be repositioned as described in “Special Set-Up Procedure” section of this manual. Refer to illustration/chart for box height range possibilities by adjusting machine upper frame and/or outer column positioning.

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 above 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 3/4" [70mm].
- B. Raised Machine Position:** Maximum Box Height (i.e. Outer Columns and Upper Drive Assembly in Highest Position - See Special Set-Up Procedure). Tape Leg Length - 2 3/4" [70mm]

Note: Possible Case Range alternatives depend on column position and any resulting interference with taping heads.

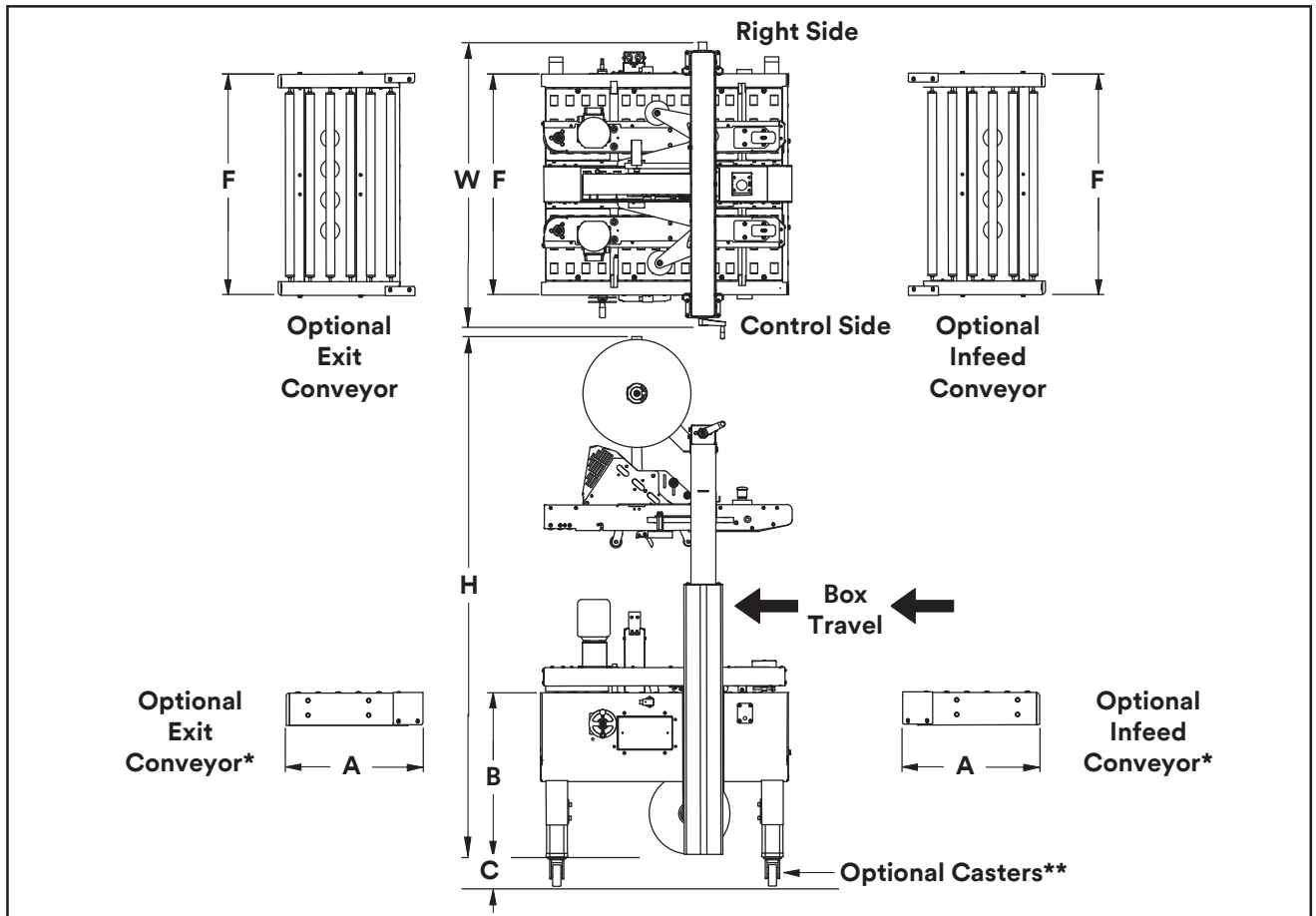
Special modifications may be available for carton sizes not listed on previous page. Contact your 3M Representative for information.

Note: The case sealer can accommodate most boxes within the size range listed above. However, if the box length (in direction of seal) to box height ratio is .6 or less, 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
Minimum							
mm	980	920	1395	460*	610	105**	620
[Inches]	[38 1/2]	[36 1/4]	[55]	[18]	[24]*	[4 3/16]	[24.5]
Maximum							
mm	--	--	2185	--	890	--	--
[Inches]	--	--	[86]*	--	[35]*	--	--

- * Infeed/Exit conveyors are optional
- ** Casters and Conveyors are optional

Packaged Machine Dimensions:

Height (H) - 49 1/2" [1257]
 Length (L) - 51" [1295]
 Width (W) - 42" [1067]

Weight:

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

