



Technical Bulletin

Bulletin #
V031110-01

Issue Date
March 11, 2010

FLEX Series Electrical Programming Change Notice

Summary

In our continuing effort to make improvements to our equipment, we have updated the HMI (Touchscreen) layout, (*assigned as Rev.4*) and PLC programming to make setup, film payout, operations and maintenance easier and more in-depth for both our distribution network and end users.

Procedure / Hardware Change

The HMI is the current XBGT panel and only software updates have been added to the existing Rev II panel. Changes include better layout on the main panel for quicker operator access to commonly used parameters, multiple language capability (*English, Spanish and French*), a new Auto-Home feature (*Carriage and Table / Tower returns to base points*), Multiple security settings (*password needed for settings changes*), Assistance Pop-Up screens and more.....New PLC programming has also yielded smoother film payout and film tension resolution.

Please see the accompanying screen shots for more information.

Instructions to Distributors

Please familiarize your team with the new updates and capabilities of the new HMI layout. The new Rev-4 programs will be posted on the support site once production begins (*est. Mid April, 2010*) for your backup needs and end user support.

The new Rev.4 HMI Program is only applicable with the accompanying Rev. 4 PLC program and can only be retrofitted on certain machines.

We urge all servicing distributors that have not retained the proper programming software to do so as soon as possible to be able to properly support the equipment. Future updates will be available as they are developed.

Please contact the factory support dept. at 1 (800) 542-4977 for details.



Orion Packaging *A division of Pro Mach
4750 County Road 13 NE-Alexandria, MN 56308
1(800) 333-6556
www.support.orionpackaging.com

Bob Scoby,
Distributor Training and Legacy Research

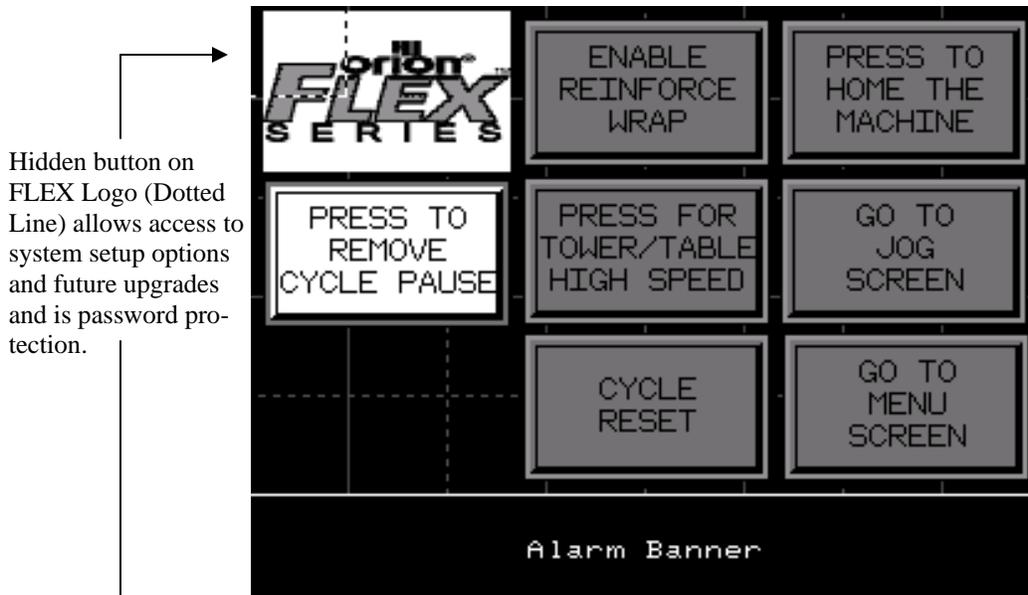


FLEX Series Electrical Programming Change Notice

New Operator **"MAIN" Screen**. Most commonly used operations needed commands are located here. *(Not all functions are described– only Rev.4 Updates.)*

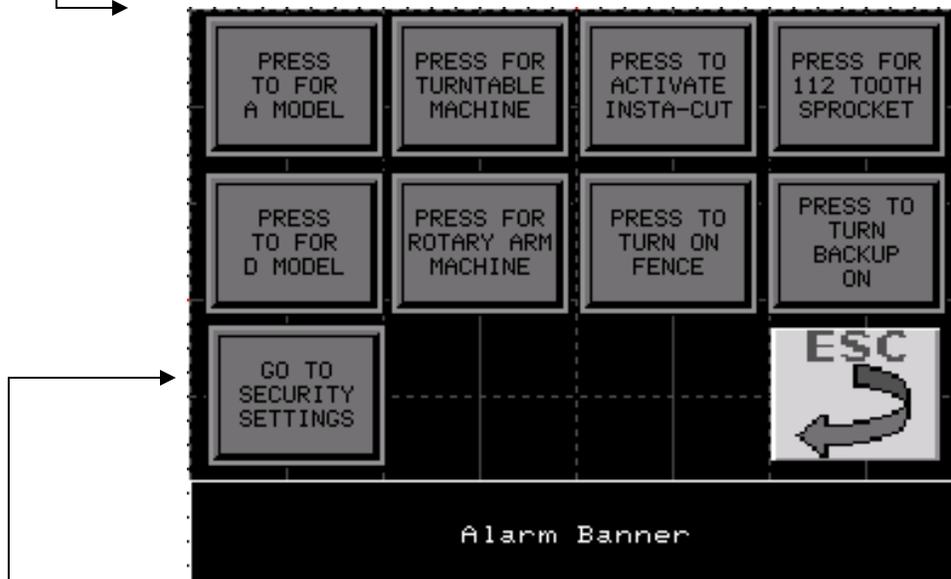
Reinforce wrap (banding) is accessed here and can now be set for a preset number of bands so the operator can simply press and walk away

Machine "Home" has been added to allow an operator to press one button to re-align the Table / Tower and bring the carriage to its base point when needed.



Hidden button on FLEX Logo (Dotted Line) allows access to system setup options and future upgrades and is password protection.

Hidden setup screen allows future upgrades such as Insta cut, additional fencing etc. as well as assigning multiple password security settings. This page is password protected.



Note the addition of selectable security settings.....described in later pages.

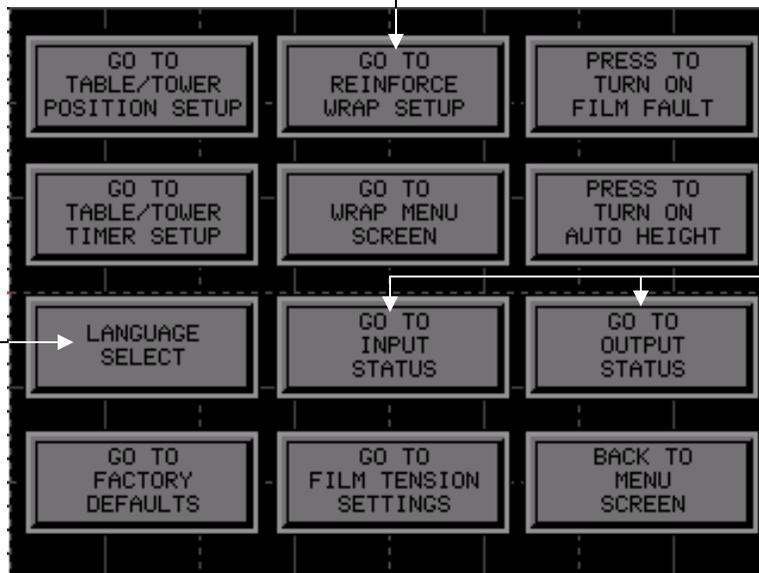
FLEX Series Electrical Programming Change Notice

Wrapper **MENU** Screen allows for general navigation.



Wrapper **MACHINE SETTINGS** Screen allows for advanced navigation.

Reinforce Wrap settings (Banding) counts can be set up here

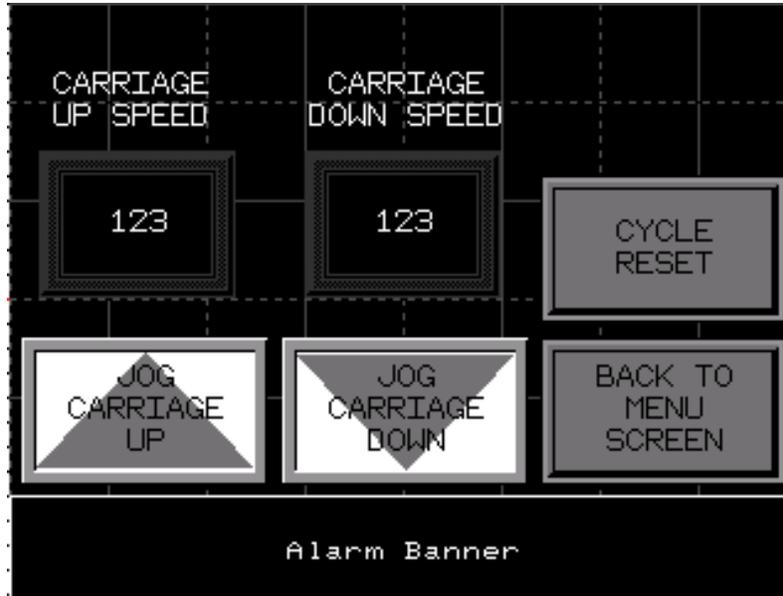


I.O. Status can be viewed here-no need to open the panel for basic troubleshooting.

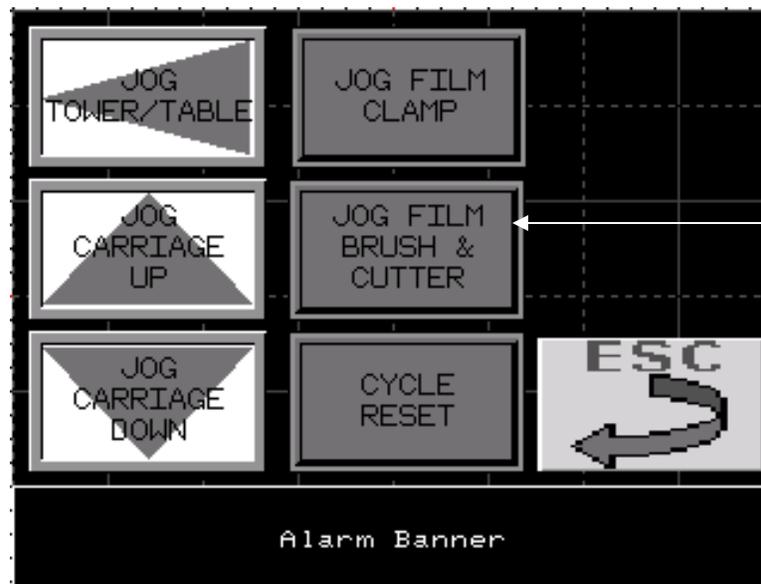
Multiple language settings can be selected here. The screen is password protected.

FLEX Series Electrical Programming Change Notice

The **CARRIAGE SETTINGS** page allows for carriage UP-DN speed settings and manual jogging



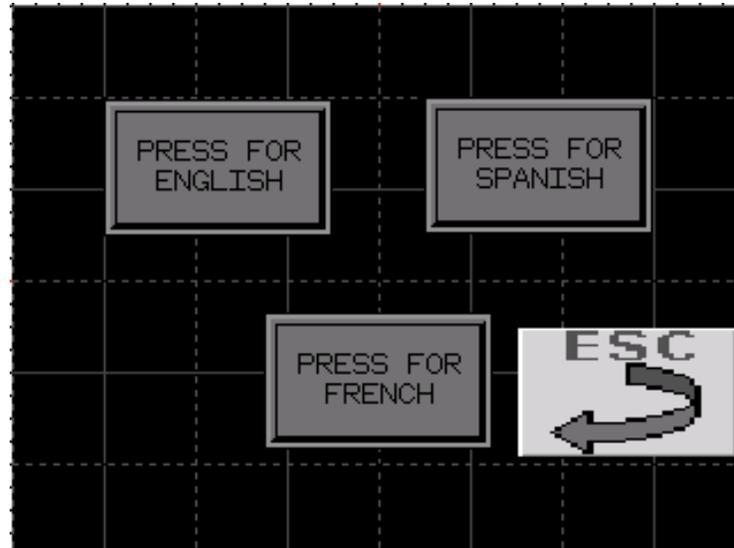
The **“JOG”** Function screen has been simplified and set up for quick access for ease of operation. All major movements can be accessed here.



Newly added film brush and cutter manual control allows setup and troubleshooting of the cutter on “A” Models

FLEX Series Electrical Programming Change Notice

The **LANGUAGE SELECT** screen has been added to allow for different languages to be assigned to the machine. This page is password protected



The **SECURITY SETTINGS** screen has been added to allow certain screens to be locked out to keep operators from changing settings without authorization. It is password protected.



Security Level #1 removes most lockouts. All major settings (wrap counts, carriage speed, tension etc are open). Timers are still adjustable.

Security Level #2 adds lockout to the timers and requires a password to change.

Security Level #3 adds lockout to all adjustable settings including: Timers, Counters, carriage speeds, film tension etc. This is useful for installations where management does not want operators to have ability to change wrap styles.

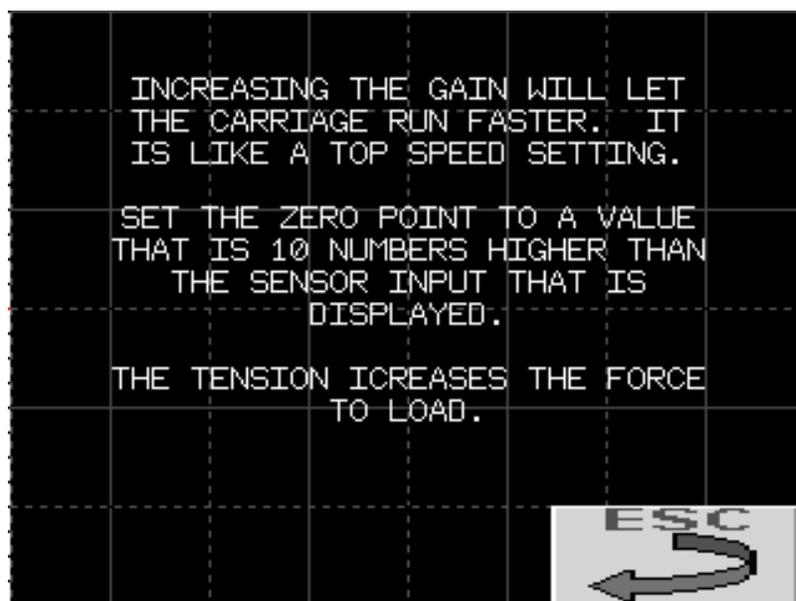
FLEX Series Electrical Programming Change Notice

The **FILM TENSION SETTINGS** screen allows the final tension (F2) to be adjusted and allows the hall effect circuits to be fine tuned. This screen is password protected



Feedback value from the hall effect device is useful for troubleshooting. It shows a real-time signal value from the hall effect so that the ZERO setting can be calibrated.

The Multistretch setup info “Pop-Up” aids technicians on how to properly calibrate the Hall Effect / Film Feed circuit.

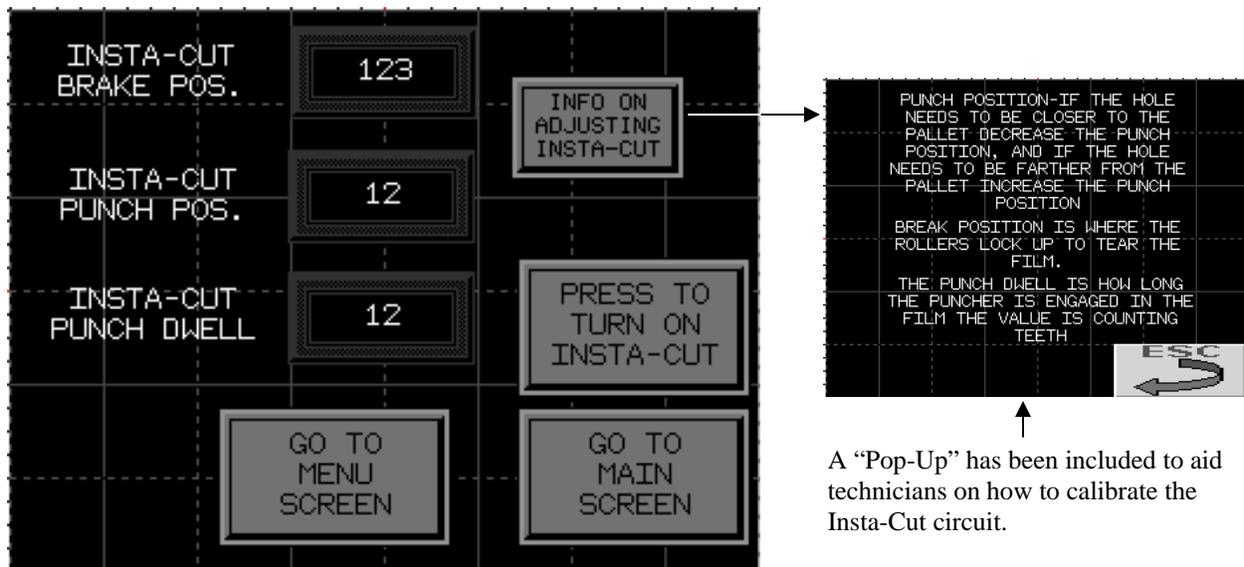


FLEX Series Electrical Programming Change Notice

The **WRAP MENU** screen is where the top and bottom wrap counts can be changed. Newly added WRAP UP ONLY has been reinstated to the machines (removed from Orion equipment since 2006).

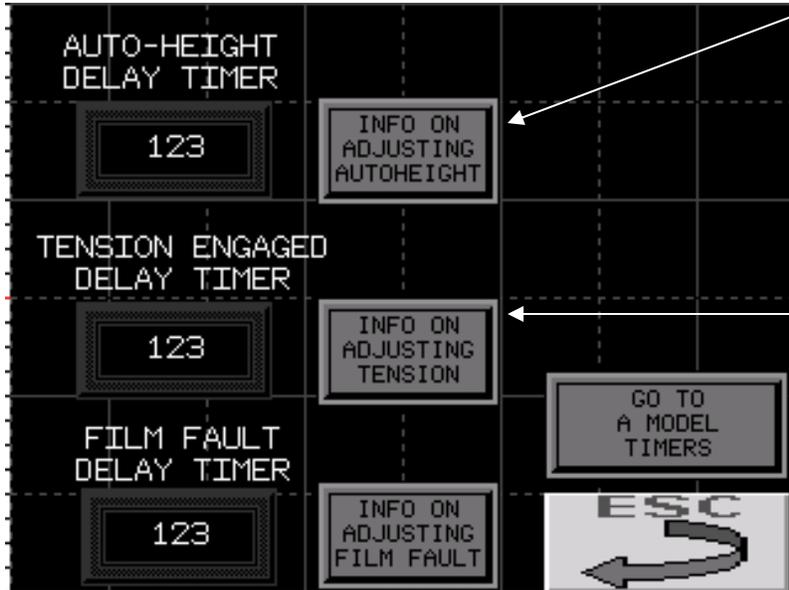


The **INSTA-CUT SETTINGS** screen allows for fine tuning of the puncher device (if equipped). Punch location, Punch Dwell and Brake position (roller lock-up) can all be adjusted to best suit the customer's product.

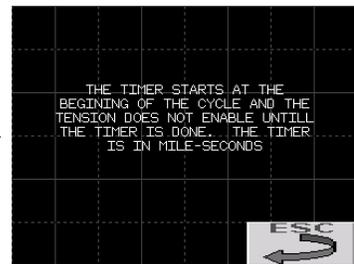


FLEX Series Electrical Programming Change Notice

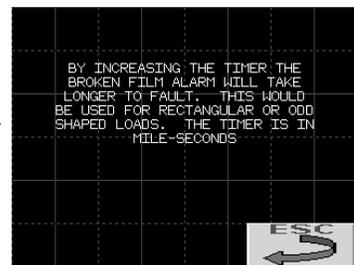
The **TIMERS** screen allows for precision tuning of timers used in the program. Newly added *Tension* engaged timer allows fine tuning of when the (F2) tension activates during a cycle.



Autoheight Pop-Up Info

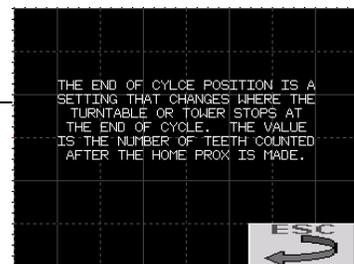
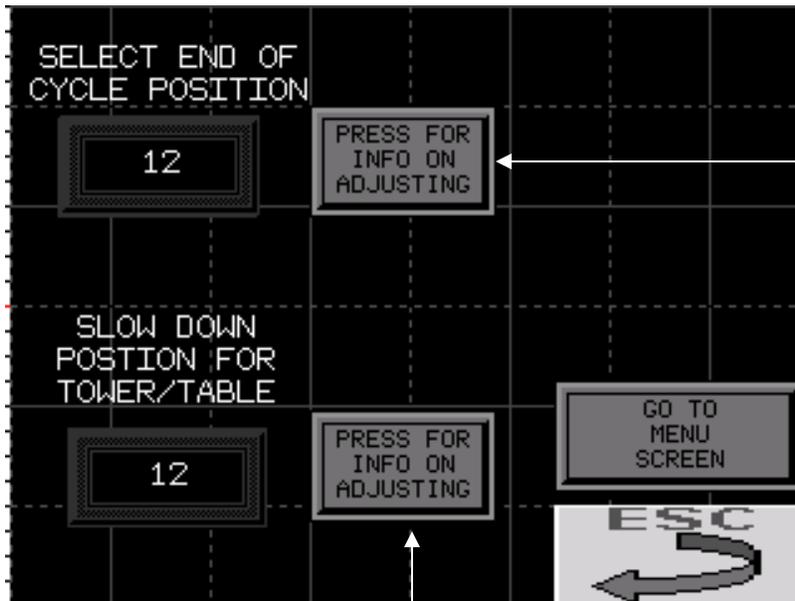


Tension Timer Pop-Up Info



Broken film detect Pop-Up

The **POSITIONS** screen allows fine tuning of how and where the table / tower slows and stops at the end of a cycle.



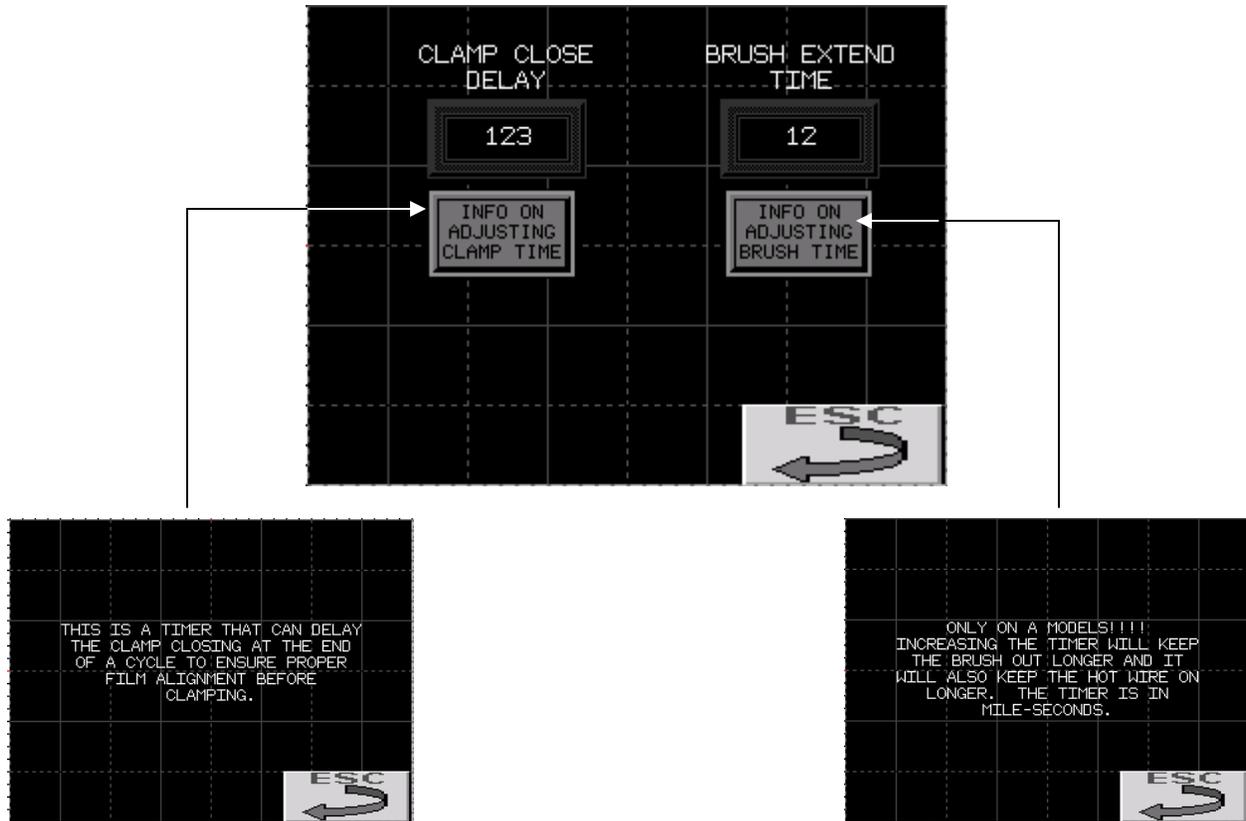
End-Of-Cycle timer Pop-Up



Deceleration Adjustment Pop-Up

FLEX Series Electrical Programming Change Notice

“A” Series **TIMERS** screen allows for fine tuning of the film tail treatment.



Film Clamp timer adjustment Pop-Up info screen

Film brush / cutter dwell timer adjustment Pop-Up info screen

The **CYCLE START DELAY** timer screen allows for fine tuning of the “START” push button dwell timer. You can choose how long the operator must press the start button (as a conscious decision) before the cycle will actually begin. This is useful for plants requiring heavy safety protocols.



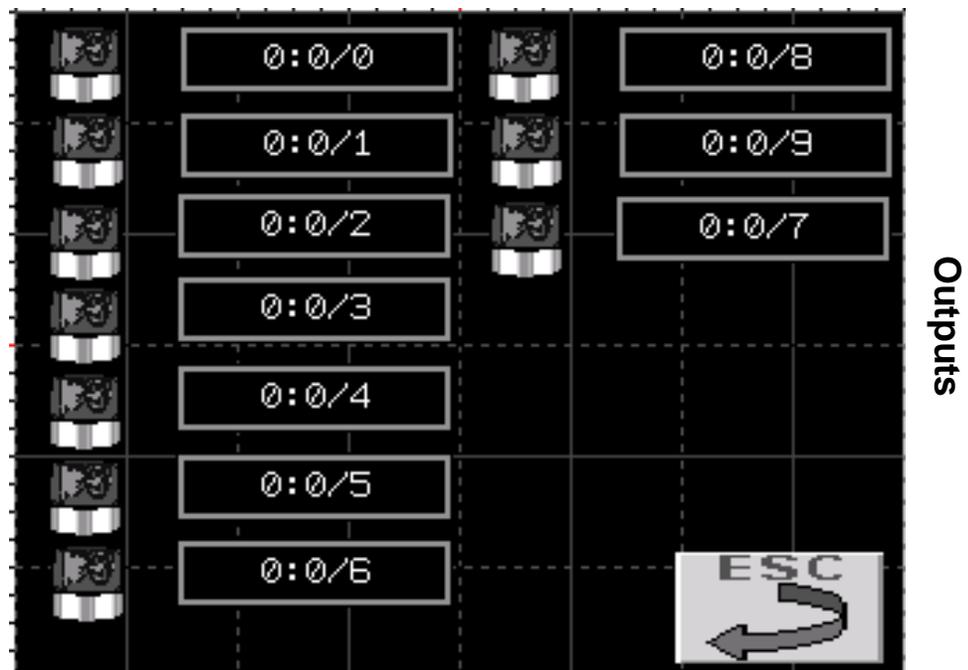
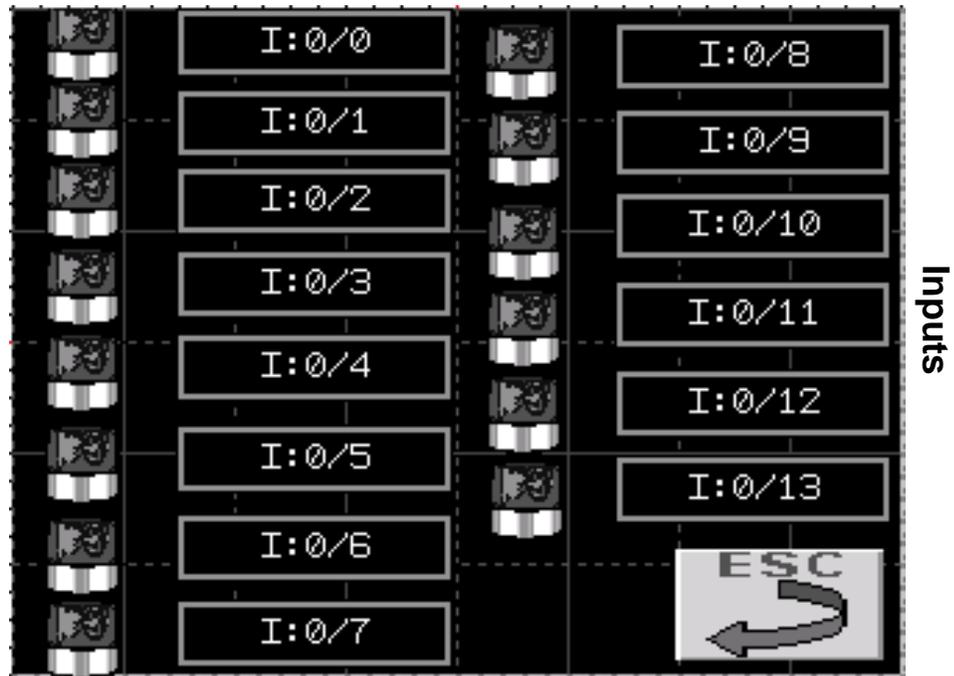
FLEX Series Electrical Programming Change Notice

A **WRAPPER STATUS** screen has been added for technicians to quickly check the applied settings on the machine for diagnostics. No need to log on with a password as before. Current values are shown on the right column, factory supplied values are on the left to compare.

| FACTORY SETTINGS | CURRENT SETTINGS | | |
|-------------------------|------------------|--|--|
| TOP WRAPS=3 | 123 | | |
| BOTTOM WRAPS=3 | 123 | | |
| END OF CYLCE POSITION=0 | 123 | | |
| SLOW DOWN POSITION=30 | 123 | | |
| AUTOHEIGHT DELAY=20 | 123 | | |
| TENSION DELAY=20 | 123 | | |
| FILM FAULT DELAY=50 | 123 | | ESC  |

FLEX Series Electrical Programming Change Notice

The **INPUT** and **OUTPUT STATUS** screens have been added for diagnostic purposes. A technician can quickly view the status of an input or an output without opening the panel.



FLEX Series Electrical Programming Change Notice

The **FACTORY DEFAULTS** page allows the original, factory program to overwrite the current program. This is useful when troubleshooting. All machine settings will be restored to the factory settings for a solid starting point. This page is password protected.



The **MESSAGES** screen allows past errors and status to be viewed for diagnostics.

