ANYTHING LESS IS A GAMBLE

MODEL CTS67-20
SERIAL # 2006-8899999

2270 Industrial boul. , Montreal (Laval), Canada, H7S 1P9
Tel.: (450) 667-9769, Fax: (450) 667-6320

ANYTHING LESS IS A GAMBLE

INSTRUCTION MANUAL

FOR ALL INQUIRIES
PLEASE CONTACT
OUR LOCAL DISTRIBUTOR

FOR NORTH AMERICA ONLY
1-800-333-6556

Thank you for choosing ORION stretch-wrapping equipment. It is a wise choice, which will benefit your company now and in the future.

ORION uses a unique combination of functional, rugged steel structure and sophisticated control systems to offer equipment high in durability and low in maintenance requirements. Our advance control systems mean that Orion equipment can be operated safely and efficiently without the need for special operator expertise.

Please read this manual carefully and keep it handy. Following these simple operating instructions will insure the safe and efficient performance of this machine while simple maintenance procedures will guarantee a long and productive life of the equipment.

Notice:

Our manual covers standard features of the machine. Certain options may not be fully covered due to their unique application.

In order to acquire more information about custom made features of your machine and to provide quicker service, the following information is required when making an inquiry:

1)Model

2)Serial Number 2006-8899999

3)Subassembly (see PART LIST)

SAFETY:

ORION'S stretch wrappers should be operated with caution and common sense as any other industrial equipment. To prevent injury and/or electrical shocks, careful operation of the machine and awareness of its many automatic functions is required.

NOTE: All electrical power and compressed air must to be disconnected prior to all inspection, maintenance or repair work.

ORION PACKAGING INC.

ORION PACKAGING SYSTEMS INC.
FULLY AUTOMATIC EQUIPMENT SPECIFICATIONS

ORION MODEL CTS67 (2003)
Medium Duty Conveyorized Rotary Turntable Automatic System

Maximum Load Size	48"W x 48"L x 75"H
Minimum Load Size	30"W x 30"L x 26"H*
Weight Capacity	200 lbs*** - 4,000 Ibs. Dynamic / 20,000 Ibs. Static**
Production Capacity	See Attached Throughput Calculation
Utilities	115 / 1 / 60 ; 20 Amps Electrical Service 3 CFM Compressed Air @ 80 PSI
Turntable	Powered Conveyor Turntable Surface with 25" Diameter Ring Bearing Support
Turntable Drive	0 - 12 RPM Variable Turntable Speed Electronically Adjustable Acceleration/Deceleration (Soft Start) DC Variable Speed Drive Heavy Duty ANSI Chain & Sprocket Turntable Drive
Control Features	Free Standing, CSA Approved, NEMA 12 Control Panel State-of the-Art Allen Bradley Programmable Logic Control for Maximum Flexibility User Friendly Controls with Non-Proprietary Pushbuttons, and Switches Electronic Film Tension Control Adjustment on the Panel End of Cycle Film Force Release Separate Top and Bottom Wrap Count Selectors Variable Speed & Separate Film Carriage Up/Down Controls Photocell for Automatic Load Height Detection **** Rewrap Pushbutton for Rewrapping Load After Film Roll Replacement, E-Stop, Etc Turntable Jog Pushbutton Conveyor Jog Pushbuttons Current Overload Protection
Film Delivery	20" Orion Insta-Thread™ Powered Prestretch Film Delivery System Precision Ground, Polyeurethane Pre-Stretch Rollers for Consistent, Maximum Film Yield 260% Standard Pre-Stretch Ratio (Adjustable from 100% to 300%) Easy & Safe to Operate Self-Threading Carriage Design Electronic Film Tension Control Adjustment on the Panel Full Authority Film Dancer Bar with Variable Speed Output (Non-Wearing Sensor) Heavy Duty ANSI Chain & Sprocket Ratio Control Insta-Sense™ Film Out/Broken Sensing Logic with Indicator Light
Film Carriage Drive	Heavy Duty ANSI Chain Carriage Lift DC Variable Speed Drive Multi-Point UHMW Precision Carriage Guidance System

ORION PACKAGING SYSTEMS INC.
FULLY AUTOMATIC EQUIPMENT SPECIFICATIONS

ORION MODEL CTS67 CONTINUED

Structural Features	Ergonomic Chassis Layout for Ease of Operator Use Side Facing Carriage for Easy Film Roll Change Personnel Decking Between Chassis Tubes in Film Clamp Area 100% Structural Steel Construction Throughout Non-Proprietary, Locally Obtainable Components Throughout Easy Access to All Components Open Mechanical Design for Ease of Maintenance Forklift Portable Base Design Forklift Easy Access For Loading /Unloading Machine Design Floor Mounted Forklift Wheels Stoppers For Unloading
Conveyor Features	5' Powered lnfeed Conveyor Included 100% Orion Manufactured 100% Structural Steel Construction 4,000 lb. Max Load Weight Capacity 18" Height to Top of Rollers 52" Effective Conveyor Width 2.5" Diameter Rollers on 3.75" Centers All Full Length Rollers Driven Via Heavy Duty ANSI Chain Loop to Loop Full Length Solid Steel Conveyor Roller Axles Individual Bearings with Cast Housings for Each Roller Fully Automatic Sequencing Logic 30 fpm Standard Conveyor Speed DC Variable Speed Drive
Film Tail Treatment	Pneumatic Film Clamp Impulse Wire Film Cutting Pneumatic Load Seeking Brush Down System
Estimated Shipping Weight	4,500 lbs.

* Minimum load height capability is based on 20" film carriage. For 30" carriage, minimum load height capability is 36"

** In applications in which the pallet bottom boards are parallel to conveyor rollers, the minimum bottom board width is 4", and the minimum number of bottom boards is 3.

*** For lighter loads than 200 lbs. consult factory.

**** For black, shiny or transparent loads special type of detector is required.

MACHINE UNLOADING
INSPECTION & INSTALLATION

UNLOADING

Machine can be easily unloaded and transported by a forklift with a minimum capacity of 2500 lbs.

1. Carefully insert the forks into the lifting tubes to the maximum possible depth. Depending on the model, a forklift access may be either at the turntable end of the machine frame, the tower end or both. In case of the mongoose machine enter the forks under the frame or insert the forks in the tube brackets welded to the top of the machine.

2. Lift the machine (or other part of system) only to the necessary height to move it with no bouncing or friction on the floor.

3. Sit the machine down assuring uniform contact with the floor, which is necessary to ensure correct and smooth operation.

INSPECTION

1. Remove all packing and supporting additions - these may include the blocks under the carriage and the restraining bar over the table.

NOTE: when removing the stretchwrap film covering the machine, care must be taken not to cut any of the electrical wires and/ or polyurethane covering on the film carriage rollers.

2. Perform a visual inspection of the electrical and mechanical parts for loosened joints and / or broken connections. Any suspected shipping damage must be reported immediately to the freight carrier. Any transport damage cannot be claimed to Orion Packaging Inc.

Items that are vulnerable to damage and must be inspected are as follows:

- Motors and transmissions
- Junction boxes
- Electrical conduits
- Proximity and limit switches
- Photocells

3. Check under the turntable to ensure that there is no crippling of the movable parts i.e. casters, center axle or drive assembly.

4.Verify the following:

- Turntable or rotary arm drive system to confirm that the reducer to drive the chain is snug and properly aligned.

- Verify the wires tight conduits for crushed sections or loose fittings.

- Verify the film carriage to be sure that it is correctly aligned with the tower
- Verify the tension on the lift chain.
- Verify all the dials and knobs on the control panel for smooth action.

MACHINE INSTALLATION

After the visual inspection has been completed, the electrical power and the compressed air shall be connected as specified on the diagrams supplied with the machine. An electrical diagram is provided with each machine in the envelope attached to the panel box.

ASSEMBLY PROCEDURE

The structural frames of the machine have to be installed on a leveled floor. Locate the main wrapper section into its final position, keeping the tower assembly* away from any traffic. The wrapper mainframe section **must be bolted to the floor by the 1/2" concrete floor anchors** (leg & shield or expandable type).

Any wiring that has been disconnected to facilitate transport is marked with a number located on the junction box to which the wiring must be reconnected. Any wire run that appears too short or long may indicate that the position of the mechanical components is incorrect. Verify the status of all assemblies before proceeding.

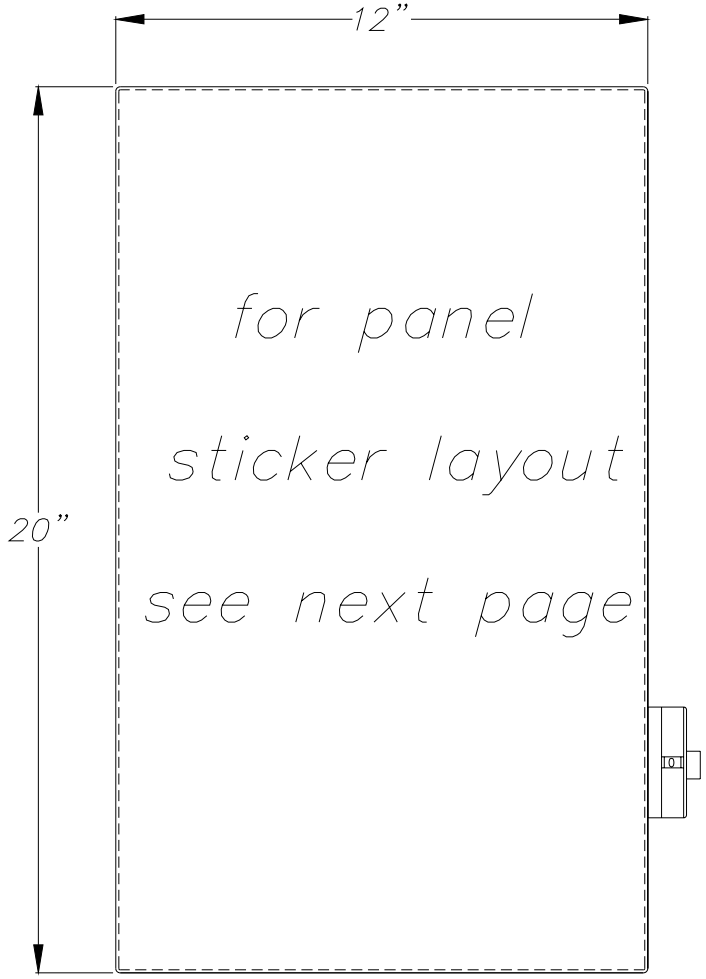
* The tower deviation from vertical must not exceed 1/4" on the distance of 10 feet (angle: 0 degrees 6').

CONTROL PANEL

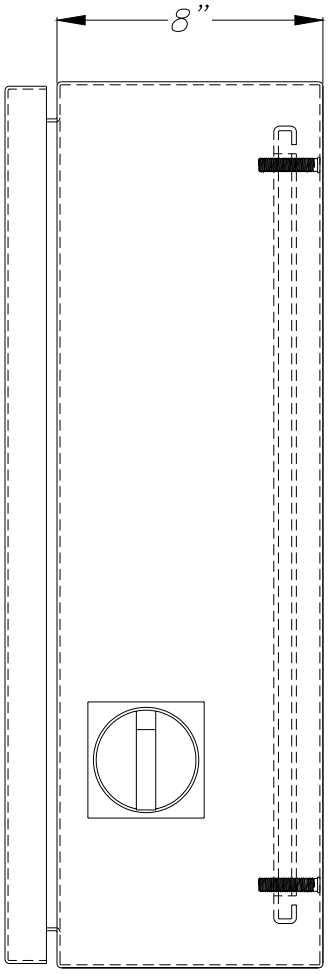
In the case of the free standing panel (console) place it adjacent to the system and anchor firmly to the floor. Connect the liquid tight (rigid conduit) to the main junction box located on the wrapper main frame next to the tower.

Before Starting Machine Operation

Verify that the machine is properly connected to the electrical source. The electrical requirements depend on the machine type and features. For this information, please see the machine electrical diagram provided with the machine operation manual. The control panel layout for the machine is shown on the drawing.
CAUTION: Before preceding the machine operation familiarize yourself with the **EMERGENCY-STOP** button and all functions, switches and pushbuttons.



FRONT PLATE



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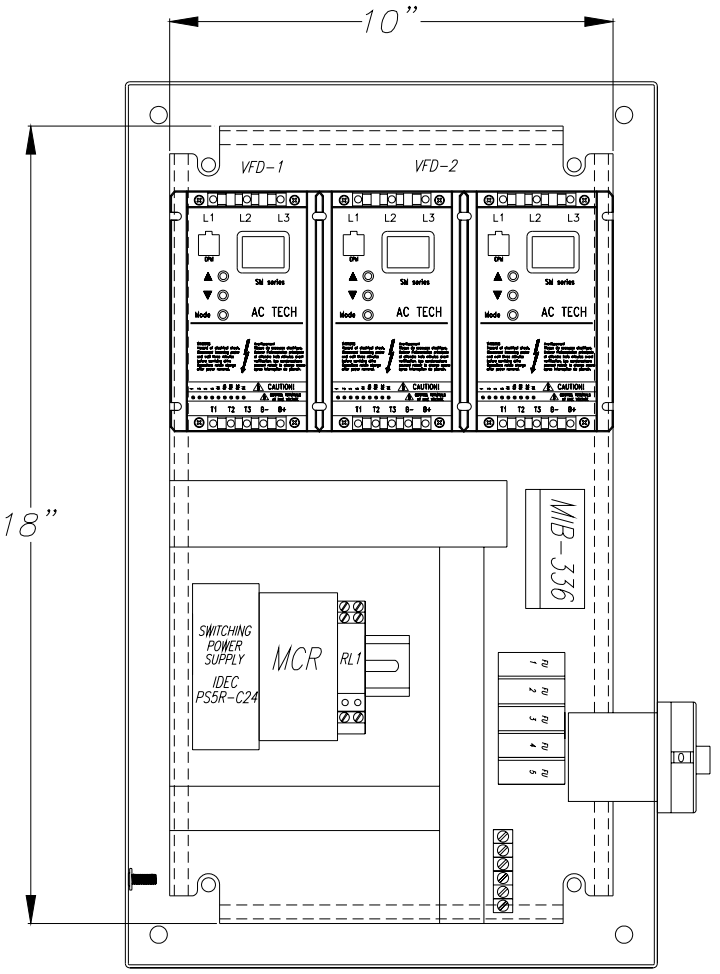

BACK PLATE

orion
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ORION PACKAGING INC.

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TEL: (450) 667-9769 FAX: (450) 667-6320
APPR. BY: J.B.S. DRAWN BY: J. ALEXANDER

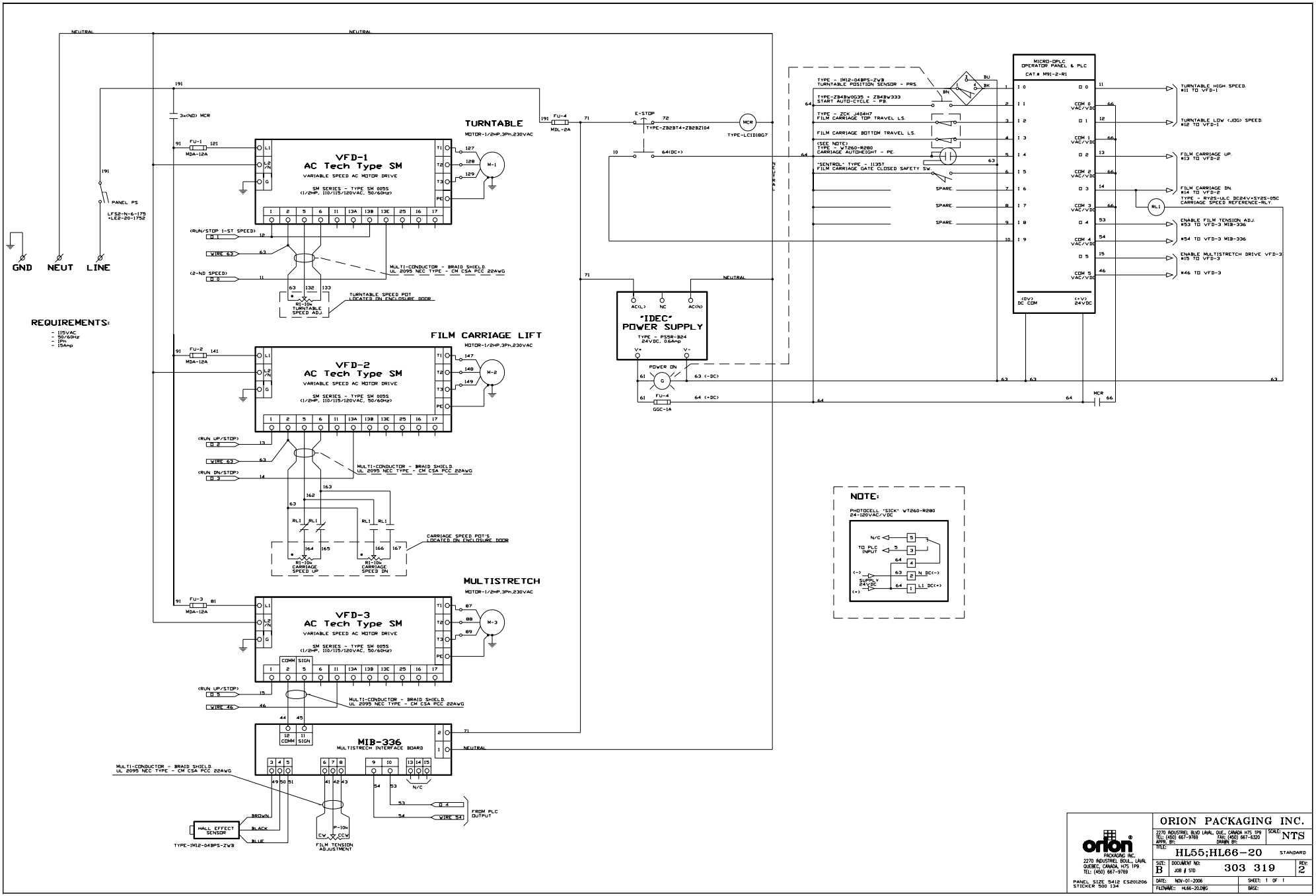
SCALE: 1:2

TITLE: HL66-20 "STANDARD"

SIZE: B | DOCUMENT NO: JOB # STD 303 319/L | REV: 2

DATE: NOV-01-2006 | SHEET: 1 OF 1

FILENAME:: H66-20L.DWG | BASE:



Note: For VFD adjustment, please contact Orion Packaging service department.


orion
A Division of Pro Mach
unitronics
M-90
PLC
START
STOP
FILM TENSION
CARRIAGE SPEED
UP
DN
TABLE / TOWER
SPEED
1 AUTOHEIGHT PE
OFF/ON
2 TOP WRAPS
T (1-9)
3 BOTTOM WRAPS
B (1-9)
4 WRAPPING MODE
a - SPIRAL UP & DOWN
b - SPIRAL UP ONLY
5 WRAPPING MODE
c - TOP WRAPS FIRST
d - BOTTOM WRAPS FIRST
6 TURNTABLE JOG
7
8 REINFORCED WRAPS
R (1-9)
9
PAUSE / RESET
CARRIAGE JOG UP
CARRIAGE JOG DN
WARNING!
DISCONNECT POWER TO THE MACHINE BEFORE OPENING THE PANEL.
DANGEROUS OR FATAL ELECTRIC SHOCKS MAY RESULT IF POWER TO
THE MACHINE IS NOT DISCONNECTED BEFORE OPENING THE PANEL.
PN 500 134
Orion Packaging Systems, Inc :: Collierville, Tn, USA / Laval, Qc, Canada :: www.orionpackaging.com

MACHINE OPERATION

POWER SWITCH

Located on the panel door or side of the panel box, the lockable power switch has two settings:

ON - connects a power source to the machine
OFF - disconnects the power source.

START AND EMERGENCY STOP SWITCHES

The START switch is used to start the cycle once the load is on the turntable. The cycle may be stopped at anytime by pressing the STOP button. (see ***Figure 1***)

Figure 1

NOTICE: The STOP button interrupts the entire machine electrical circuits. To continue the cycle the STOP push/pull button should be pulled out and START button pressed for the machine to restart. Double pressing the push – pull STOP button will reset the machine program and machine will be ready to apply the wrapping cycle from the beginning.

SETTING-UP MACHINE PARAMETERS

Note: Parameter change is available when machine is not in cycle.

1- AUTOHEIGHT PHOTOCELL

Press button #1 on the keypad to switch from ON to OFF, or vice-versa.(see ***Figure 2***)

ON - When ON, the photocell is activated to automatically detect top of the load. The carriage will automatically stop at the top of the load regardless of its height.

OFF - When OFF, the photocell is inoperative and carriage will travel to the top limit switch regardless of its height.

NOTE: For proper machine operation, top limit switch position should be adjusted to desired level prior to starting the cycle.

Figure 2

2- TOP WRAPS 1,2,3...9

Press button #2 on the keypad to select “Top Wrap”, then using the arrows on the keyboard select between 1 to 9 for required number of wraps on top of the load.

3- BOTTOM WRAPS 1,2,3...9

Press button #3 on the keypad to select “Bottom Wrap”, then using the arrows on the keyboard select between 1 to 9 for required number of wraps at the bottom of the load.

Note: Refer to the list of options at the bottom of the panel sticker for reference. (see ***Figure 3***)

Figure 3

4- WRAPPING MODE "SPIRAL" UP OR UP-DOWN

Press button #4 on the keypad to switch from **UP** to **UP & DOWN**, or vice-versa.

UP - When the UP position has been selected machine will first wrap bottom of load applying selected number of bottom wraps. The film carriage will then move to the top of load and stop. Selected number of top wraps will then be applied, after which the turntable will slow down and stop in home position. Wrap pattern "SPIRAL UP ONLY" has been completed.

UP-DOWN - This Selection has two Sub-Modes, programmable to enable the machine to perform the two different wrap patterns (Bottom Wraps First and Top Wraps First). ***(Figure 4)***

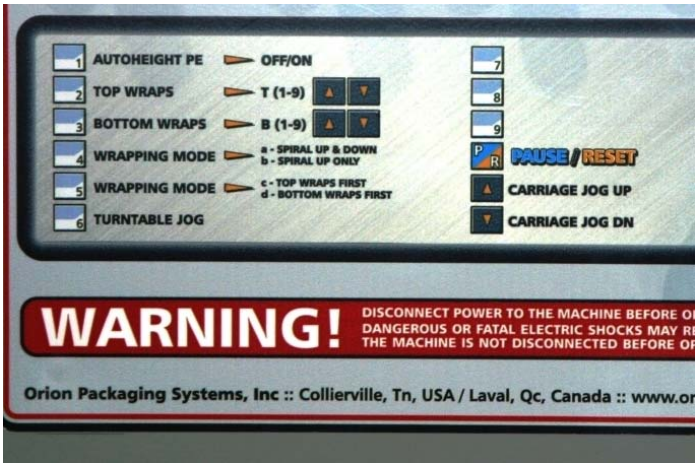


Figure 4

5- WRAPPING MODE; BOTTOM WRAPS FIRST OR TOP WRAPS FIRST
(ENABLE ONLY IF THE WRAPPING MODE SPIRAL UP-DOWN HAVE BEEN SELECTED PREVIOUSLY)

Press button #5 on the keypad to switch from **BOTTOM WRAPS FIRST** to **TOP WRAPS FIRST**, or vice-versa.

BOTTOM WRAPS FIRST - When this Sub-Mode has been selected machine will first wrap bottom of load applying selected number of bottom wraps. The film carriage will then move to top of load and stop. Selected number of top wraps will then be applied. The film carriage will move down to bottom position, after which the turntable will slow down and stop in home position.

TOP WRAPS FIRST - When this Sub-Mode has been selected film carriage will move to top of load and stop. Selected number of top wraps will be applied. The film carriage will then move to bottom of the load and stop. Selected number of bottom wraps will then be applied. The film carriage will remain in bottom position; turntable will slow down and stop in home position.

6- TURNTABLE JOG

The turntable jog can operate only when machine is not in cycle. The turntable jog will rotate at a low speed when the button #6 is held down, when released, the turntable will stop.

FILM TENSION

Film tension may be adjusted using the film tension control knob (see ***Figure 5***). The range of tension is from 0 to 10 (0 to 4 the low range, 4 to 8 the most selected range for most of the films used by our customers, 8 to 10 as a very high range which may break some types of films).

Figure 5

CARRIAGE SPEED (Film Overlap)

The carriage speed knob can be used to control the amount of film overlap apply during the wrap. The potentiometer has settings from 0 to 10, the higher the settings the faster the speed. High settings apply less film overlap due to faster carriage speed. Low settings apply more film overlap due to lower carriage speed.

This machine is equipped with independent speed adjustement for travel up & down. (see ***Figure 5***)

TABLE / TOWER SPEED

The table speed knob can be used to control the speed of the table during the operation mode.

MACHINE WRAPPING TEST

Notice: It is advisable to test-run the equipment with several pallet loads before attempting to wrap using film. Please position the operator beside the EMERGENCY STOP push button. Start up of the machine (system) may determine the need for the adjustment of:

- Load height stop photoswitch (on the carriage)
- Top limit switch position
- Bottom limit switch position
- Roping bar height adjustment

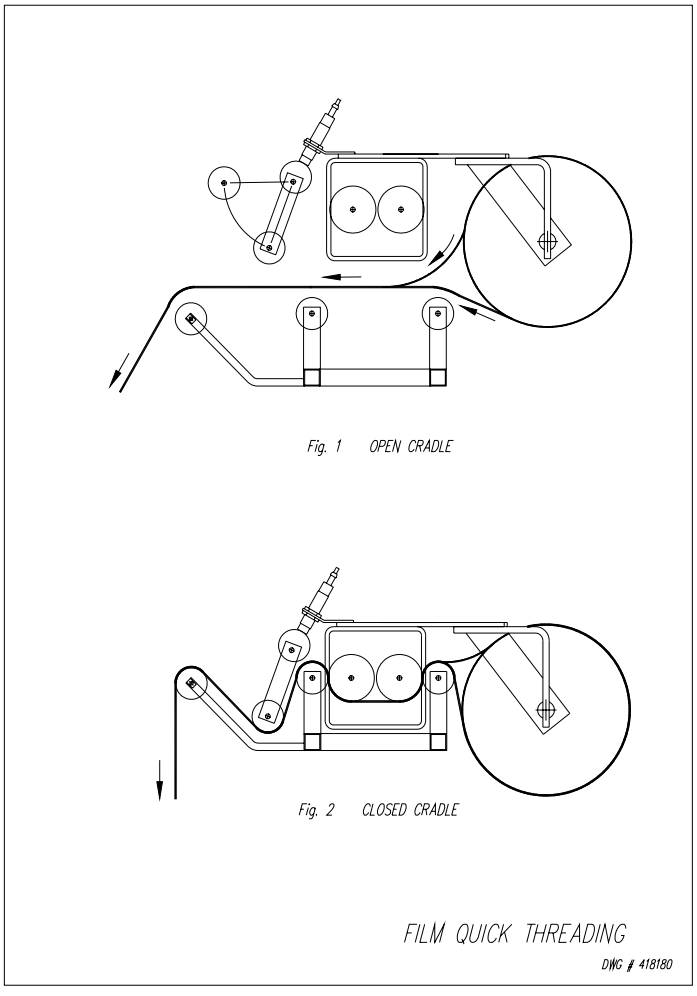
Before the test procedures adjust the wrapping cycle parameters i.e. top wraps, bottom wraps, height photocell on/off, film tension, carriage speed (Last two parameters may be adjusted during the wrapping cycle).

LOADING THE FILM

The film roll can be loaded on the carriage mandrel from either end of the roll. When using tacky film, please verify that the inward tacky surface of the film is inward on the load.

1. Disconnect power (turn off power switch).
2. Swing up the top mandrel spool.
3. Put the roll of film on the bottom mandrel.
4. Install the top mandrel on top of the roll to prevent upward movement.
5. Pull the handle marked PULL TO OPEN to open film distributor cradle.
6. Pass the roped tail of the film through opening (as shown on the film quick threading pattern DWG. # 418180 Fig.1).
7. Close the film distributor cradle by pushing bar marked PUSH TO CLOSE.
8. When the film feeding is completed (fig. 2) – turn the power switch on.
9. Peel off the first few winds of the film (multistrech will run due to displacement of the dancer roller) and fix the film end onto the load.

The system is now ready to begin the first wrapping cycle.

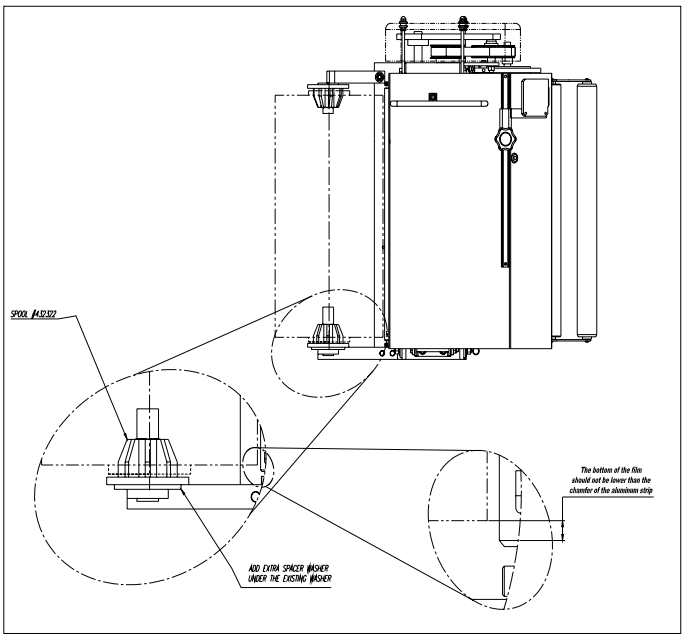


ADDITIONNAL SPACER WASHER

(IF NEEDED ONLY)

The roll of film may be slightly different from time to time, so you might have to change the bottom spool spacer (washer). The only thing you have to do is to add or remove the spacer washer under the bottom spool. With the machine their is 1 washer under the bottom spool (432322), and you have received with the machine 2 extra washer to be use if needed.

<u>Note:</u> The bottom of the film should not be lower than the chamfer of the aluminum strip as shown on the drawing below.

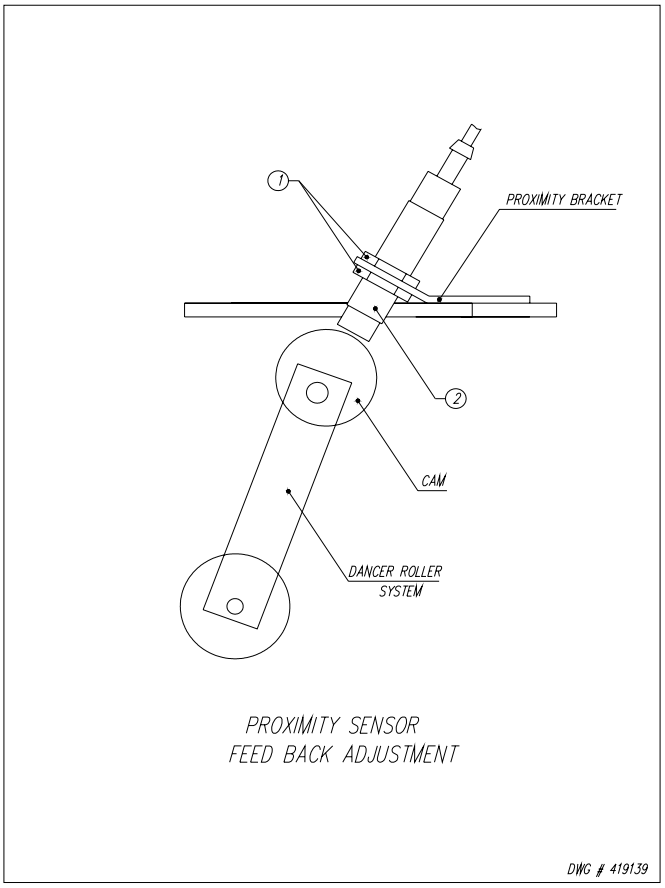


PROXIMITY SENSOR ADJUSTMENT

Occasionally the Feed Back Proximity Sensor may need some adjustment. The position of the feed back proximity sensor against the cam is shown on drawing # 419139 and on ***Figure 6***.

Adjustment instructions:

- Power down machine.
- Remove the carriage cover.
- Unbolt the two nuts holding the proximity switch - item # 1.
- Turn the Proximity sensor - (item # 2) to create the gap between the cam and the front side of proximity sensor about 1/8 ".
- Tighten on the nuts securing the Proximity Sensor.
- Put the cover back on.
- Power up machine.
- Turning the trim pot SPAN adjust the moment when motor starts to turn when dancer roller moved from its home position up to 1 1/2".
- If not satisfied repeat the procedure.



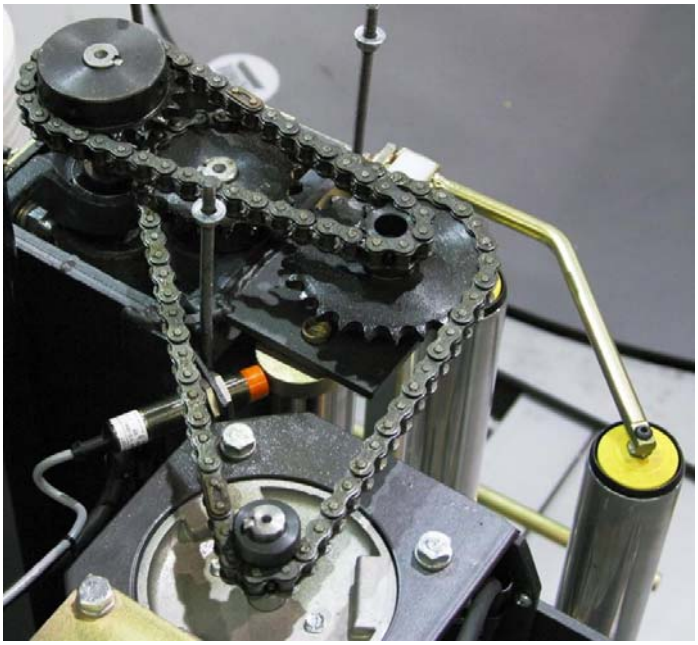


Figure 6

MACHINE MAINTENANCE

All general information about machine maintenance is based on normal machine working conditions: indoor, moderate dust and low moisture environment, and maximum rotation of 32 RPM of turntable/rotary arm. They should be regarded as guidelines, reviewed and corrected according to requirements of actual use and conditions.

MOTOR MAINTENANCE

An occasional inspection of the brushes should be made in order to establish a wear rate. Replacement brushes should be installed before old brushes wear to 9/16" long, measured on the long side. After replacing brushes run the motor near rated speed for at least l/2 hour with no load to seat the new brushes. Failure to properly seat the new brushes may cause commutator damage and rapid wear of the new brushes. If the commutator becomes rough, scored or out of shape, a competent motor shop should disassemble it and resurface the commutator. With every third brush change, have a competent motor shop resurface the commutator and blow the carbon dust out of the motor.

REDUCER OIL CHANGE

All external cap screws and plugs on the reducing transmission should be checked for tightness after the first week. It is recommended to change the oil every six months or at least 1800 hours of operation, whichever comes first. When adding or changing oil, the transmission should never be filled above the oil level mark indicated, because leakage and overheating may occur. Below is the list of the type of lubricant that should be used. List of recommended reducer oils:

Manufacturer	Lubricant
American Oil Co.	American Cyl Oil no: 196-L
Cities Service Oil Co.	Citgo Cyl Oil 100-5
Gulf Oil Corp.	Gulf Senate 155
Mobil Oil Corp.	Mobil 600 W Suer-r Cyl. Oil
Philips Oil Corp.	Andes S 180
Texaco Inc.	624 + 650T Cyl.Oil
Shell Oil Co.	Velvata Oil J82
Union Oil of Cal.	Red Line Worm Gear Lube 140

RING BEARING MAINTENANCE (when applicable)

The ring bearing (located under the turntable) should be re-lubricated internally and externally.

Internally: by injecting grease into all the lubrication nipples in succession until a collar of fresh grease appears around the perimeter of the ring. The re-lubrication interval suggested for these bearings, used in Stretch Wrapping Machinery is 750 hours, with a maximum period of 6 months. The lubricant should be fresh and applied in sufficient quantities to make sure all surfaces are lubricated.

Externally: by lubricating and wiping the chain drive with oily cloth. The frequency of lubrication depends on entirely upon the usage of the machine and environment in which the machine is placed (dust, moisture etc.). Machines working under extremely dirty conditions should be lubricated every 400 operating hours but at minimum, every 2 months. Longer lubrication intervals may occur only when machine is working under very clean and dry conditions but should be not be longer than 6 months.
List of recommended lubricants for the ring bearing lubrication

Manufacturer	Lubricant
BP	Energrease LS2
Castrol	Speeroll AP2
Esso	Beacon 2
Gulf	Crown Grease 2
Mobil	Mobilus 2
Shell	Avania Grease R2
Texaco	Glissando FT 2
Valvoline	LB-2

TOWER RACEWAYS MAINTENANCE

The film distributor (carriage) is sliding on the plastic guides attached behind its back plate. The section of the tower on which the plastic guides move (raceways) should be cleaned and re-greased approximately every 600 hours of machine operation.

NOTICE: If the machine works in a dusty and corrosive environment, the raceways should be re-greased more often (at least every 100 hours).

CHAIN MAINTENANCE

To clean the chain, wipe it with an oily cloth every month. When machine is working in a dusty and damp environment, it may be necessary to repeat the cleaning operation more often. As the chain lubricants please use the most common chain lubricants on the market. With time, the chain will tend to stretch. A loose tower chain should be tightened by moving the reducer on its mounting plate. Turntable is equipped with automatic chain tensionner and does not need any adjustement.

NOTICE: First chain tension inspection must be done after the first two weeks of machine usage.

CAM FOLLOWER MAINTENANCE (when applicable)

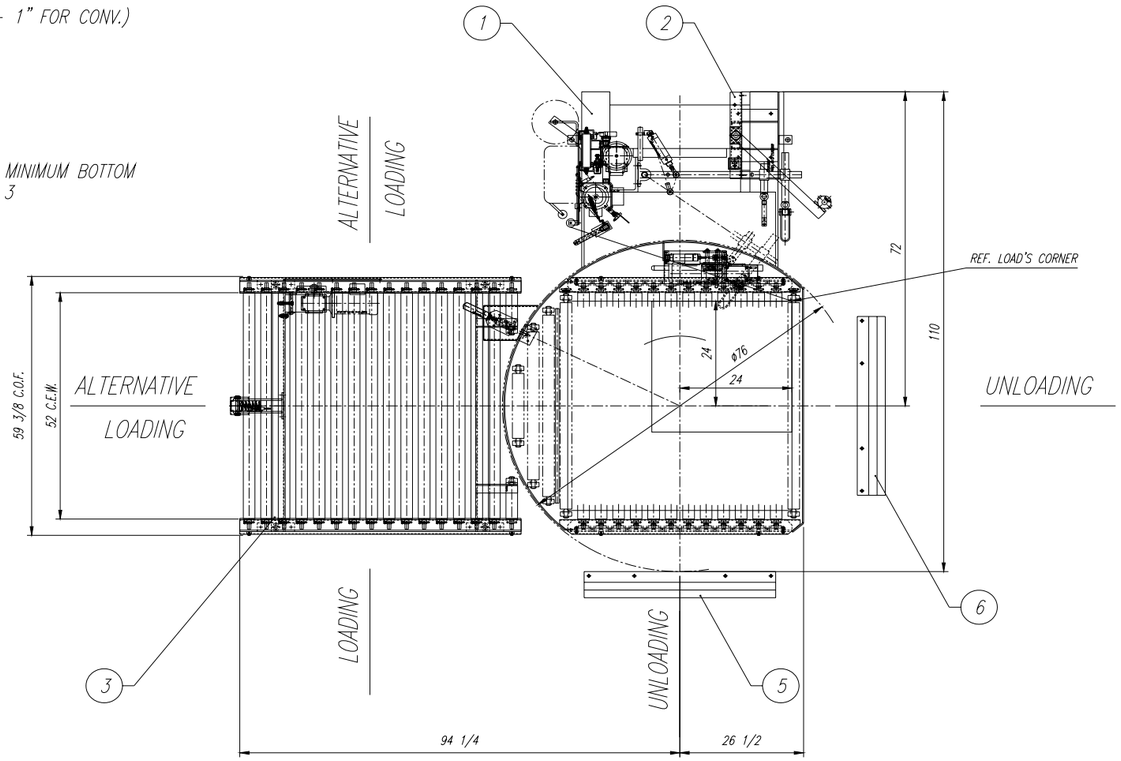
The cam followers have deep grease pockets and do not need frequent relubrication. The portion of the tower on which the cam followers run, should be cleaned and regreased every 300 hours of operation. If the machine operates in a dusty or corrosive environment the tower should be relubricated more often.

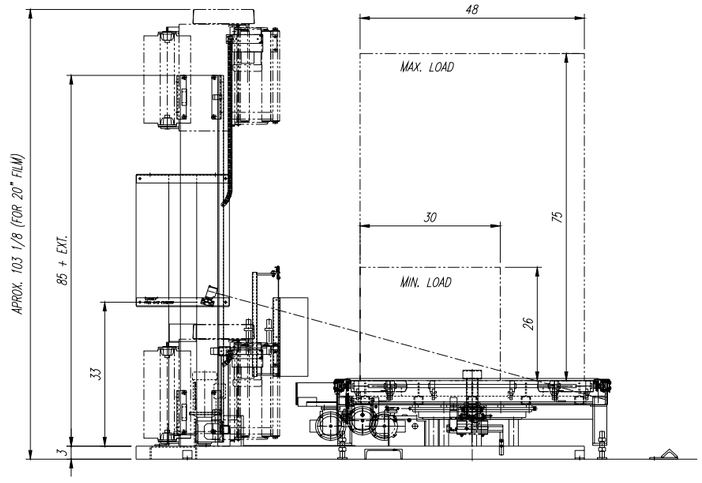
SEMI-AUTOMATIC STANDARD ASSEMBLY PART LIST

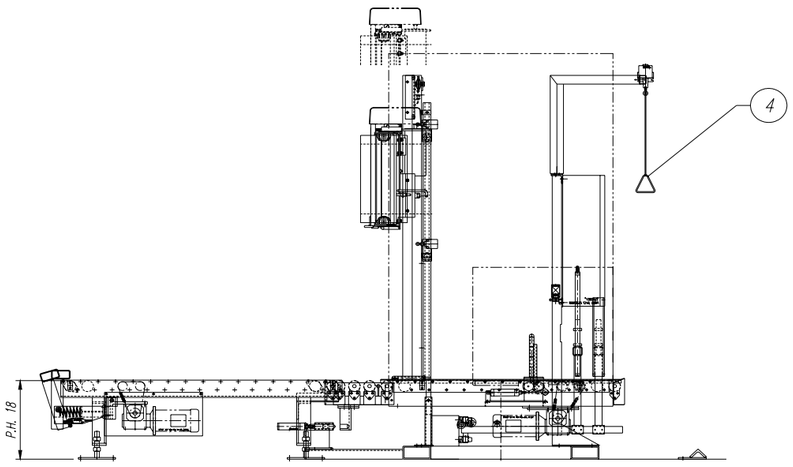
Note :
*** Quantity listed in order of part number**
**** The names given to the parts are generic**

NOTE :

1. CONVEYOR ROLLERS : 2 1/2" DIA. x 3 3/4" CENTERS , 52" EFECTIVE WIDTH
2. CONVEYOR PASS HEIGHT : 18" (FIXED FOR CENTRAL MODUL, ADJUSTABLE +/- 1" FOR CONV.)
3. CONVEYOR SPEED : 30 FPM
4. TURNTABLE SPEED : 12 RPM
5. MAX. LOAD SIZE : 48" L x 48" W x 75" H
6. MIN. LOAD SIZE : 30" L x 30" W x 26" H (*)
   (*) - FOR 20" FILM CARRIAGE. (FOR 30" FILM CARRIAGE IT IS 36" H)
7. LOAD WEIGHT : MIN. 200 Lbs , MAX. 4000 (**)
   (**) - IF PALLET BOTTOM BOARDS ARE PARALLEL TO CONVEYOR ROLLERS, THE MINIMUM BOTTOM BOARD WIDTH IS 4" , AND THE MINIMUM NUMBER OF BOTTOM BOARD IS 3
8. POWER REQUIREMENT : 115 VAC, 1 Ph, 60 Hz, 20 Amp
9. AIR SUPPLY : 3 CFM @ 80 PSI
10. MACHINE COLOR : "ORION STD. GREY"
11. REVERSING CONVEYOR







No.	DESCRIPTION	DWG SIZE	PART No.	Q'ty	WEIGHT
6	FORKLIFT WHEEL STOP			1	
5	FORKLIFT WHEEL STOP			1	
4	LANYARD SWITCH HANDLE ASS'Y			1	
3	5 FT CONTOUR ROLLER CONVEYOR			1	
2	ELECTRICAL PANEL STAND			1	
1	BASE & TOWER ASS'Y 76" DIA. TURNTABLE ASS'Y 20" INSTA-THREAD FILM CARRIAGE ASS'Y 20" FILM TAIL TREATMENT ASS'Y			1	

REMARKS:

REMARKS:

CTS 67 LAYOUT

orion
PACKAGING INC.
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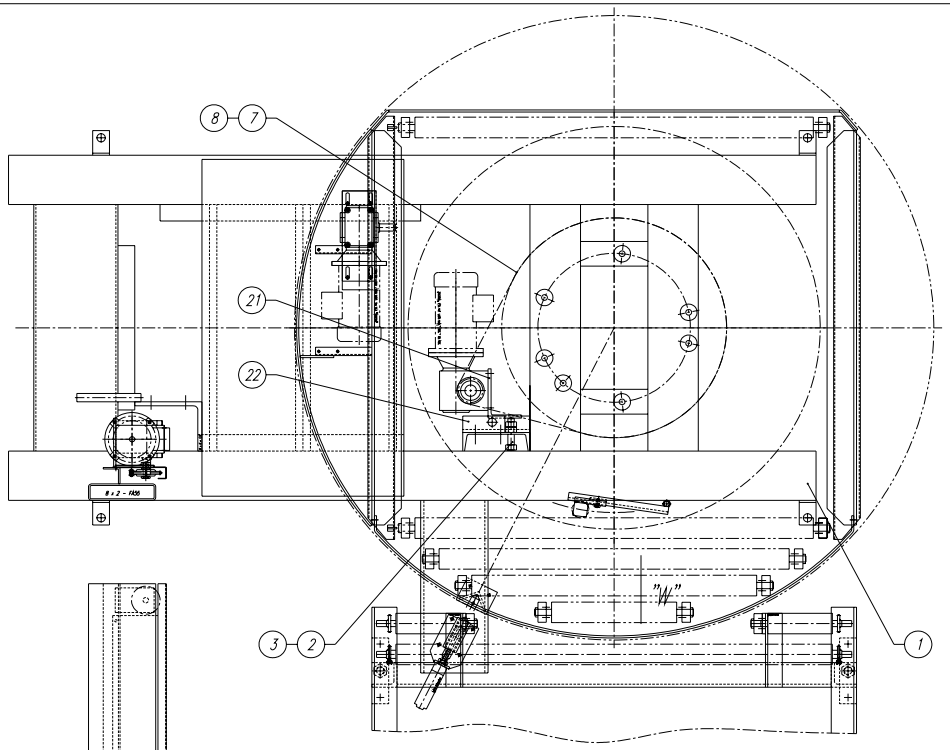
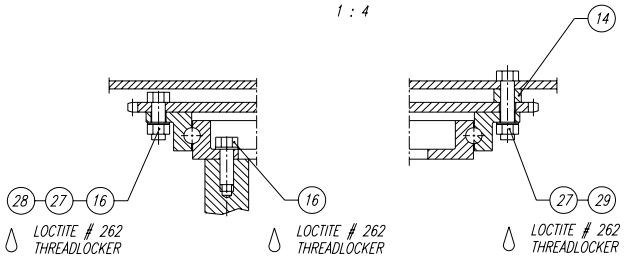
QUEBEC, CANADA, H7S 1P9
TEL.: (514) 667-9769

DATE:	AUG-29-2003
SCALE:	1 : 8
DRAWN BY:	S. KUBICKA
MACHINE TYPE:	CTS67
CHECKED BY:	K. GLOWACKI
DRAWING SIZE:	D
ASSEMBLY DWG:	-
JOB No.:	STD 2003/2
DRAWING No.:	438880M

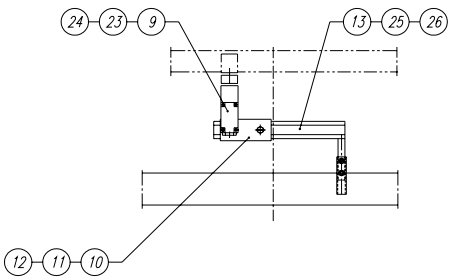


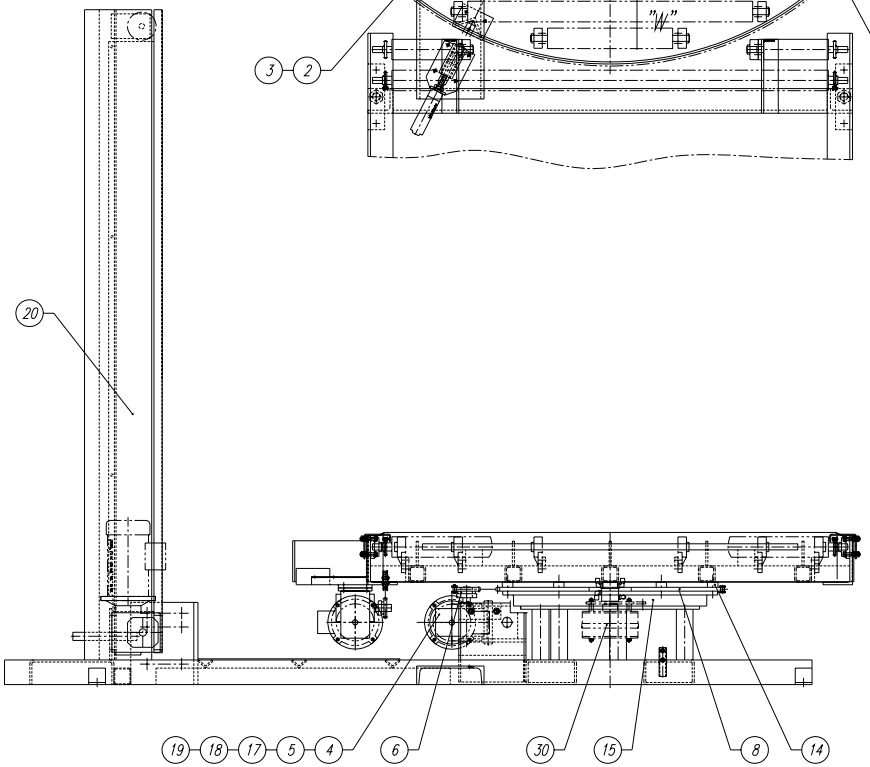
TURNTABLE BEARING MOUNTING

1 : 4



VIEW "W"





No.	DESCRIPTION	DWG SIZE	PART No.	Q'ty	WEIGHT
30	ROTORSEAL-SLIPRING ASS'Y (4 WIRES)		427861	1	
29	HEX HEAD SCREW		013405	6	
28	CENTERING BUSHING		402388	4	
27	HEX. NUT		012846	10	
26	HEX. NUT		013407	2	
25	HEX HEAD SCREW		013470	2	
24	HEX. NUT		012726	2	
23	RD. HEAD PHILLIPS SCREW		012858	2	
22	TOP BRACKET		403103	1	
21	REDUCER BASE		436762	1	
20	TUBULAR TOWER (L - R) ASS'Y		438882	1	
19	SPRING WASHER		012724	4	
18	FLAT WASHER		012725	4	
17	HEX HEAD SCREW		010455	4	
16	HEX HEAD SCREW		012847	11	
15	TURNTABLE BEARING		014671	1	
14	TT. SPACER		270060	6	
13	PROXIMITY SWITCH CHANNEL		260972	1	
12	HEX HEAD SCREW		012474	1	
11	CHANNEL GUIDE		220518	1	
10	PROXIMITY SWITCH HOLDER		260817	1	
9	PROXIMITY SWITCH		010739	1	
8	SPROCKET		415961	1	
7	CHAIN		011484	1	
6	SPROCKET		011226	1	
5	REDUCER		015699	1	
4	EL. MOTOR		017851	1	
3	HEX. NUT		012992	1	
2	ADJUSTING SCREW		403264	2	
1	SA66 BASE WELDING (L - R)		436211	1	

REMARKS:

REMARKS:

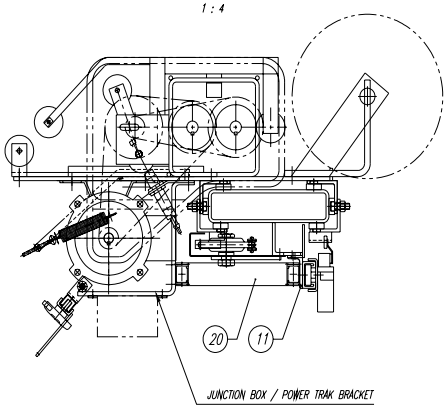
CTS67 BASE & TOWER ASS'Y (L - R)

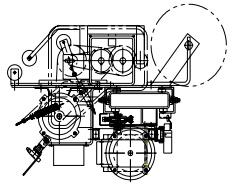
orion
PACKAGING INC.
2270 INDUSTRIEL, LAVAL
QUEBEC, CANADA, H7S 1P9
TEL.: (514) 667-9769

DATE: AUG-29-2003		SCALE: 1 : 8
DRAWN BY: S. KUBICKA		MACHINE TYPE: CTS67
CHECKED BY: K. GLOWACKI		DRAWING SIZE: D
ASSEMBLY DWG: 438880 D	JOB No.: STD 2003/2	DRAWING No.: 438881M

POWER TRAK MOUNTING

1 : 4

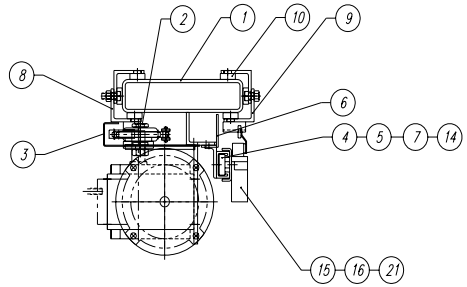


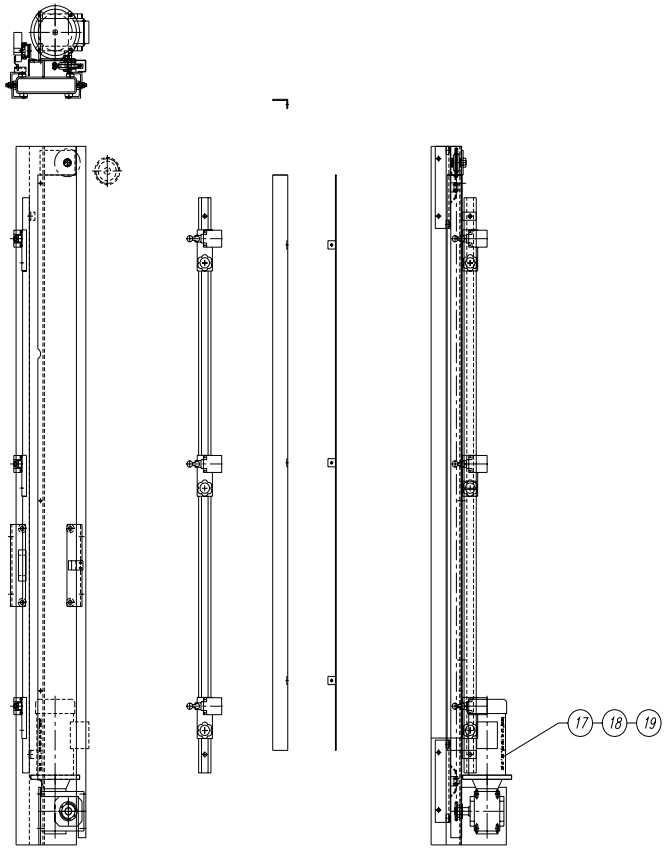


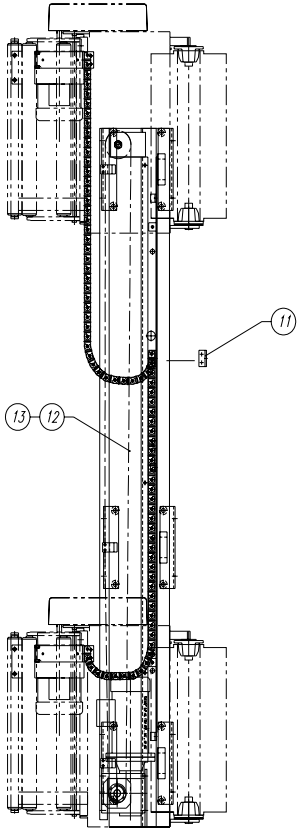
"W"

VIEW "W"

1 : 4







No.	DESCRIPTION	DWG SIZE	PART No.	Q'ty	WEIGHT
21	LIMIT SWITCH		010123	3	
20	NYLATRAC		015897	1	
19	SPROCKET		010074	1	
18	REDUCER		015700	1	
17	EL. MOTOR		017851	1	
16	HEX. NUT		012726	6	
15	PAN PHILL SCREW		012481	6	
14	HEX. HEAD SCREW		012474	3	
13	CHAIN LINK		010009	2	
12	ROLLER CHAIN		010009	1	
11	TOWER POWER TRAK BRACKET		435272	1	
10	SLIDE BUTTON		427058	12	
9	CARRIAGE ATTACHMENT ANGLE W/ACTUATOR		424814	1	
8	CARRIAGE CHAIN ATTACHMENT ANGLE		420000	1	
7	CHANNEL GUIDE		220518	3	
6	LIMIT SWITCH CABLE COVER		436276	1	
5	LIMIT SWITCH HOLDER		260816	3	
4	LIMIT SWITCH CHANNEL		409047	1	
3	CHAIN GUARD (L-R)		436281	1	
2	IDLER SPROCKET ASS'Y		420809	1	
1	TUBULAR TOWER 8 x 2 WELDING (L-R)		436274	1	

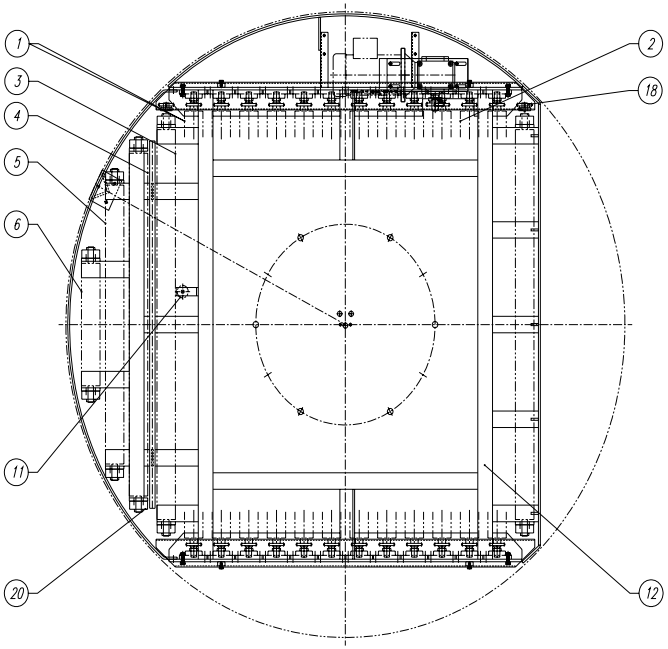
REMARKS:

REMARKS:

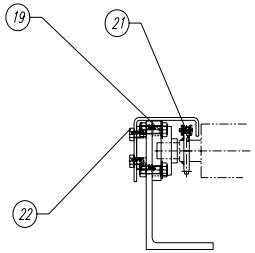
CTS67 TUBULAR TOWER 8 x 2 ASS'Y (L-R)

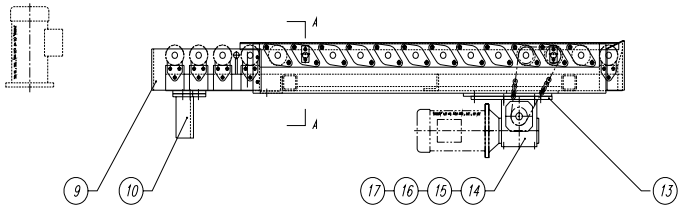
orion
PACKAGING INC.
2270 INDUSTRIEL, LAVAL
QUEBEC, CANADA, H7S 1P9
TEL.: (514) 667-9769

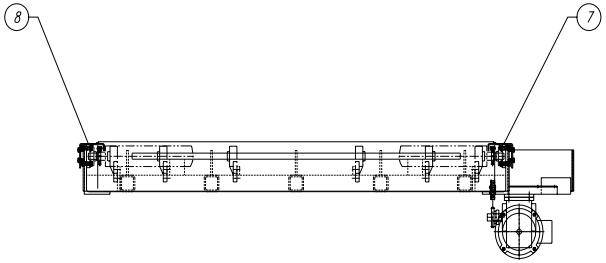
DATE: AUG-29-2003		SCALE: 1 : 8
DRAWN BY: S. KUBICKA		MACHINE TYPE: CTS67
CHECKED BY: K.GLOWACKI		DRAWING SIZE: D
ASSEMBLY DWG: 438880 D	JOB No.: STD 2003/2	DRAWING No.: 438882M



A – A
1 : 4







No.	DESCRIPTION	DWG. SIZE	PART No.	Q'ty	WEIGHT
22	HEX. HEAD CAP SCREW		013471	8	
21	ROLLER CHAIN		010583	12	
20	BEARING		012341	10	
19	CONVEYOR CHAIN GUARD & BEARING, ASS'Y		436896	24	
18	SPROCKET		010748	2	
17	ROLLER CHAIN		010009	1	
16	SPROCKET		010411	1	
15	EL MOTOR		017851	1	
14	REDUCER		015189	1	
13	REDUCER BASE		200626	1	
12	CTS67 TURNTABLE WELDING		437969	1	
11	PROXIMITY SWITCH TARGET		402711	1	
10	TURNTABLE LOCK CATCH		436221	1	
9	INFEED SIDE GUARD		436218	1	
8	CHAIN GUARD		437976	1	
7	DRIVE SIDE CHAIN GUARD		437977	1	
6	ROLLER		410045	1	
5	ROLLER		410046	1	
4	ROLLER		409971	1	
3	ROLLER		414494	2	
2	MEDIUM DUTY DRIVE ROLLER		434967	2	
1	MEDIUM DUTY BASIC ROLLER		434966	10	

REMARKS:

REMARKS:

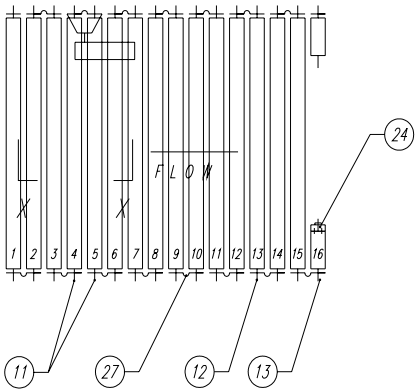
CTS67 76" DIA. TURNTABLE W/ROLLER CONVEYOR L-R

orion
PACKAGING INC.
2270 INDUSTRIEL, LAVAL
QUEBEC, CANADA, H7S 1P9
TEL.: (514) 667-9769

	DATE: AUG-29-2003	SCALE: 1 : 8
	DRAWN BY: S. KUBICKA	MACHINE TYPE: CTS67
	CHECKED BY: K. GLOWACKI	DRAWING SIZE: D
ASSEMBLY DWG.: 438880 D	JOB No.: STD 2003/2	DRAWING No.: 438883M

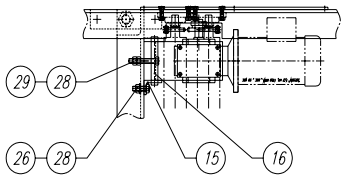
DIAGRAM

N T S



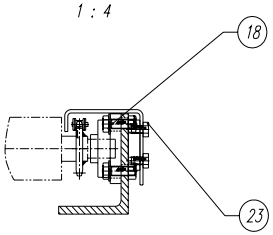
X – X

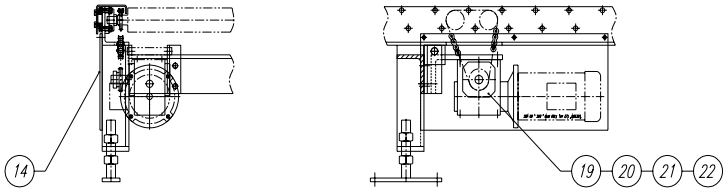
CONV. DRIVE ASS'Y

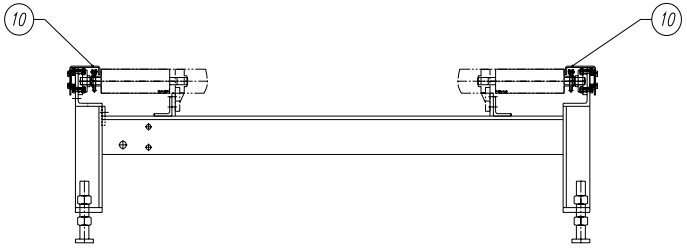


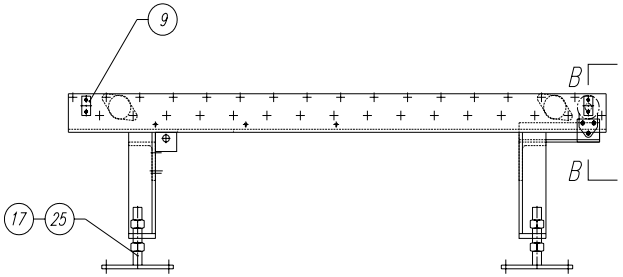
B – B

1 : 4









No.	DESCRIPTION	DWG. SIZE	PART No.	Q'ty	WEIGHT
29	HEX. HEAD CAP SCREW		010408	1	
28	REGULAR HEX. NUT		011266	4	
27	ROLLER CHAIN		010583	14	
26	HEX. HEAD CAP SCREW		010287	2	
25	HEX. NUT		012688	8	
24	BEARING		012341	2	
23	HEX. HEAD CAP SCREW		013471	8	
22	ROLLER CHAIN		010009	1	
21	SPROCKET		010411	1	
20	REDUCER		015189	1	
19	EL. MOTOR		017851	1	
18	CONVEYOR CHAIN GUARD & BEARING ASS'Y		436896	32	
17	LEG		240868	4	
16	REDUCER BASE		403685	1	
15	BRACKET R.H.		408196	1	
14	CONVEYOR DRIVE GUARD		436184	1	
13	MEDIUM DUTY CONTOUR ROLLER		434968	2	
12	MEDIUM DUTY BASIC ROLLER		434966	13	
11	MEDIUM DUTY DRIVE ROLLER		434967	2	
10	5 FT CHAIN GUARD		436968	2	
9	CONVEYOR CHAIN GUARD SPACER		436894	4	

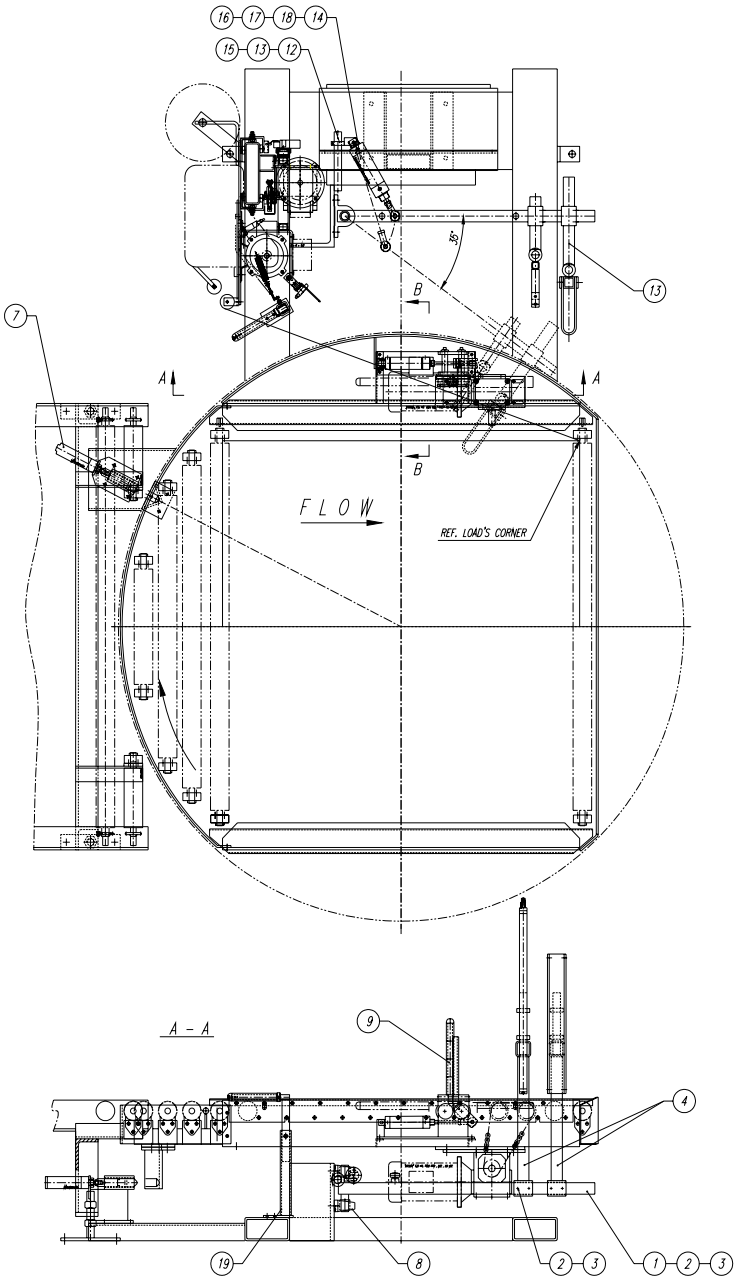
REMARKS:

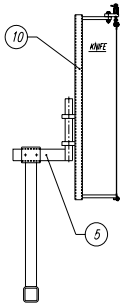
REMARKS:

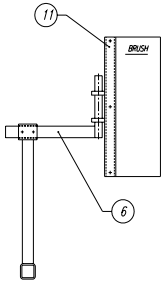
CTS67- 5 FT LG CONTOUR ROLLER CONVEYOR L-R

orion PACKAGING INC.
2270 INDUSTRIEL, LAVAL
QUEBEC, CANADA, H7S 1P9
TEL.: (514) 667-9769

DATE: AUG-29-2003		SCALE: 1 : 8
DRAWN BY: S. KUBICKA		MACHINE TYPE: CTS67
CHECKED BY: K. GLOWACKI		DRAWING SIZE: D
ASSEMBLY DWG.: 438880 D	JOB No.: STD 2003/2	DRAWING No.: 438884M







No.	DESCRIPTION	DWG SIZE	PART No.	Q'ty	WEIGHT
19	ROPING ROLLER ASS'Y		431001	1	
18	FLAT WASHER		017494	1	
17	SOCKET HD CAP SCREW		010191	1	
16	AIR CYLINDER		014167	1	
15	CYLINDER HOLDER		424885	1	
14	ROD END		013813	1	
13	HEX. NUT		011128	1	
12	HEX. HEAD CAP SCREW		013479	1	
11	20" BRUSH ASS'Y		417539	1	
10	20" HOT WIRE CUTTER ASS'Y		417750	1	
9	FILM CLAMP ASS'Y R.H.		414433	1	
8	BEARING		011191	2	
7	TURNTABLE POSITIONING LOCK ASS'Y		436080	1	
6	ARM SEGMENT		404925	1	
5	KNIFE ARM SEGMENT		417244	1	
4	BRUSH HOLDER		412236	2	
3	HEX NUT		012751	8	
2	HEX BOLT		012757	8	
1	CUTTER-BRUSH ARM		427730	1	

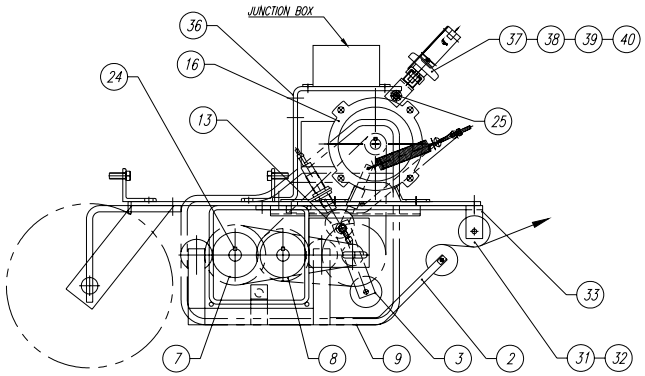
REMARKS:

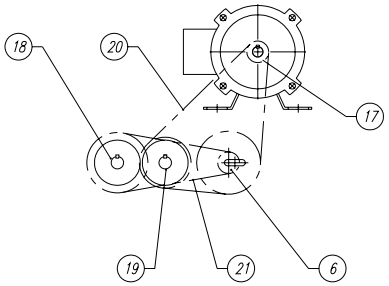
REMARKS:

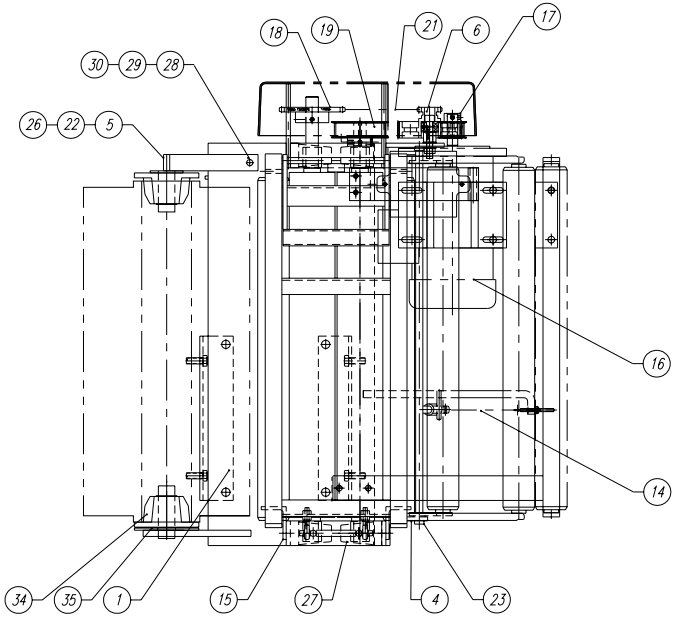
CTS67 FILM TAIL TREATMENT

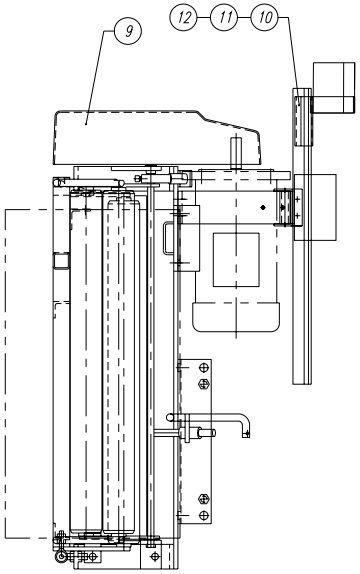
orion PACKAGING INC.
2270 INDUSTRIEL, LAVAL
QUEBEC, CANADA, H7S 1P9
TEL.: (450) 667-9769

DATE: SEP-04-03	SCALE: 1 : 8
DRAWN BY: S. KUBICKA	MACHINE TYPE: CTS67
CHECKED BY: K. GLOWACKI	DRAWING SIZE: D
ASSEMBLY DWG: 438880 D	JOB No.: STD 2003/2	DRAWING No.: 438916M









No.	DESCRIPTION	DWG. SIZE	PART No.	Q'ty	WEIGHT
40	BLACK KNOB		010092	1	
39	PAN PHILL SCREW		012481	2	
38	HEX. NUT		012726	2	
37	CHANNEL GUIDE		427690	1	
36	JUNCTION BOX/POWER TRAK BRACKET		435553	1	
35	BOTTOM SPOOL WASHER		432322	1	
34	BOTTOM SPOOL		432323	2	
33	20" (30") ROLLER BRACKET (FLR)		427276	1	
32	IDLE ROLLER SHAFT-20"		413249	1	
31	ALUMINUM ROLLER 1.9 - 20"		402789	1	
30	HEX. NUT		012689	1	
29	FLAT WASHER		012221	1	
28	SOCK. HD. CAP SCREW		010259	1	
27	PILLOW BLOCK		011192	4	
26	FLAT WASHER		012323	1	
25	HEX. HEAD SCREW		012474	2	
24	SQ. KEY		010227	3	
23	FL. BRONZE BUSHING		014247	2	
22	SELF SEATING RETAINING RING		013860	2	
21	CHAIN		013397	1	
20	TIMMING BELT		011151	1	
19	PULLEY		431672	1	
18	SPROCKET (245 %)		428647	1	
17	PULLEY		431477	1	
16	EL. MOTOR		015240	1	
15	CRADLE ROLLER OPENING LOCK		409469	2	
14	TENSION SCREW ASS'Y		433628	1	
13	PROXIMITY SENSOR CAM		413744	1	
12	PHOTOCELL BRACKET		435397	1	
11	PHOTOCELL HOLDER (FLR, FRL)		432739	1	
10	PHOTOCELL CHANNEL		434651	1	
9	FIBERGLASS COVER - FLR		414854	1	
8	RUBBER ROLLER - 2 (20" FILM)		420917	1	
7	RUBBER ROLLER - 1 (20" FILM)		420916	1	
6	SPROCKET / PULLEY ASS'Y		431475	1	
5	TOP MANDREL FLR		414853	1	
4	DANCER ROLLER BRACKET FLR		414852	1	
3	DANCER ROLLER ASSEMBLY - 20" IT, FLR		414843	1	
2	CRADLE ROLLER ASSEMBLY - 20" IT, FLR		426137	1	
1	BACK PLATE - 20" INSTA-THREAD, FLR		438964	1	

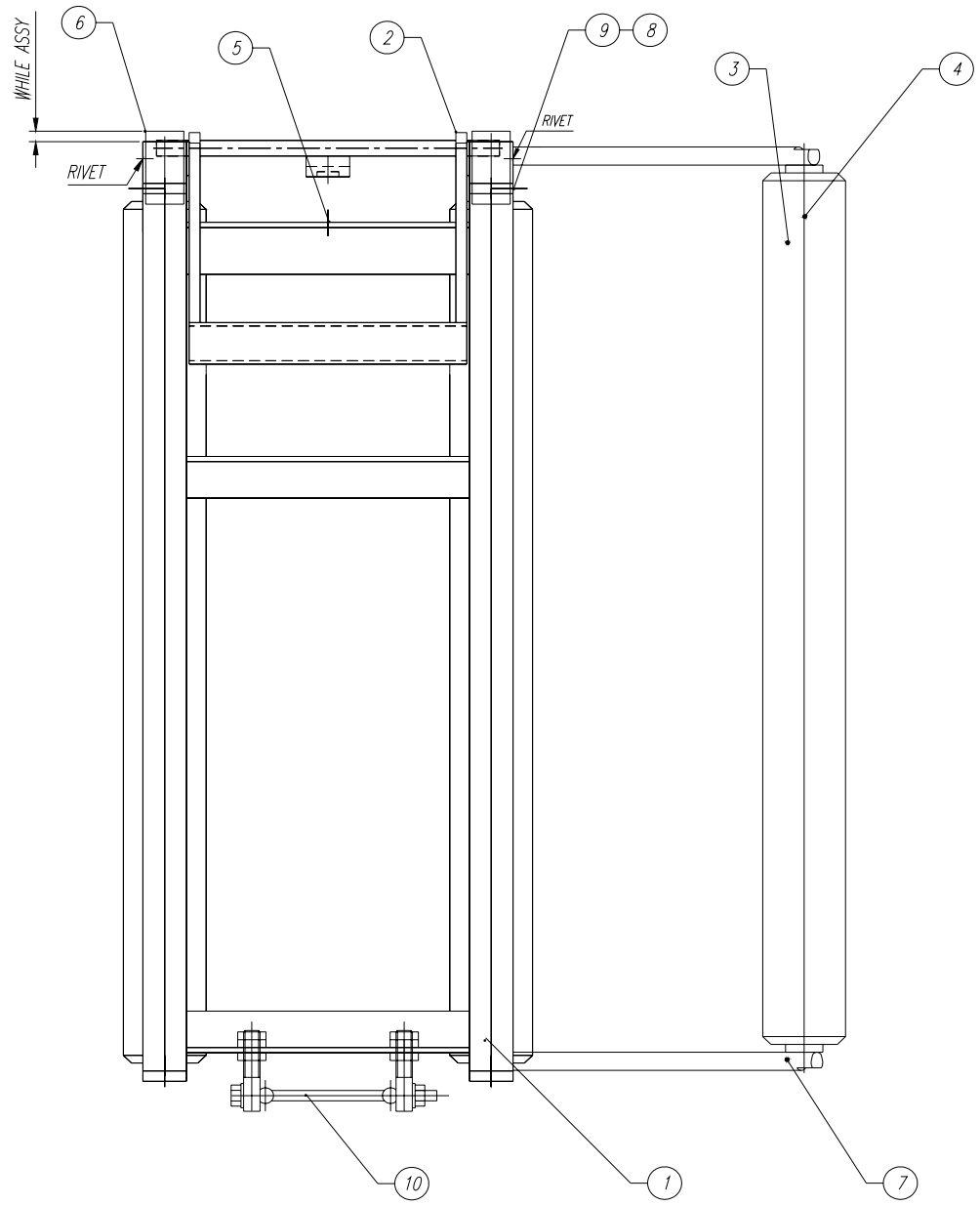
REMARKS:

REMARKS:

20" INSTA-THREAD FILM CARRIAGE ASS'Y (FLR)

orion
PACKAGING INC.
2270 INDUSTRIEL, LAVAL
QUEBEC, CANADA, H7S 1P9
TEL.: (450) 667-9769

DATE: SEP-02-2003		SCALE: 1 : 4
DRAWN BY: S. KUBICKA		MACHINE TYPE: CTS67
CHECKED BY: -		DRAWING SIZE: D
ASSEMBLY DWG.: -	JOB No.: STD 2003/2	DRAWING No.: 438885M



No.	DESCRIPTION	DWG. SIZE	PART No.	Q'ty	WEIGHT
10	CRADLE HINGE ASS'Y		426200	1	
9	HEX NUT		013451	2	
8	HEX SOCK. CAP SCREW		015020	2	
7	HEX SOCK. BUTT. HEAD SCREW		015133	2	
6	POLYETHYLENE		015023	2	
5	SPRING		013994	1	
4	IDLE ROLLER SHAFT		413249	3	
3	ALUMINIUM ROLLER 1.9 DIA - 20 LG		402789	3	
2	LOCK		412542	1	
1	CRADLE ROLLER FRAME - 20" (FLR)		426138	1	

REMARKS:

REMARKS:

CRADLE ROLLER ASSEMBLY - 20 (FLR)

orion
PACKAGING INC.
2270 INDUSTRIEL, LAVAL
QUEBEC, CANADA, H7S 1P9
TEL.: (514) 667-9769

DATE: DEC-13-99

SCALE: 1 : 2

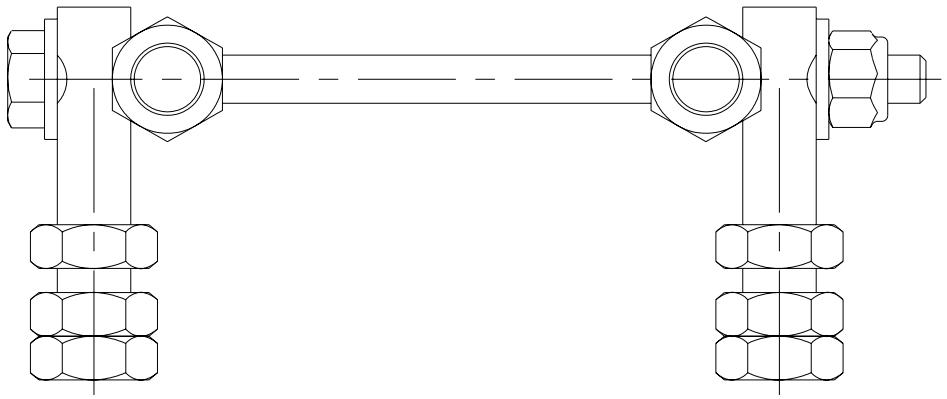
MACHINE TYPE: H,L/14

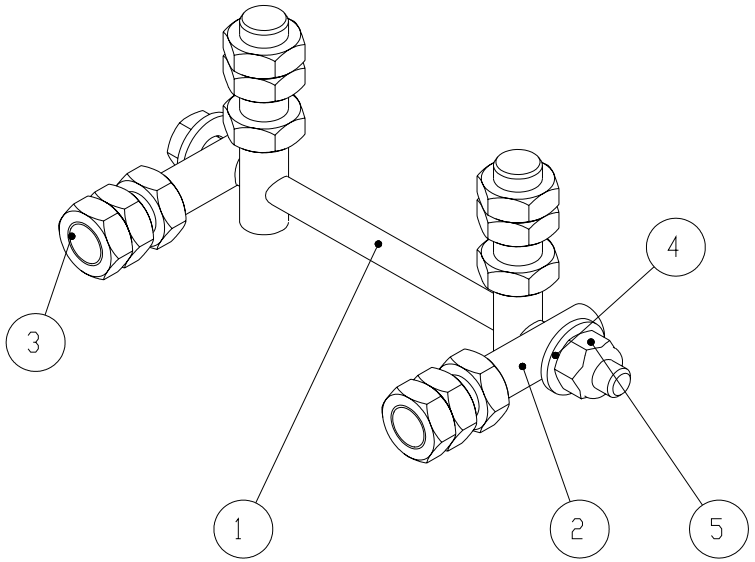
DRAWING SIZE: C

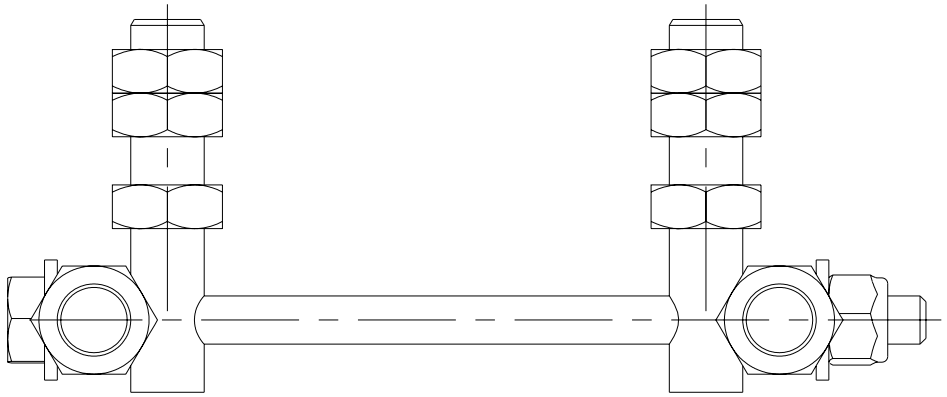
ASSEMBLY DWG.: –

JOB No.: STD

DRAWING No.: 426137M







#	TITLE	Length	PART NO	Q
5	HEX. SELF-LOCKING NUT		015098	1
4	FLAT WASHER		012221	2
3	HEX. JAM NUT		014235	12
2	SPECIAL BOLT		415938	4
1	HEX BOLT		015099	1

REMARKS

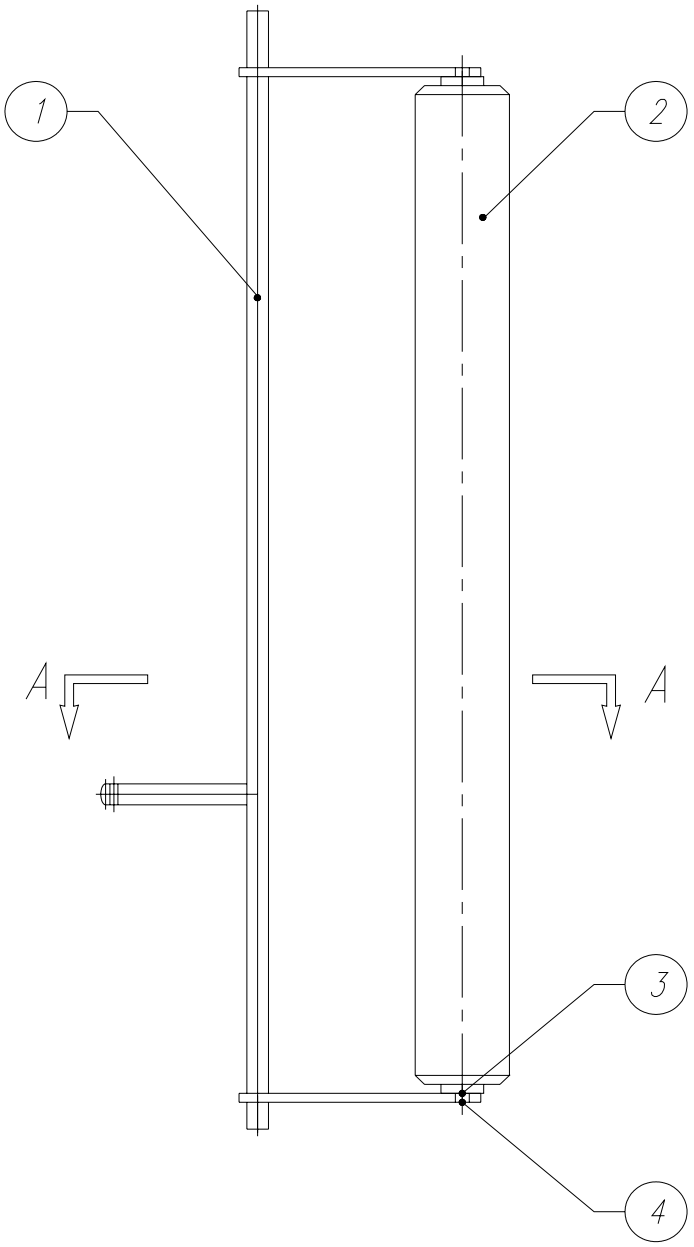
REMARKS

CRADDLE HINGE ASS'Y

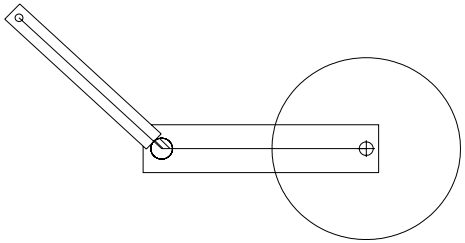
orion
PACKAGING INC.
2270 INDUSTRIEL, LAVAL
QUEBEC, CANADA, H7S 1P9
TEL.: (450) 667-9769

TOLERANCES
UNLESS OTHERWISE SPECIFIED
MACHINED : ±1/32
WELDED : ±1/16
ANGLE : ±1/16 PER 60°
X.XX : ±0.02
X.XXX : ±0.005

DRAWN BY: S.KUBICKA	DRAWN DATE: 12/15/1999	WEIGHT (lb): 0.45	
APPROVED BY:	APPROVED DATE:	SCALE: 1:1	
MACHINE TYPE: ALL	JOB NO.:	SHEET: 1 / 1	
REFERENCE DWG.:	ASSEMBLY DWG:	DWG SIZE: A	DWG NO.: 426200M REV.: A+



A – A



No.	DESCRIPTION	DWG. SIZE	PART No.	Q'ty	WEIGHT
4	HEX HEAD SCREW		012475	2	
3	FLANGE NUT		014164	2	
2	ALUMINIUM ROLLER 1.9 DIA – 20		402789	1	
1	DANCER ROLLER CRADLE – 20 (FLR)		414851	1	

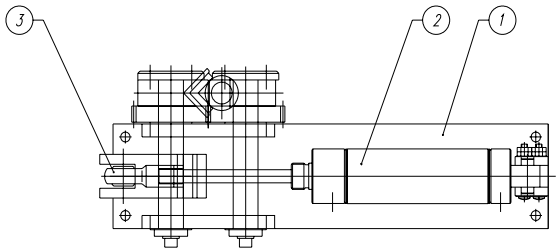
REMARKS:

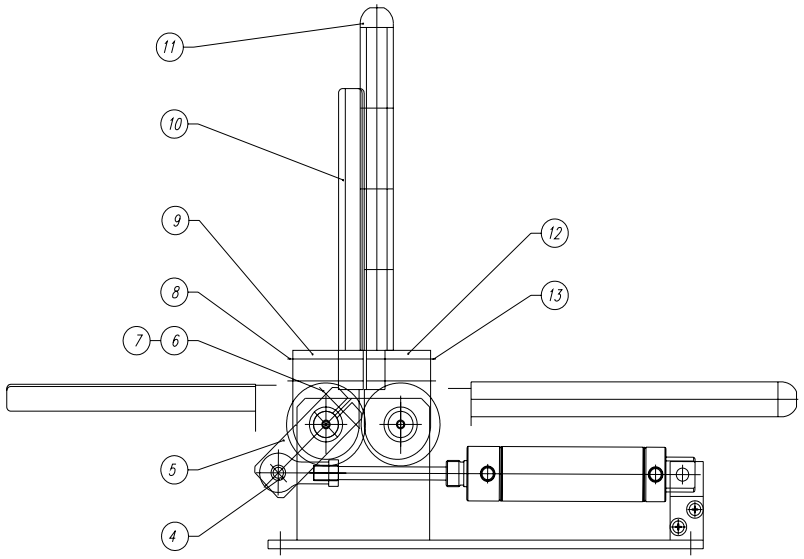
REMARKS:

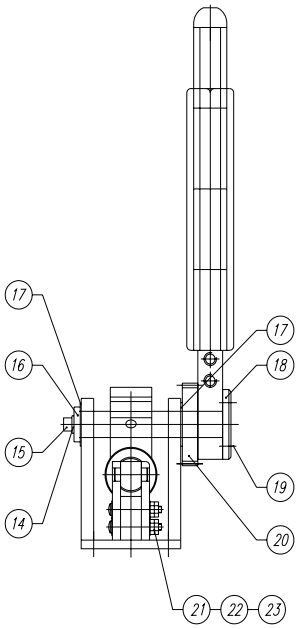
DANCER ROLLER ASSEMBLY – 20 (FLR)

orion
PACKAGING INC.
2270 INDUSTRIEL, LAVAL
QUEBEC, CANADA, H7S 1P9
TEL.: (514) 667-9769

	DATE: JAN-23-1997	SCALE: 1 : 4
		MACHINE TYPE: ALL/12
		DRAWING SIZE: A
ASSEMBLY DWG.: 438636M	JOB No.: STD – 12.1	DRAWING No.: 414843M







No.	DESCRIPTION	DWG. SIZE	PART No.	Q'ty	WEIGHT
23	FLAT WASHER		013335	4	
22	HEX NUT		012726	4	
21	PAN PHIL		012858	2	
20	SPUR GEAR		011384	2	
19	FLAT CAP SCREW		012671	6	
18	CLAMP JAW PIVOT SHAFT		260558	2	
17	THRUST WASHER		010193	4	
16	FLAT WASHER		011381	2	
15	HEX SOCKET SCREW		010286	2	
14	SPRING WASHER		011393	2	
13	HEX SOCKET SCREW		012834	2	
12	SMOOTH JAW HOLDER		401184	1	
11	SMOOTH JAW		400810	1	
10	JAW WITH RUBBER		400811	1	
9	JAW WITH RUBBER HOLDER		401185	1	
8	HEX SOCKET SCREW		012686	2	
7	SPRING WASHER		011390	1	
6	HEX HEAD SCREW		012406	1	
5	CLAMP YOKE		421689	1	
4	SPRING PIN		010264	1	
3	ROD END		011201	1	
2	AIR CYLINDER		014150	1	
1	CLAMP BASE		414465	1	

REMARKS:

REMARKS:

FILM CLAMP ASSEMBLY - R.H.

orion
PACKAGING INC.
2270 INDUSTRIEL, LAVAL
QUEBEC, CANADA, H7S 1P9
TEL.: (514) 667-9769

ASSEMBLY DWG.:

DATE: DEC-09-1996

DRAWN BY: G. SEWERYN

CHECKED BY:

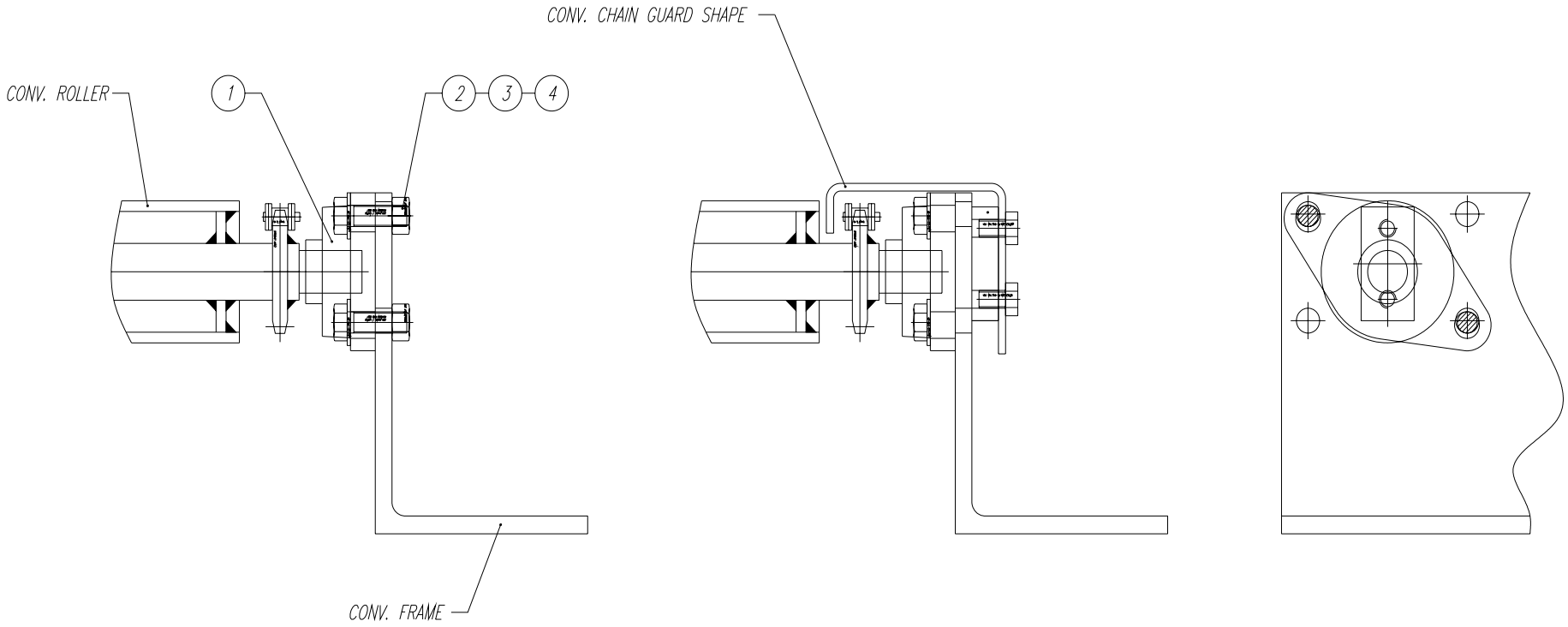
JOB No.: STD

SCALE: 1 : 2

MACHINE TYPE: FA , MA

DRAWING SIZE: D

DRAWING No.: 414433M



No.	DESCRIPTION	DWG. SIZE	PART No.	Q'ty	WEIGHT
4	FL. WASHER		017298	2	
3	HEX. REGULAR NUT		014238	2	
2	HEX. HEAD CAP BOLT		014510	2	
1	BEARING		010042	1	

REMARKS:

REMARKS:

CONVEYOR CHAIN GUARD & 3/4" BRG ASS'Y

orion
PACKAGING INC.
2270 INDUSTRIEL, LAVAL
QUEBEC, CANADA, H7S 1P9
TEL.: (514) 667-9769

DATE: NOV. 26. 2002

SCALE: 1 : 2

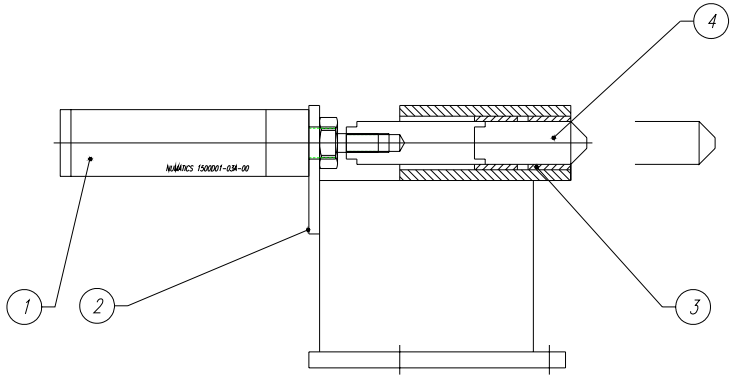
MACHINE TYPE: 33, 44, 55, 66

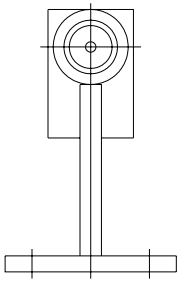
DRAWING SIZE: B

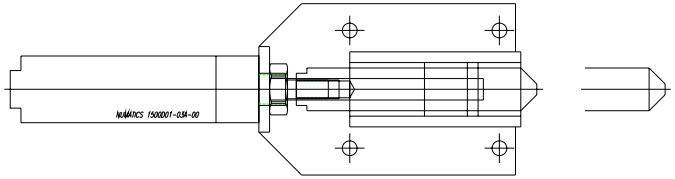
ASSEMBLY DWG.: —

JOB No.: STD

DRAWING No.: 436896M







No.	DESCRIPTION	DWG. SIZE	PART No.	Q'ty	WEIGHT
4	LOCK SHAFT		436215	1	
3	BRONZE BEARING		012925	2	
2	TURNTABLE LOCK BRACKET		436081	1	
1	AIR CYLINDER		014166	1	

REMARKS:

REMARKS:

TURNTABLE POSITIONING LOCK

orion
PACKAGING INC.
2270 INDUSTRIEL, LAVAL
QUEBEC, CANADA, H7S 1P9
TEL.: (514) 667-9769

DATE: SEP. 30. 2002

SCALE: 1 : 2

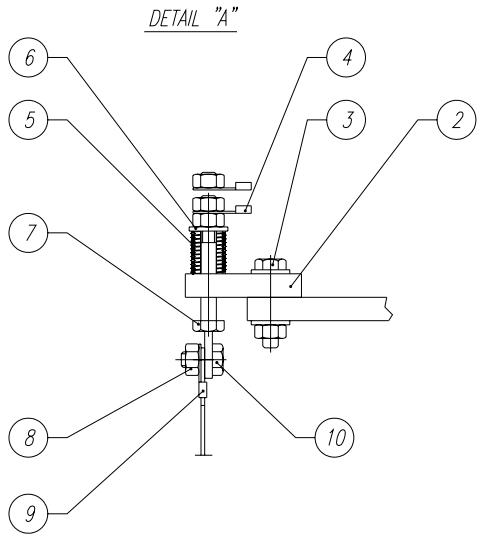
MACHINE TYPE: FA55

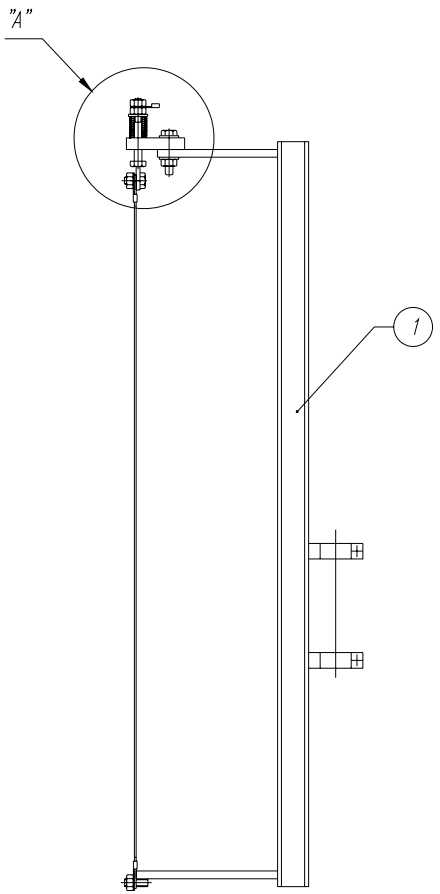
DRAWING SIZE: C

ASSEMBLY DWG.: 436049 D

JOB No.:

DRAWING No.: 436080M





No.	DESCRIPTION	DWG SIZE	PART No.	Q'ty	WEIGHT
10	HEX. HEAD CAP SCREW		012722	1	
9	CUTTING WIRE		402745	1	
8	HEX. NUT		012689	5	
7	WIRE ATTACHMENT		409351	1	
6	FLAT WASHER		012221	1	
5	COMPR. SPRING		013995	1	
4	TERMINAL RING		010693	1	
3	HEX. HEAD CAP SCREW		012793	1	
2	HOT WIRE BRACKET		409350	1	
1	20" CUTTING WIRE BRACKET		417752	1	

REMARKS:

REMARKS:

20" HOT WIRE CUTTER ASS'Y

orion
PACKAGING INC.
2270 INDUSTRIEL, LAVAL
QUEBEC, CANADA, H7S 1P9
TEL.: (514) 667-9769

DATE: OCT-30-1997

SCALE: 1 : 4

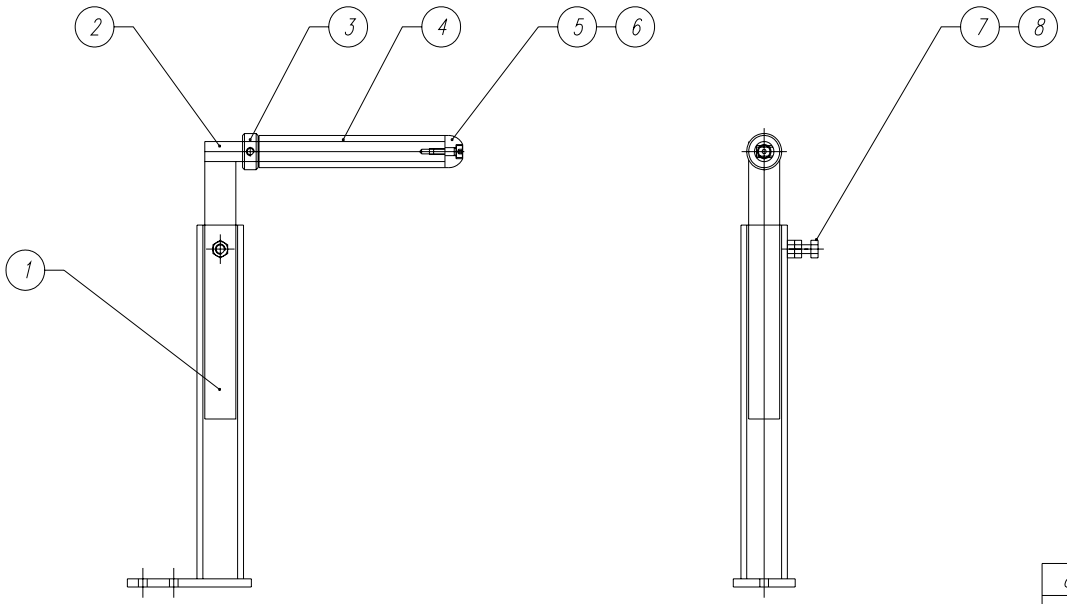
MACHINE TYPE: ALL-66

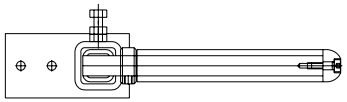
DRAWING SIZE: B

ASSEMBLY DWG: –

JOB No.: 13405

DRAWING No.: 417750M





TOP VIEW

No.	DESCRIPTION	DWG. SIZE	PART No.	Q'ty	WEIGHT
8	HEX. HEAD SCREW		013470	1	
7	HEX. NUT		013407	1	
6	SHOULDER SCREW		015502	1	
5	ROLLER STOPPER		431005	1	
4	ROLLER		431002	1	
3	STEEL COLLAR		014596	1	
2	ROLLER BRACKET		431003	1	
1	STAND		431004	1	

REMARKS:

REMARKS:

ROPING ROLLER ASS'Y

orion
PACKAGING INC.
2270 INDUSTRIEL, LAVAL
QUEBEC, CANADA, H7S 1P9
TEL.: (450) 667-9769

DATE: MAR. 15/2001

SCALE: 1 : 4

DRAWN BY: GREGORY STACHURA

MACHINE TYPE: FA44

CHECKED BY:

DRAWING SIZE: B

ASSEMBLY DWG.: –

JOB No.:

DRAWING No.: 431001M