



ATTENTION:

VERY IMPORTANT

Before unloading and unpacking the stretchwrapper read carefully section 5 of this manual for unloading and unpacking instructions.

Failure to do so may result in the forfeiture of the warranty.

ORION PACKAGING INC.

NOTICE

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

- 1) Serial Number
- 2) Model Number
- 3) Subassembly-Part Location

ORION PACKAGING SYSTEMS, INC.
DISTRIBUTOR PRICE LIST - EFFECTIVE NOVEMBER 1, 1989

ORION MODEL H-66

032070

Spiral Semi-Automatic Medium Heavy Duty High Profile

Maximum Load Size	55"W x 55"L x 82"H (Recommended) 60"W x 60"L x 85"H (Theoretical)*
Weight Capacity	4,000 lbs. dynamic, 8,000 lbs. static
Utilities	115/1/60 20 Amp Electrical Service
Turntable	48" x 48" Octagonal Formed 3/8" Steel Friction Drive Floating Caster Design 11" Height Floor to Top of Turntable
Turntable Drive	0-12 RPM Variable Turntable Speed 1/2 HP DC Drive Motor Friction Drive Wheel Electronic Soft Start Positive Alignment Feature
Control Features	Electronic Film Force Control Separate Top and Bottom Wrap Selectors Variable Speed Film Carriage Control Auto-Height Photocell w/On/Off Switch Film Carriage Raise/Lower Switch Turntable Jog Pushbutton Spiral Up or Up/Down Cycles Current Overload Protection NEMA 12 Electrical Enclosure
Film Delivery	20" Orion MultiStretch Power Prestretch Electronic Film Tension Control End of Cycle Film Force Release Full Authority Film Dancer Bar Chain & Sprocket Stretch Ratio Control 1/3 HP DC/SCR Film Drive
Film Carriage Drive	#50 Roller Chain Carriage Lift 1/3 HP Elevator Drive Motor Variable Speed SCR Control Structural "H" Channel Guidance Precision Cam Follower Tracking
Structural Features	Forklift Portable Base Design All Structural Steel Construction Film Roping Bar 8" x 18 lb./ft. "H" Channel Mast
Est. Shipping Weight	900 lbs.

*Theoretical is based upon removal of roping bar, and
reflects maximum film web height attainable

ORION PACKAGING INC.

H66
Owner's Manual

ORION PACKAGING INC.
2270 Industriel
Laval, Quebec H7S 1P9

Telephone: (514) 667-9769
Fax: (514) 667-6320

ALL Series (except 4)

DISTRIBUTOR PRICE LIST - EFFECTIVE NOVEMBER 1, 1989

AUTO-HEIGHT PHOTOCELL

77 series.....

L77/66.....
L55S/44S.....
L55/44.....
L66-72.....

H77/66 (per foot)
L77/66 (per foot)

H55/44 (per foot)
L55/44 (per foot)
L55S/44S (per foot)

All Series (Except "M") (first foot).....
(each additional foot).....

M77/67/66 (per foot).....
M57/55 (per foot).....
M44 (per foot).....

All Series (Except "M").....

ORION PACKAGING INC.
DISTRIBUTOR PRICE LIST - EFFECTIVE NOVEMBER 1, 1989

SEMI-AUTOMATIC MACHINE OPTIONS

PNEUMATIC TOP PLATENS

36" circular platen with 24" stroke.....
36" circular platen with 36" stroke.....
48" x 48" square platen with homing.....
device, and 36" stroke
48" x 48" square platen with homing.....
device, and 48" stroke

TRANSFORMER

To accept 430/60 or 575/60.....
For each additional conveyor section.....

DUAL TURNTABLE OPTION

L66.....
H66.....
L55/44.....
H55/44.....
L55S/44S.....

NOTE: Dual Turntable options includes second
turntable with all drive components &
controls, second auto-height photocell,
and table selector switch.

NOTE: When a ring gear/pinion gear turntable
drive is required, the cost of 2 ring
gear options must be added to the dual
turntable option price.

RING GEAR/PINION GEAR TURNTABLE DRIVE

H66....(20" DIA.).....
H55....(25" DIA.).....
H44....(33" DIA.).....

Central lubrication point for ring gear.....

72" dia. round, 1/2"

60" dia. round, 1/2"

ORION PACKAGING INC.
DISTRIBUTOR PRICE LIST - EFFECTIVE NOVEMBER 1, 1989

Remote Pull Switch

SEMI-AUTOMATIC MACHINE OPTIONS

Filler Plate (H77/66)

Filler Plate (H55/44)

PROGRAMMABLE LOGIC CONTROLLER OPTIONS

66/55 Series - Allen Bradley SLC-100.....

44 Series - Allen Bradley SLC-150.....

EEPROM ordered with machine.....

EEPROM ordered after shipping of the machine.....

CYCLE COUNTER (inside control panel).....

TURNTABLE OPTIONS

0-12 RPM Variable Speed Turntable Drive for.....
L/H 77 Models

0-12 RPM Variable Speed Turntable Drive with.....
Positive Alignment Feature for L/H 77 Models

10,000 lb Capacity (H55/44).....

8,000 lb Capacity (L55/44).....

10,000 lb Capacity (L55/44).....

Anti-Skid Surface.....

72" dia. round, 3/8" with 4" skirt (H55/44).....

72" dia. round, 1/2" (L44/44S, L55/55S).....

72" dia. round, 1/2" (L66).....

72" dia. round, 3/8" (L66).....

60" dia. round, 1/2" (L66/55/44).....

Reinforced Concentric Rings.....

Remote Pull Switch.....

Filler Plate (H77/66).....

Filler Plate (H55/44).....

ORION PACKAGING INC.
DISTRIBUTOR PRICE LIST - EFFECTIVE NOVEMBER 1, 1989

SEMI-AUTOMATIC MACHINE OPTIONS

COLD TEMPERATURE OPTIONS (-20 F)

Heated Control Enclosure, Silicon Rubber Wiring.....
and Special Lubricant in Reducers

CONVEYOR OPTIONS

IDLER ROLLER (NON-DRIVEN)

72" Dia. idler roller turntable for H66/55/44.....
(On H-66, requires ring gear option and
max. wt. 2,500 lbs) Rollers are 3.5" Dia.
on 4.5" centers, with manual brake.

72" Dia. idler roller turntable for L55S/44S.....
Rollers are 3.5" Dia. on 4.5" centers, with
manual brake.

Pneumatic Roller Brake for "L" Series.....

Pneumatic Roller Brake for "H" Series.....

5' Length CONTOURED Idler Roller Conveyor,.....
3.5" Dia. Rollers on 4.5" Centers, 50" Wide
Roller Face.

5' Length STRAIGHT Idler Roller Conveyor,.....
3.5" dia. rollers on 4.5" centers,
50" wide roller face.

POWERED ROLLER

55 STYLE (Powered Roller Turntable)

76" Dia. powered roller TURNTABLE, Rollers.....
rollers 3.5" dia. on 4.5" centers, all full
length driven. Includes 1/2 hp AC drive,
adjustable speed. Wall tubing 1/8"
(H55/44 only - requires ring gear option)

ORION PACKAGING INC.
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SEMI-AUTOMATIC MACHINE OPTIONS

44 STYLE (Powered Roller Turntable)

76" Dia. Powered Roller TURNTABLE, Rollers.....
3.5" Dia. on 4.5" Centers, All Full Length
Driven. Includes 1/2 hp DC Drive, Adjust-
able Speed. Wall Tubing 3/16", Cast Iron
Pillow Blocks. (NOTE: H55/44 only, requires
RING GEAR OPTION)

55 STYLE (CONTOURED Powered Roller Conveyor)

5' Length CONTOURED Powered Roller Conveyor,.....
3.5" Dia. Rollers on 4.5" Centers, 50"
Effective Width, All Full Length Rollers
Driven. Includes 1/2 hp AC Drive, Non-
Reversing. Wall tubing 1/8"

44 STYLE (CONTOURED Powered Roller Conveyor)

5' Length CONTOURED Powered Roller Conveyor,.....
3.5" Dia. Rollers on 4.5" Centers, 52"
Effective Width, All Full Length Rollers
Driven, Cast Iron Pillow Blocks.
Includes 1/2 hp DC Drive, Variable
Speed, with Soft Start.

Automatic Sequencing, Logic and Photocell.....
For Powered Conveyor (Per Section) - Includes
Photocell PLC Input and Output/Program.

Turntable Mechanical Home Position Lock.....
(Pneumatic, Positive Lock)

ORION PACKAGING INC.
DISTRIBUTOR PRICE LIST - EFFECTIVE NOVEMBER 1, 1989

SEMI-AUTOMATIC MACHINE OPTIONS

FILM CARRIAGE OPTIONS

Double #60 Chain Carriage Lift.....
20" Multistretch Retrofit Carriage.....
(For Installation on Existing Machines)
30" Multistretch Retrofit Carriage.....
(For Installation on Existing Machines)
30" Multistretch Carriage Upgrade from 20".....
on H66/55/44 and L66/55/66.
30" Multistretch Carriage Upgrade from 20".....
on M66/55/44.
30" Econostretch Carriage Upgrade on 77
Series from 20".

ELECTRONIC SCALE PACKAGE OPTION

Includes Heavy Duty Load Cells Incorporated.....
into the Machine or Conveyor Frame, Protected
from Lateral Shock, and a Digital Display of
Load Weight, with RS-232C Port, Gross, Net
Tare, Zero.

NOTE: On L-77 and L-66 models, scale option
reduces machine capacity to 2500 lbs.,
unless base reinforcement option is
ordered.

Base Reinforcement on L-77 or L-66 models,.....
when 4000 lbs capacity is desired with
scale package.

4.1 Tower Parts List

The exploded assembly drawing of the Small Tower is shown on drawing number 200 190. Table 1 has the parts listed in order of part number. Note: the names given to the parts are generic.

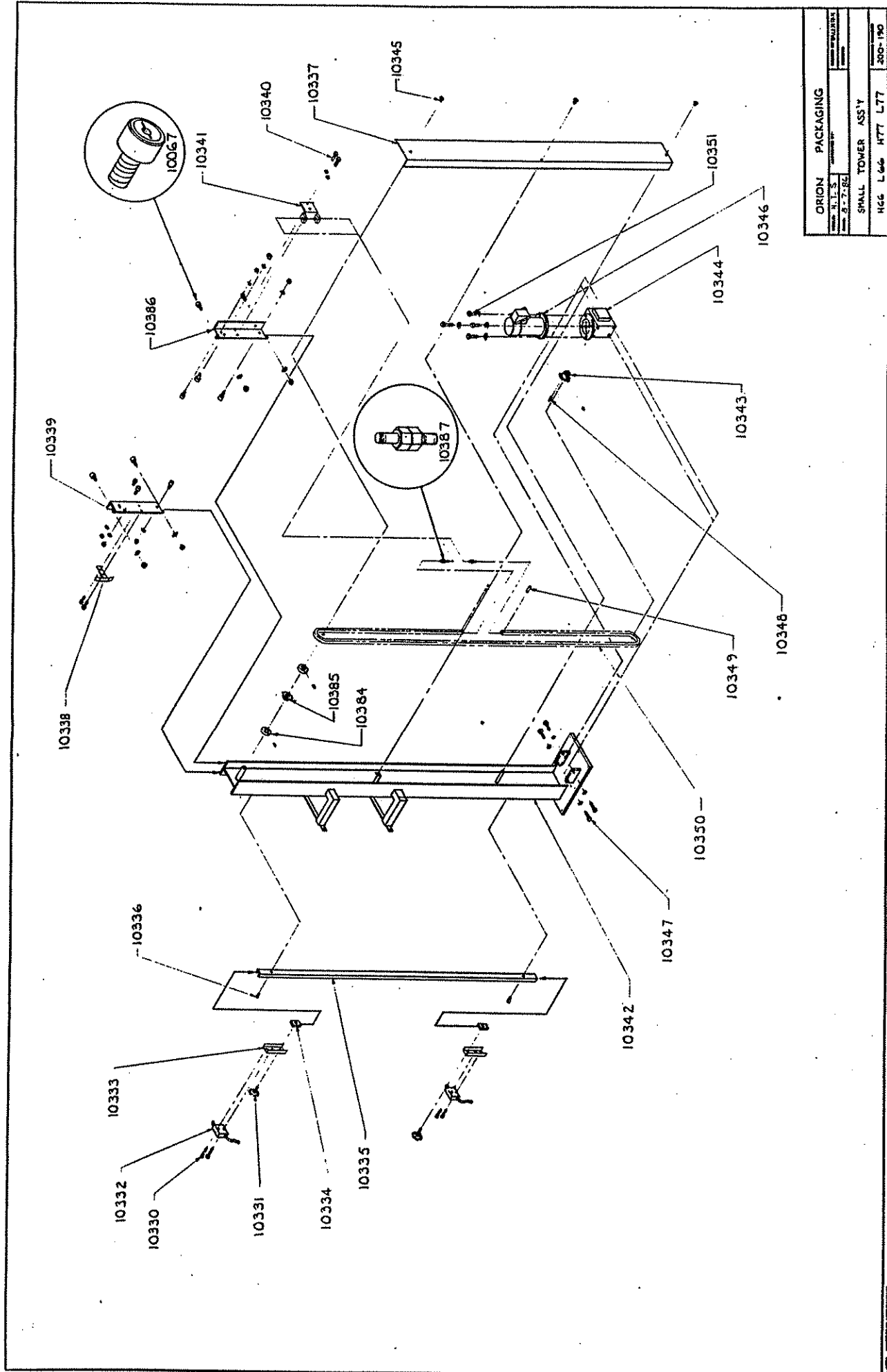
TABLE 1

Tower Parts List

Part Number	Description	Quantity
10067	Cam follower (1/2 inch O.D.)	4
10330	10-24 UNC x 2 long SHCS	2
10331	Knob	2
10332	Limit switch	2
10333	Limit switch bracket	2
10334	Channel guide	2
10335	Channel	1
10336	1/4-20 UNC x 1/2 long SHCS	2
10337	Chain cover	1
10338	Limit switch actuator	1
10339	Right carriage holder	1
10340	3/8-16 UNC x 1 long hex bolt	2
10341	Chain tensioner	1
10342	Tower	1
10343	Elevator driver sprocket	1



10344	Reducer (40:1)	1
10345	1/4-20 UNC x 1/2 long SHCS	3
10346	Motor (1/3 hp, 90 VDC)	1
10347	5/16-18 UNC x 1 long hex bolt	4
10348	3/16 square key	1
10349	Chain link pin	2
10350	Chain	1
10351	3/8-16 UNC x 2 long hex bolt	4
10384	1" collar	2
10385	Elevator idler sprocket	1
10386	Left carriage holder	1
10387	Chain tensioning screw	2



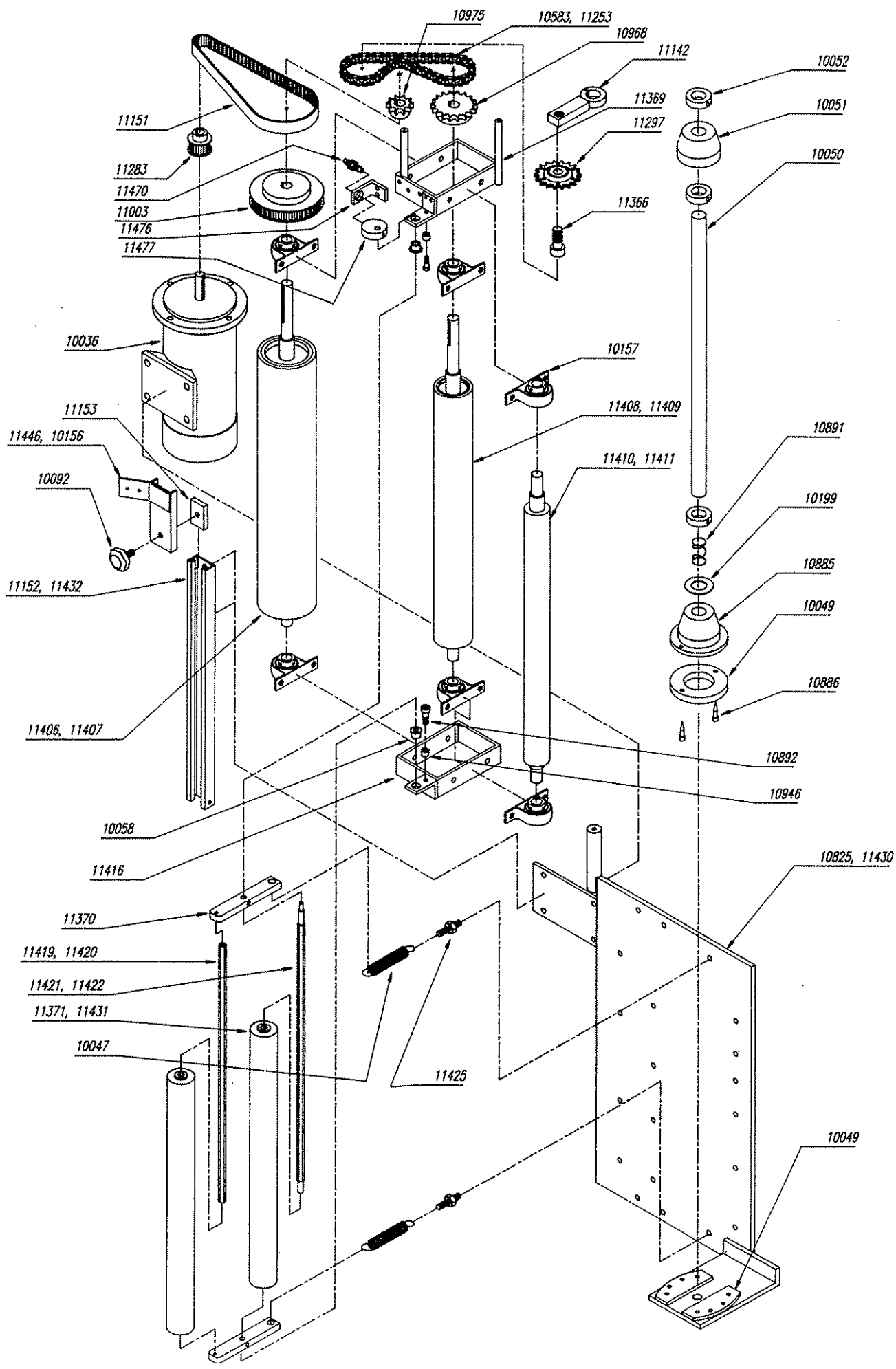
ORION PACKAGING	
Model: 1115	Part No: 1115
Rev: 1.0	Rev: 1.0
SMALL TOWER ASS'Y	
H66 L66 H77 L77	200-150

CARRIAGE PARTS LIST

<u>Orion P/N</u>	<u>Description</u>	<u>Qty</u>
10036	Electric motor 1/2HP, 90 VDC, 1750 RPM	1
10047	Tension spring	2
10049	Brake pads 1/4" thk	2
10049	Brake disk	1
10050	Film spool mandrel for 20" film	1
10051	Mandrel, top	1
10052	Collar 1"	3
10058	Bushing, bronze	2
10156	Photoswitch bracket (left hand)	1
10157	Pillow block assembly 3/4"	6
10199	Washer	1
10583	Chain #40	1
10825	Back plate for 20" film	1
10885	Bottom spool mandrel	1
10886	Spool spike	2
10891	Compression spring	1
10892	Shoulder screw 5/16" dia x 3/8" long	2
10946	Plastic hose	2
10968	Drive sprocket for std - 175%	1
10975	Drive sprocket	1
11003	Pulley	1
11142	Chain tensioner	1
11151	Timing belt	1
11152	Photocell channel for 20" film	1
11153	Channel guide	1
11253	C/L #40	1
11283	Timing belt pulley	1
11297	Sprocket	1
11366	Hex head screw 5/8-18UNF x 1 1/2" long	2
11369	Top bracket	1
11370	Lever	2
11371	Roller 21 1/4" long	2
11406	Rubber roller 4" dia x 21"	1
11407	Rubber roller 4" dia x 31"	1
11408	Rubber roller 2.66" dia x 21"	1
11409	Rubber roller 2.66" dia x 31"	1
11410	Rubber roller 1 3/4" dia x 21"	1
11411	Rubber roller 1 3/4" dia x 31"	1
11416	Bottom bracket standard	1
11419	Roller shaft for 20" film	1
11420	Roller shaft for 30" film	1
11421	Dancer roller for 20" film	1
11422	Dancer roller for 30" film	1
11425	3/8-16UNC threaded rod 2" long	2
11430	Back plate for 30" film	1
11431	Roller 31" long	2
11432	Photocell channel for 30" film	1

CARRIAGE PARTS LIST

<u>Orion P/N</u>	<u>Description</u>	<u>Qty</u>
11446	Photocell bracket (right hand)	1
11470	Proximity sensor	1
11476	Proximity sensor bracket	1
11477	Proximity sensor cam	1





4.3 Base And Turntable Parts List

The exploded assembly drawing of the H66 base is shown on drawing number 200 194. Table 3 has the parts listed in order of part number. Note: the names given to the parts are generic.

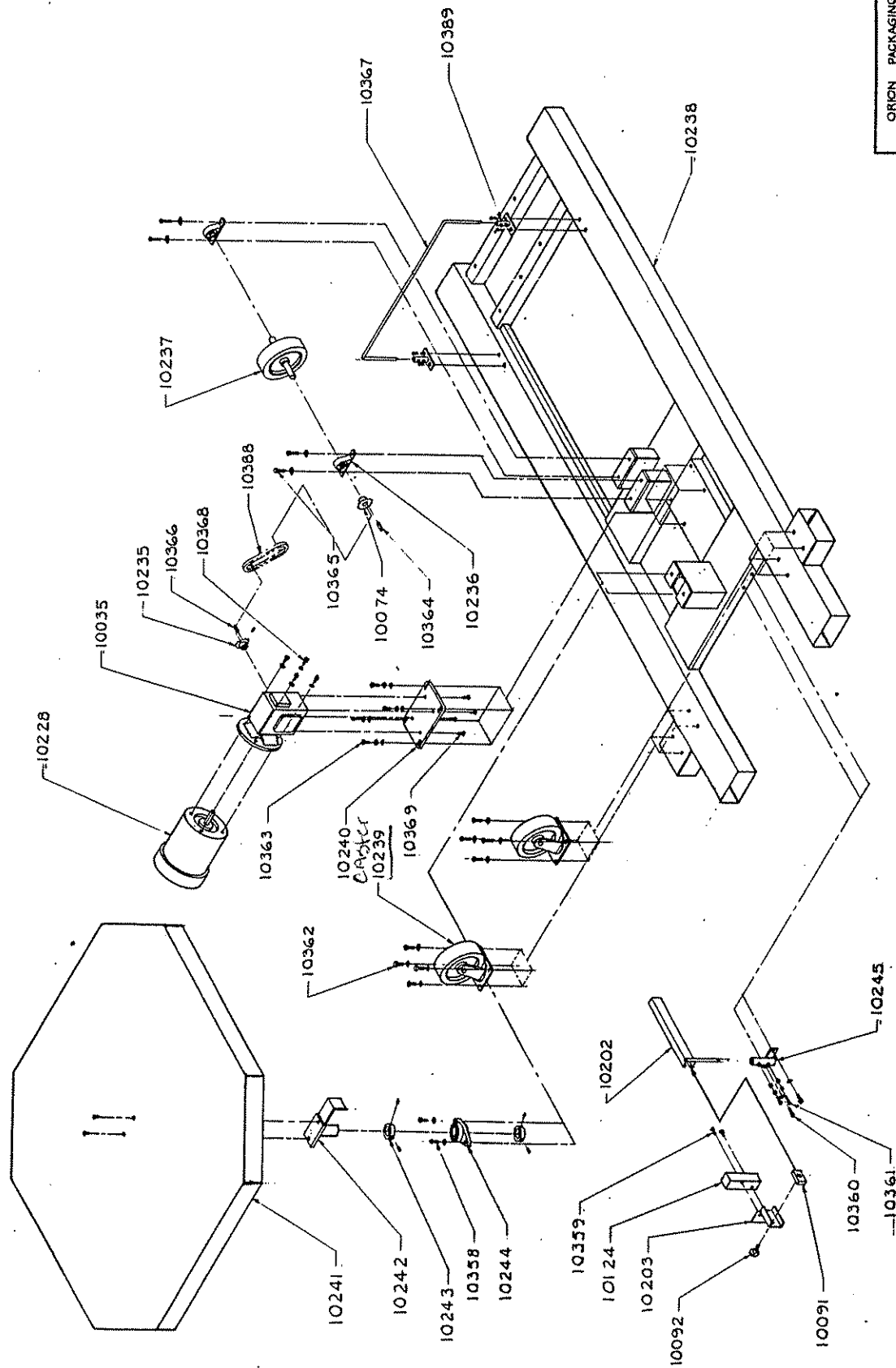
TABLE 3

Base And Turntable Parts List

Part Number	Description	Quantity
10035	Reducer	1
10074	Drive sprocket	1
10091	Channel guide	1
10092	Knob	1
10124	Proximity switch	1
10202	Channel	1
10203	Proximity switch bracket	1
10228	Motor (1/2 hp, TEFC)	1
10235	Driver sprocket	1
10236	1" pillow block bearing	2
10237 402542	Turntable drive wheel	1
10238	Base	1
10239	Caster	2
10240	Reducer mounting plate	1
10241	Turntable	1
10242	Turntable coupling	1
10243	1" collar	2
10244	Center bearing unit	1



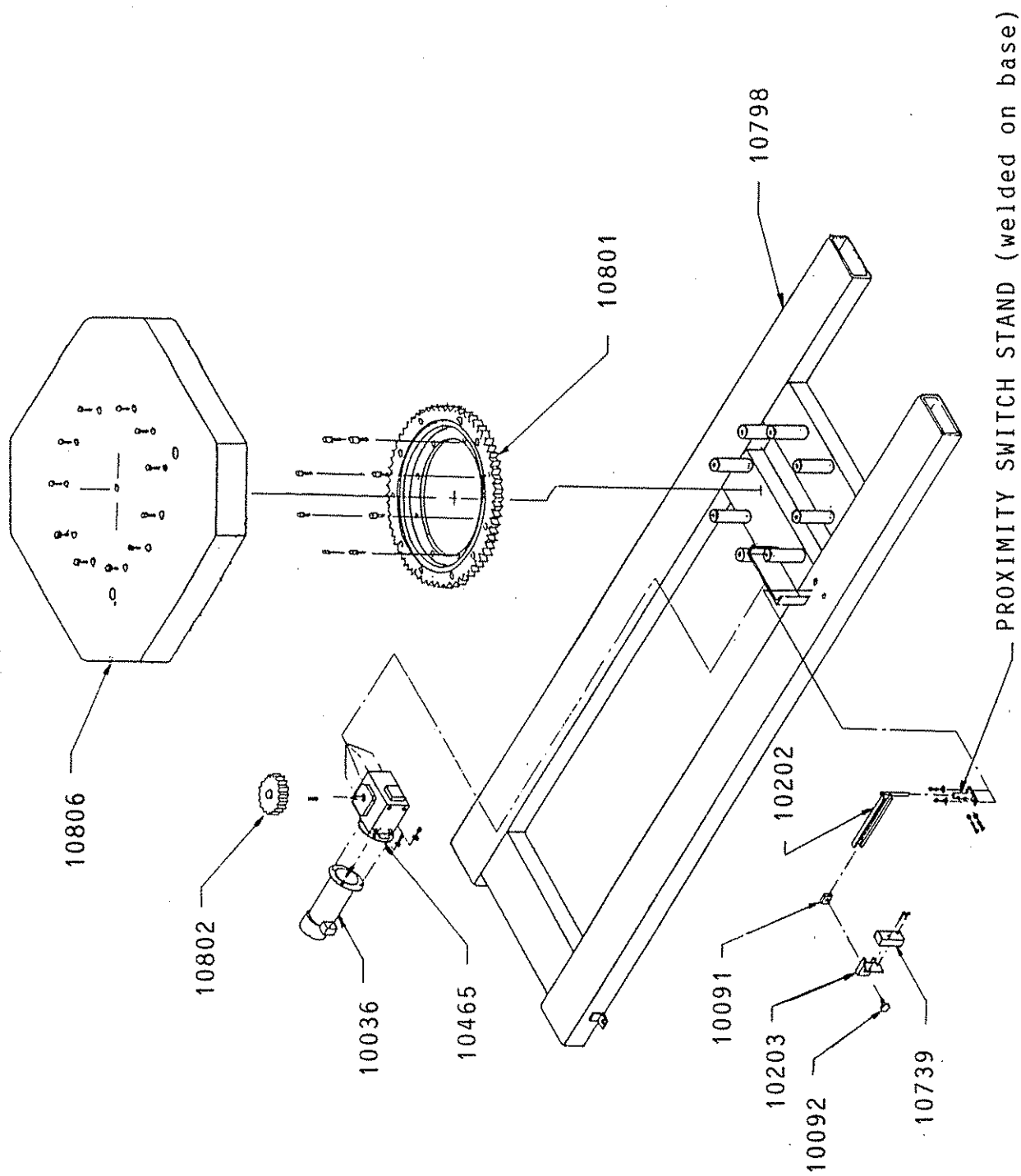
10245	Channel stand	1
10358	3/8-16 UNC x 1 long hex bolt	2
10359	10-24 UNC x 2 long SHCS	2
10360	3/8-16 UNC x 1 long hex bolt	2
10361	3/8-16 UNC x 1 long hex bolt	2
10362	3/8-16 UNC x 1 long hex bolt	4
10363	3/8-16 UNC x 1 long hex bolt	8
10364	3/16 square key	1
10365	3/8-16 UNC x 1 long hex bolt	4
10366	3/16 square key	1
10367	Roping bar	1
10368	3/8-16 UNC x 1 long hex bolt	4
10369	5/16-18 UNC x 3/4 long CHCS	4
10388	Chain	1
10389	Roping bar stand	2



ORION PACKAGING MONTREAL	
Part No.	N.T.S.
Rev.	1.0
Drawn By	10-1-77
SMALL HIGH PROFILE BASE ASSY	
Quantity	456 H77
Material	200 194

ORION PACKAGING INC.
BASE AND TURNTABLE SUBASSEMBLY PARTS LIST
MODEL H66R

ORION P/N	DESCRIPTION	QTY
10036	Motor (1/2 hp, 90vdc, 1750 rpm)	1
10091	Channel Guide	1
10092	Knob	1
10202	Proximity Switch Channel	1
10203	Proximity Switch Holder	1
10465	Reducer (BQ175, 20:1, assy 2)	1
10739	Proximity Switch	1
10798	Base	1
10801	External Ring Gear (20" dia., 99 teeth)	1
10802	Pinion Gear (12 teeth, module 5)	1
10806	Turntable (48"x48" oct. formed, 3/8" steel)	1



BASE AND TURNTABLE SUBASSEMBLY - H66R



5. MACHINE INSPECTION AND INSTALLATION

5.1 Inspection Upon Arrival

CAUTION: When unloading the stretchwrapper, care must be taken not to lift it by the turntable. The forks of the forklift should be inserted in the 6 x 2 inch rectangular tubes at either end of the base to lift the machine.

Before inspection, all packing and restraining blocks must be removed; these may include the blocks under the carriage and the restraining bar over the table.

CAUTION: When cutting the stretchwrap material covering the machine, care must be taken not to cut any of the electrical lines.

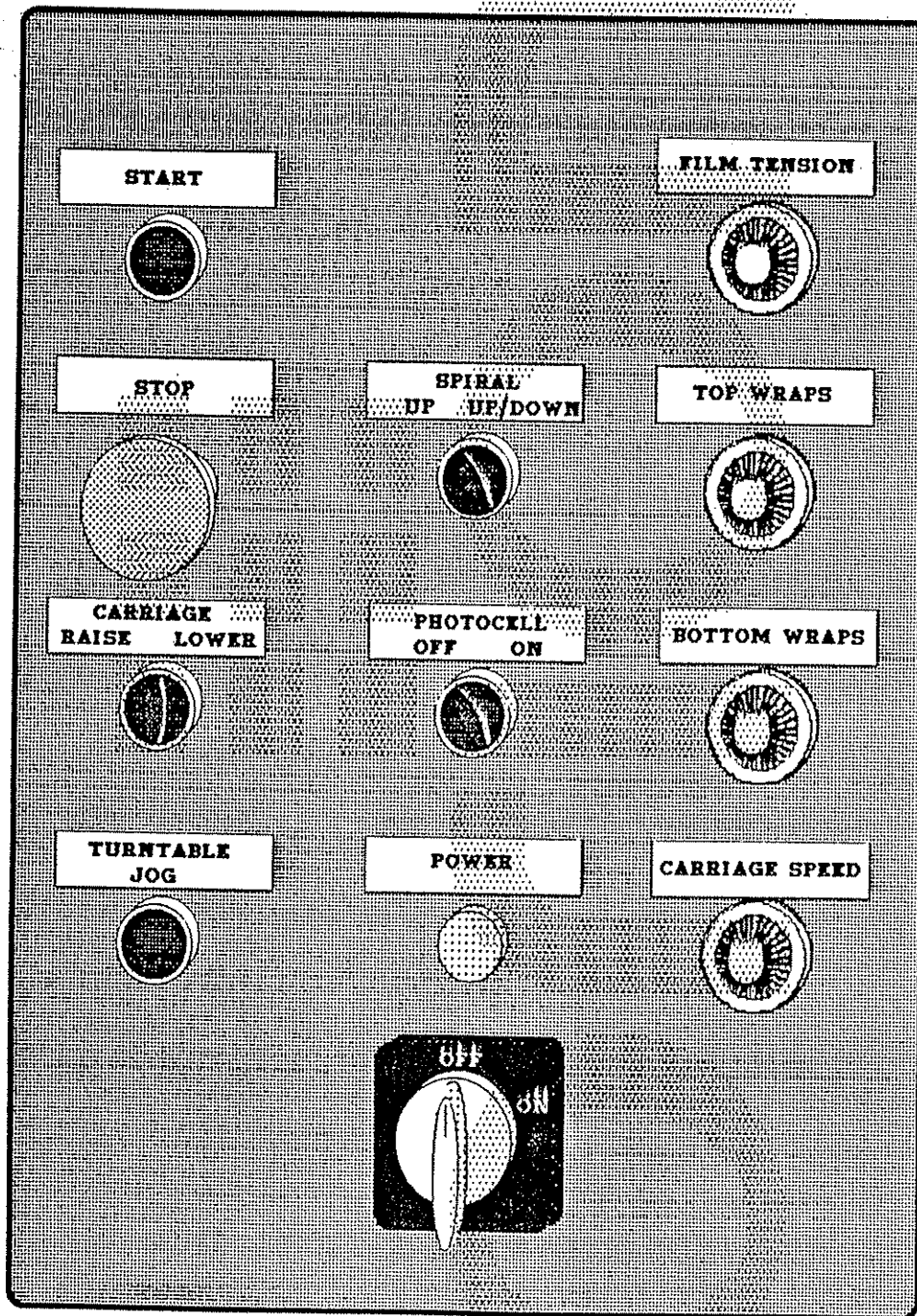
A visual inspection of all the electrical connections should be performed after unpacking the machine to check for loosened joints or broken connections. Any suspected shipping damage must be reported immediately to the freight carrier.

Items that are vulnerable to damage and must be inspected are the motor and transmission housings and connections at the base of the tower, under the turntable, and on the carriage, the photoswitch on the carriage, the carriage holders, and the roping bar and stands.

5.2 Machine Installation

After the visual inspection has been performed, the customer is required to provide the electrical power requirements as outlined in the specifications (sections 1, 2, and 3 of this manual).

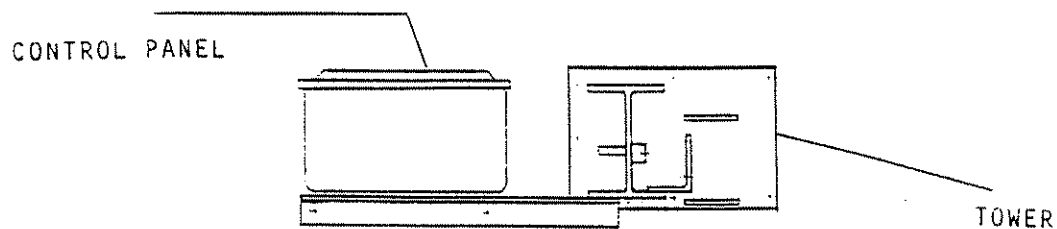
An electrical diagram is provided in the panel box. Only a qualified electrical technician or an Orion representative should effect any repairs on the machines.



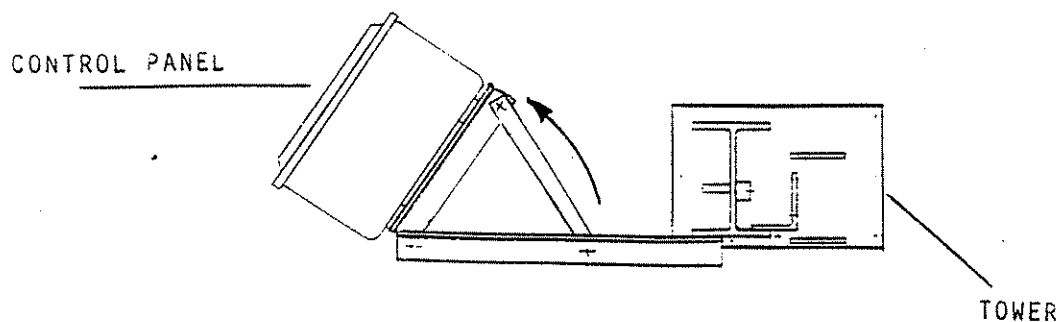
NEW, TWO POSITION CONTROL PANEL MOUNT

In order to facilitate access and manipulation, the Control Panel can be mounted in two positions:

- 1.-On the angle brackets aligned to the Tower.



- 2.-With the position bar (installed between upper angles), Control Panel can be rotated forward/ to the side.
(additional screw attached to the tower's foot).





6.1 Power Switch

The Power Switch has two settings,

ON - Connects a 115 VAC power source to the machine.

OFF - Disconnects the power source.

6.2 Start And Stop Switches

The Start switch is used to start the cycle once the load is on the turntable. The cycle may be stopped at any time by pressing the Stop button.

NOTE: if the Stop button is pressed in the middle of the cycle, the carriage and turntable can be returned back to their home positions by using the jog buttons before restarting the cycle.

6.3 Spiral Wrap Switch

The Spiral Wrap switch has two positions,

UP - In the UP position the cycle will end after completing the specified number of top wraps, therefore, the machine will only wrap the load once, going up.

UP/DOWN - In the UP/DOWN position the cycle is complete after the load is wrapped in both the up and down directions.



6.4 Turntable Jog Switch

The Turntable jog switch is a pushbutton switch that will turn the turntable in a clockwise direction (as viewed from the top) when the switch is held depressed. When the switch is released the turntable will stop.

The Turntable jog switch is inoperative during the wrap cycle.

6.5 Carriage Control Switch

The Carriage Control switch is a monostable three position switch with the following settings,

RAISE - Raises the carriage until the top limit switch on the tower is activated or until the photoswitch senses that the top of the load has been reached.

LOWER - Lowers the carriage until the bottom limit switch on the tower is activated.

The switch is normally in the middle position where the carriage remains stationary. Turning the switch to the RAISE or LOWER position will activate the carriage to move in its respective direction.

6.6 Photocell Switch

The Photocell switch has two settings,

ON - When turned ON, the photocell senses whether or not the carriage has reached the top of the load. The carriage will stop and begin the top wraps sequence once the top of the load is reached. The carriage will always stop at the top of the load regardless of its height. The photocell's position on the track can be adjusted in order to make the carriage pass the top of the load and overlap the top.

OFF - When turned OFF, the photocell is inoperative and the carriage will stop only once the top limit switch has been activated.

7.1 Film Tension

The film tension may be adjusted through the film tension control potentiometer. The pot has a range of tension from 0 to 10, 10 being the highest tension rating. This pot may be adjusted during the cycle.

CAUTION: Light loads may require lower tension settings than heavier loads.

The film tension is controlled through the dancer bar system. Occasionally the feedback potentiometer may need some adjustment. The adjustment of the feedback potentiometer can be performed while there is no film on the carriage. The bottom screw on the potentiometer coupling must first be loosened. Once the screw is loosened the potentiometer shaft must be turned until the prestretch motor just begins to hum but does not rotate, at which point the screw can be tightened. NOTE: the condition in which the motor hums but doesn't turn must be maintained even after the screw is tightened, if not, the adjustment procedure must be repeated.

7.2 Carriage Speed

The carriage speed control can be used to control the amount of overlap the film will have on itself during a wrap.

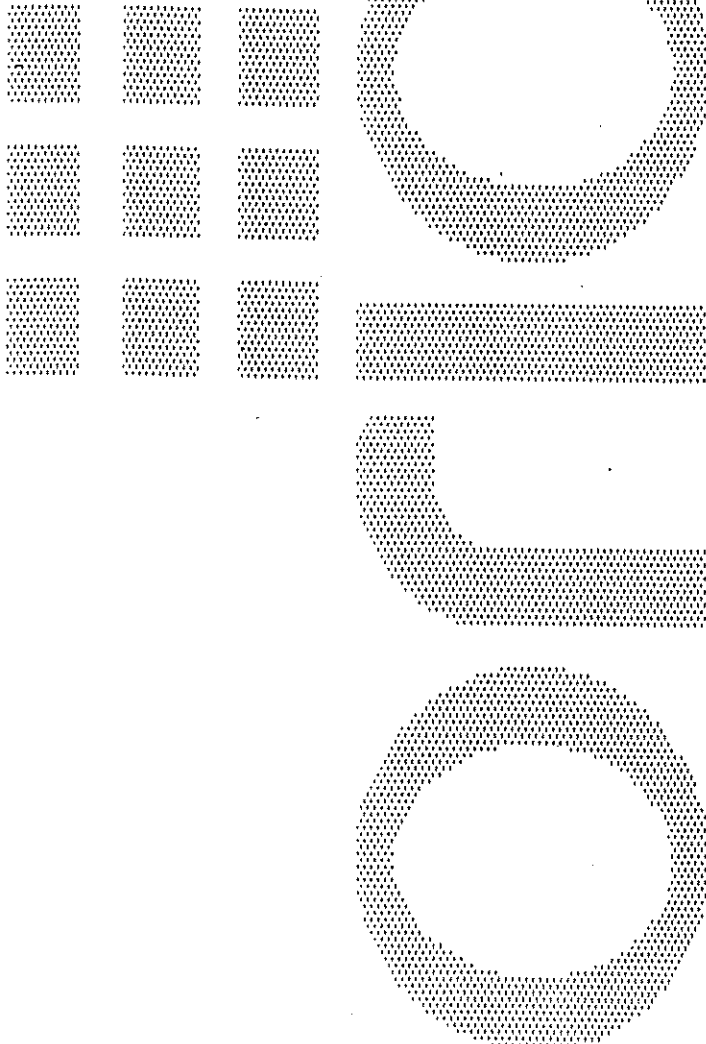
The control potentiometer has settings from 0 to 10, the higher settings being the fastest. High settings will mean less film overlap because of faster carriage speed, and low settings will mean more film overlap because of slower carriage speeds.



7.3 Top And Bottom Wraps

There are two multi-position switches which control the number of wraps that may be put at the top and bottom of the load. Each switch has positions going from 1 to 5 corresponding to the number of wraps which may be applied at the top or bottom of the load.

These switches may be set before the cycle begins.



8.

MACHINE MAINTENANCE

8.1 Speed Reducer Maintenance

On the reducing transmission, after the first week all external cap screws and plugs should be checked for tightness. It is recommended to change the oil every six months or every 2500 hours of operation, whichever comes first. When adding oil the transmission should never be filled above the oil level mark indicated because leakage and overheating may occur. Below is a list of the type of lubricant that should be used.

Manufacturer	Lubricant
American Oil Co.	American Cyl. Oil No. 196-L
Cities Service Oil Co.	Cirgo Cyl. Oil 180-5
Gulf Oil Corp.	Gulf Senata 155
Mobile Oil Corp.	Mobil 600 W Super Cyl. Oil
Phillips Oil Co.	Andes S 180
Texaco Inc.	624-650T Cyl. Oil
Shell Oil Co.	Valvata Oil J82
Union Oil Of Cal.	Red Line Worm Gear Lube 140

Reducing transmissions are found on the carriage, under the turntable, and at the base of the tower.

8.2 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 1/2 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 round, a competent motor shop should disassemble the motor 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.

8.3 Chain Maintenance

To clean and relubricate chains, wipe them with an oily cloth every month. If the environment is very dusty or damp, it may be necessary to clean and relubricate the chains more often.

With time the chains will tend to stretch. A loose elevator chain should be tightened at the chain tensioner as shown on drawing number 200 192. A loose turntable drive chain should be tightened by pulling back on the reducer under the turntable after having its bolts loosened.

8.4 Cam Follower Maintenance

The cam followers behind the carriage have deep grease pockets and do not need frequent relubrication.

The portion of the tower on which the cam followers roll 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.

8.5 Caster Maintenance

The two swivelling casters under the turntable may be relubricated every 300 hours of operation by



injecting a good quality lithium based grease into the grease nipples.

The drive wheel bearings are factory greased and sealed so they need not be relubricated in their lifetime.

8.6 Ring Gear Maintenance

If the stretchwrapper has the optional ring gear turntable drive and support system, this maintenance routine must be performed.

The ring gear is located under the turntable and should be lubricated at fixed intervals. This should be carried out by injecting grease into all the lubrication nipples in succession until a collar of fresh grease appears around the perimeter of both sealing rings. The bearing could be rotated slowly during lubrication.

The relubrication interval depends on the operating conditions. For bearings exposed to an aggressive environment, relubrication should occur every 50 operating hours. Normally, relubrication should occur every 100 to 200 hours of operation. The gear teeth should also be relubricated. Lubricants of different manufacture recommended for the ring gear are shown below.

Manufacturer	Raceway Grease	Gear Teeth Oil
BP	Energrease LS 2	Energol WRL
Castrol	Spheerol AP 2	Grippa 33 S
ESSO	Beacon 2	Surret Fluid 30
Gulf	Crown Grease No. 2	Lubcote No. 2
Mobil	Mobilux 2	Mobiltac E
SHELL	Alvania Grease R 2	Cardium Compound C/Fluid C
Texaco	Glissando FT 2	Crater 2 X Fluid
Valvoline	LB-2	FGC

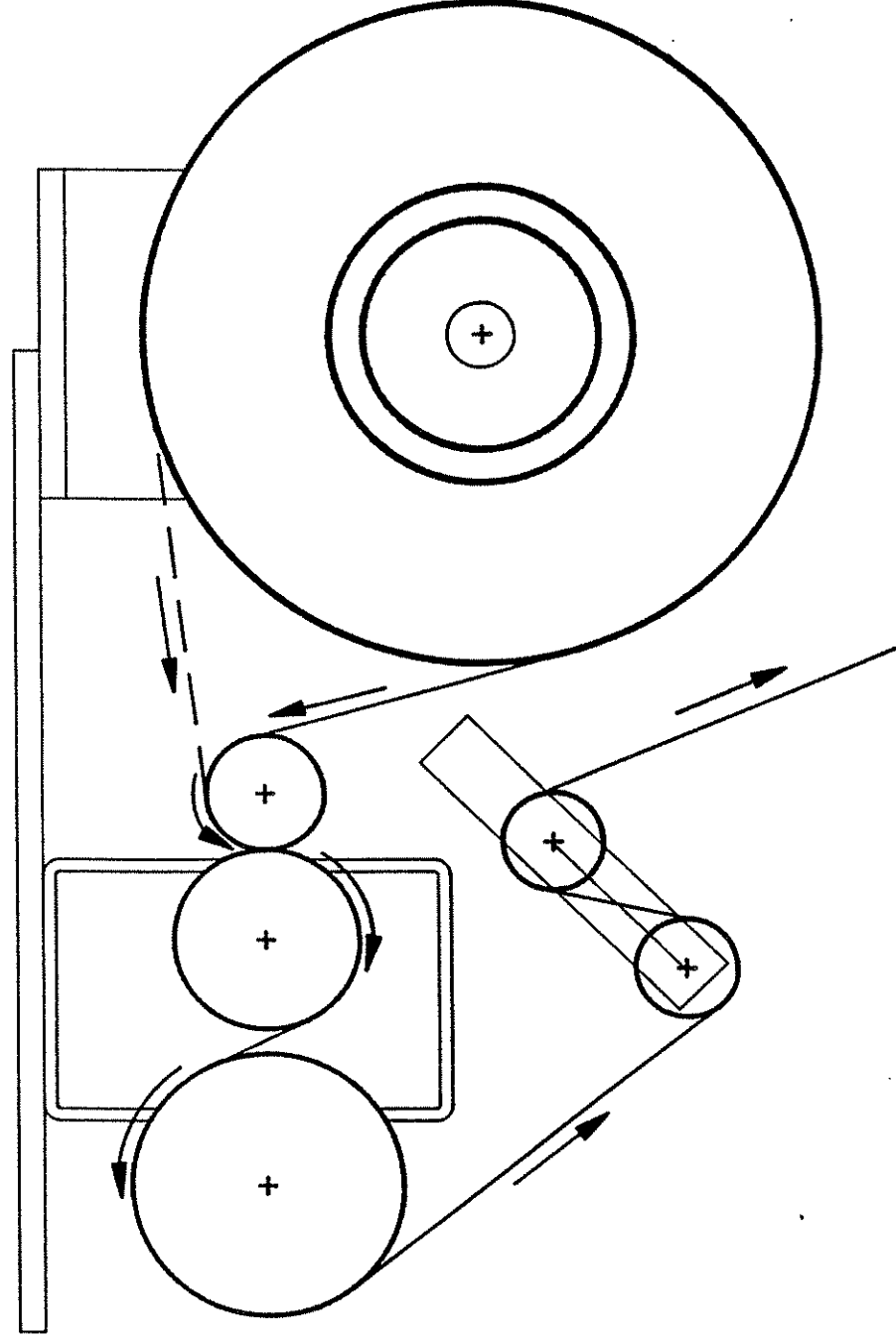
SC CO APPENDIX CO

ORION PACKAGING INC.

NOTICE

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

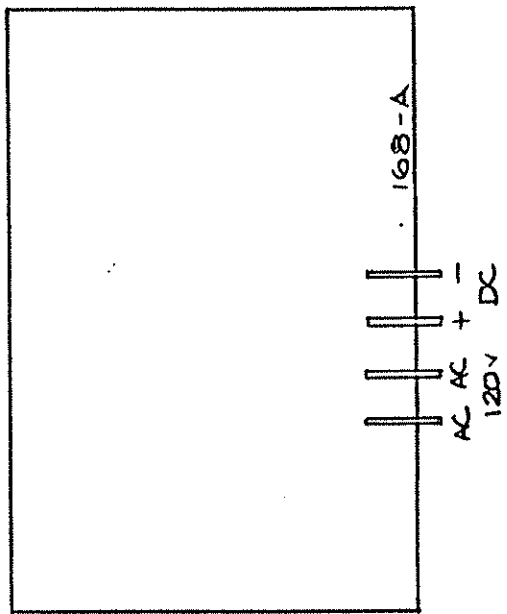
*FILM FEED PATTERN for the
STANDARD CARRIAGE*



WARNING: DISCONNECT POWER BEFORE FEEDING FILM

Electrical Boards' Chart for ORION Stretchwrappers

	168-4	168-A	236	336	750+	750W-240V	850M	850C	155-3A
MLH 44 Processor	X		X		X				
MLH 44	X		X		X				X
MLH 55		X		X			X		X
MLH 66		X		X			X		X
MLH 77		X							X
PA 33	X			X	X				
FA 33	X			X		X		X	
MA 33	X			X		X		X	
MA 44	X			X	X			X	
MA 55	X			X			X	X	



ORION PACKAGING INC

ÉCHELLE: N.T.S.
SCALE:

DATE: 16-9-87

DESSINE PAR: VALENTINI
DRAWN BY:

REVISE PAR:
REVISED BY:

168 - A

NUMERO DE DESSIN
DRAWING NUMBER

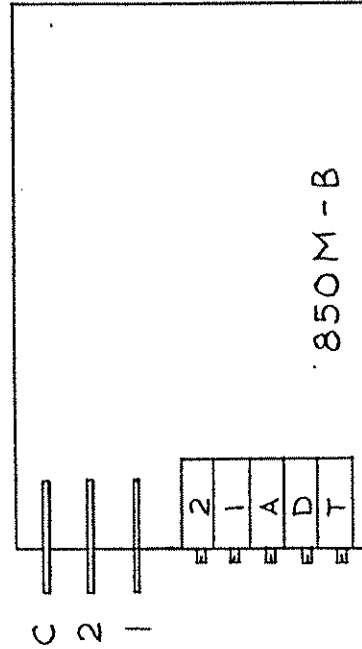
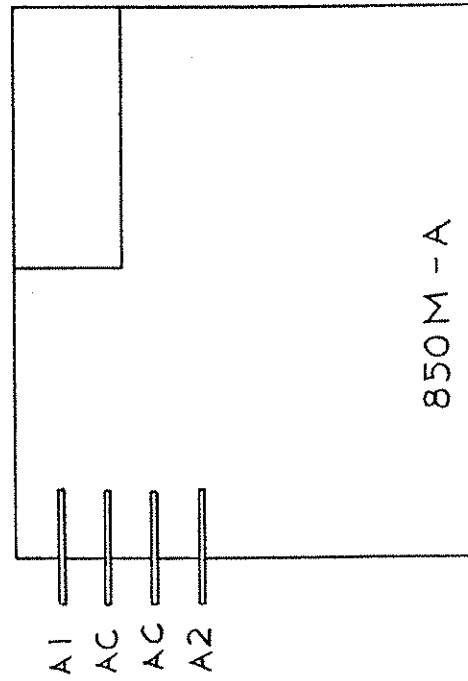
200 891 A

CL		336-3	
+	A	-	C
D	C	D	C

CW W CCW

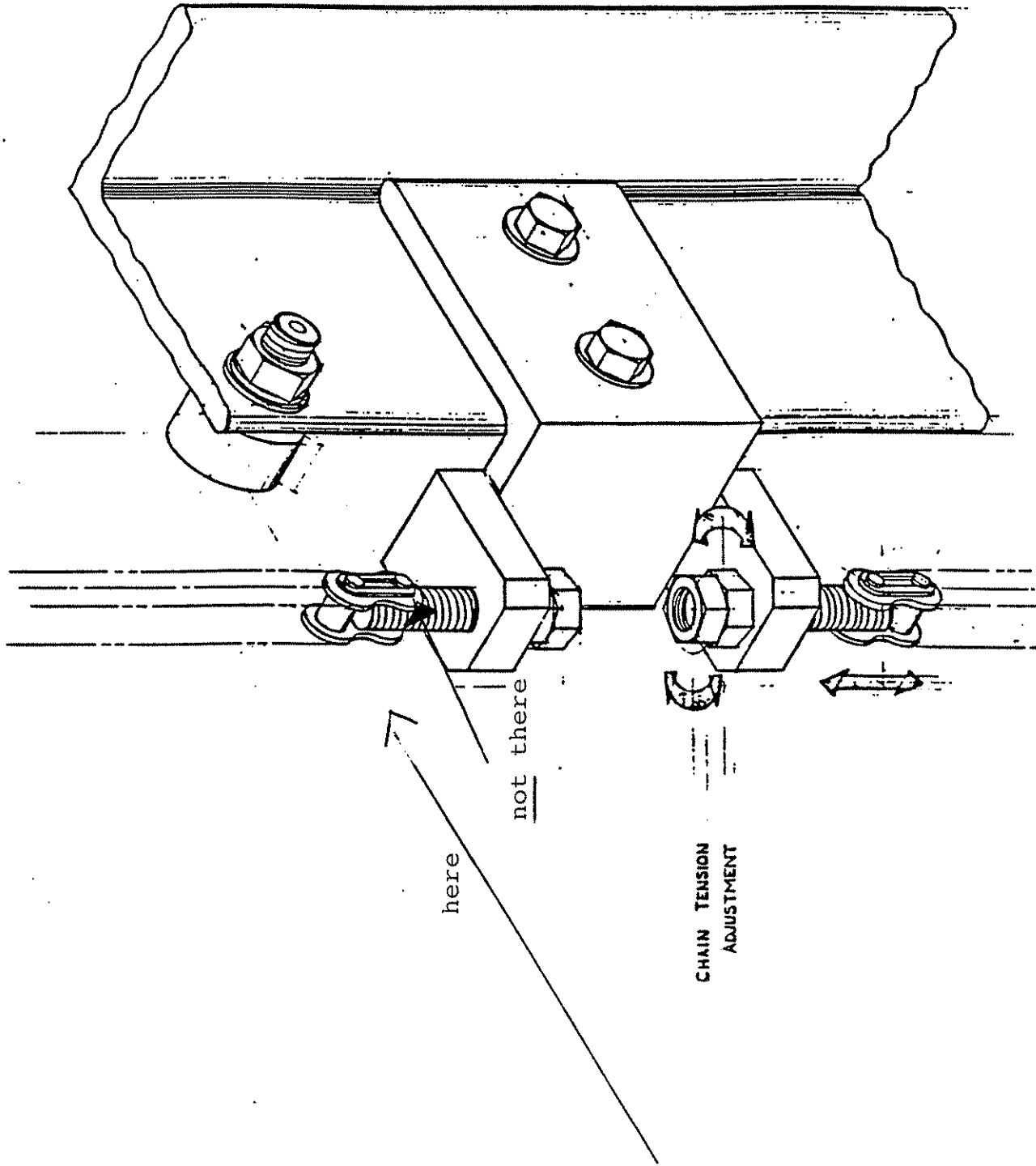
CL : CURRENT LIMITER

ORION PACKAGING INC.			
ECHELLE: N.T.S.	APPROUVE PAR: APPROVED BY:	DESSINE PAR: VALENTINI DRAWN BY:	
DATE: 16-9-87	REVISE PAR: REVISED BY:		
336-3			
		NUMERO DE DESSIN DRAWING NUMBER	
		200 890	



2: LOW SPEED ADJ.
 1: HIGH SPEED ADJ.
 A: ACCELERATION ADJ.
 D: DECELERATION ADJ.
 T: CURRENT LIM.

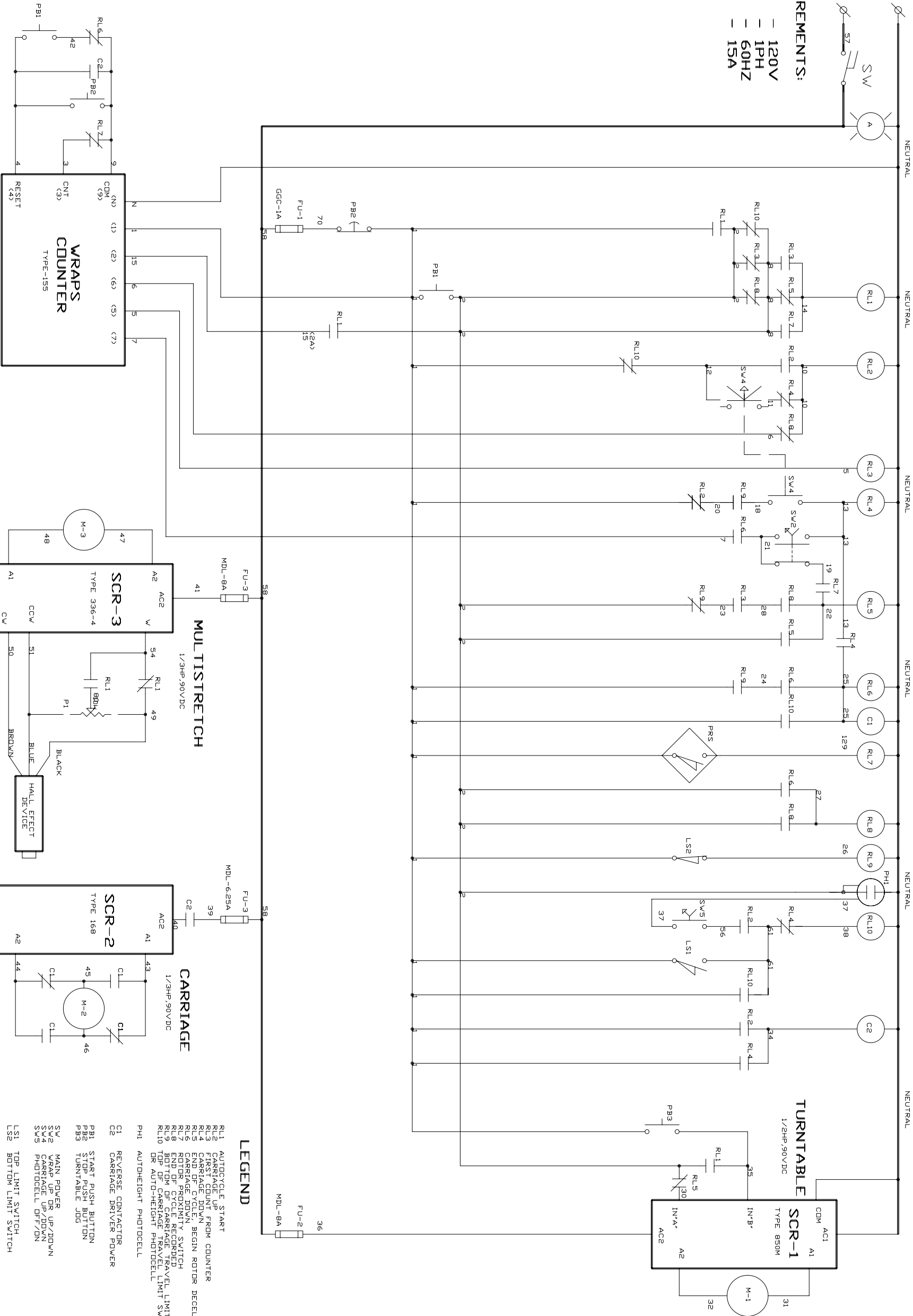
ORION PACKAGING INC.			
ECHELLE: N.T.S. SCALE:	APPROUVE PAR: APPROVED BY:		DESSINE PAR: VALENTINI DRAWN BY:
	DATE: 16-9-87		REVISE PAR: REVISED BY:
850 M			
			NUMERO DE DESSIN DRAWING NUMBER 200 389



Attention!
When mounting the carriage lift chain,
please make sure, that the connecting link's pin
is inserted from the tower side.

ORION PACKAGING			
made in T.S.		approved by	checked by
date 10 - 7 - 86			
CHAIN TENSIONER ASS'Y			
			checked by

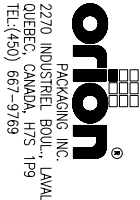
- REQUIREMENTS:
- 120V
 - 1PH
 - 60HZ
 - 15A



LEGEND

- RL1 AUTOCYCLE START
- RL2 CARRIAGE UP FROM COUNTER
- RL3 CARRIAGE DOWN
- RL4 CARRIAGE DOWN
- RL5 END OF CYCLE, BEGIN ROTOR DECELERATION
- RL6 CARRIAGE DOWN
- RL7 END OF CYCLE, BEGIN ROTOR DECELERATION
- RL8 CARRIAGE DOWN
- RL9 BOTTOM OF CARRIAGE TRAVEL LIMIT SWITCH
- RL10 TOP OF CARRIAGE TRAVEL LIMIT SWITCH
- PH1 AUTO-HEIGHT PHOTOCELL
- C1 REVERSE CONTACTOR
- C2 CARRIAGE DRIVER POWER
- PB1 START PUSH BUTTON
- PB2 STOP PUSH BUTTON
- PB3 TURNABLE JOG
- SV/ MAIN POWER
- SV2 WRAP UP OR UP/DOWN
- SV4 CARRIAGE UP/DOWN
- SVS PHOTOCELL OFF/DN
- LS1 TOP LIMIT SWITCH
- LS2 BOTTOM LIMIT SWITCH
- PRS PROXIMITY SWITCH

ORION PACKAGING INC.



2270 INDUSTRIEL BLD. LAVAL, QUE. CANADA H7S 1P9
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QUEBEC, CANADA, H7S 1P9
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