



ATTENTION: ♦

VERY IMPORTANT

Before unloading and unpacking the machine, read 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 INC.

L55
Owner's Manual

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

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

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

002044

ORION MODEL L-55

Spiral Semi-Automatic Heavy Duty Low Profile

Maximum Load Size 56"W x 56"L x 82"H (Recommended)
62"W x 62"L x 86"H (Theoretical)*

Weight Capacity 6,000 lbs. dynamic, 30,000 lbs. static

Utilities 115/1/60 20 Amp Electrical Service

Turntable 60" Diameter 3/8" Steel Plate
12 Cam Follower Support System
Self Lubricating System with Reservoir
3-7/8" Height Floor to Top of Turntable

Turntable Drive 0-12 RPM Variable Turntable Speed
1/2 HP DC Drive Motor
#50 Roller Chain Drive with Tensioner
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
1/2 HP DC/SCR Film Drive

Film Carriage Drive #50 Roller Chain Carriage Lift
1/2 HP Elevator Drive Motor
Variable Speed SCR Control
Precision Cam Follower Tracking

Structural Features Forklift Portable Base Design
Unique Steel Ring Cam Follower Support
Steel Protection Ring Surrounding Table
All Structural Steel Construction
Film Roping Bar
8" x 31 lb./ft. "H" Channel Mast

Est. Shipping Weight 1,500 lbs.

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

HINGED TOWER (FOR TRANSPORT)

All Series (Except "M")

ORION PACKAGING INC.

DISTRIBUTOR PRICE LIST - EFFECTIVE NOVEMBER 1, 1989

SEMI-AUTOMATIC MACHINE OPTIONS

AUTO-HEIGHT PHOTOCCELL

77 series.....

LOADING RAMPS FOR LOW PROFILES

L77/66.....

L55S/44S.....

L55/44.....

L66-72.....

MACHINE BASE EXTENSIONS (MAX. 3 FT)

H77/66 (per foot).....

L77/66 (per foot).....

H55/44 (per foot).....

L55/44 (per foot).....

L55S/44S (per foot).....

MACHINE MAST EXTENSIONS (MAX. 3 FT)

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

(each additional foot).....

M77/67/66 (per foot).....

M57/55 (per foot).....

M44 (per foot).....

HINGED TOWER (FOR TRANSPORT IN LOW TRUCKS)

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, 3/8"

60" dia. round, 1/2"

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

SEMI-AUTOMATIC MACHINE OPTIONS

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.
DISTRIBUTOR PRICE LIST - EFFECTIVE NOVEMBER 1, 1989

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 Standard Tower is shown on drawing number 200 99. Table 1 has the parts listed in order of part number. Note: the names given to the parts are generic.

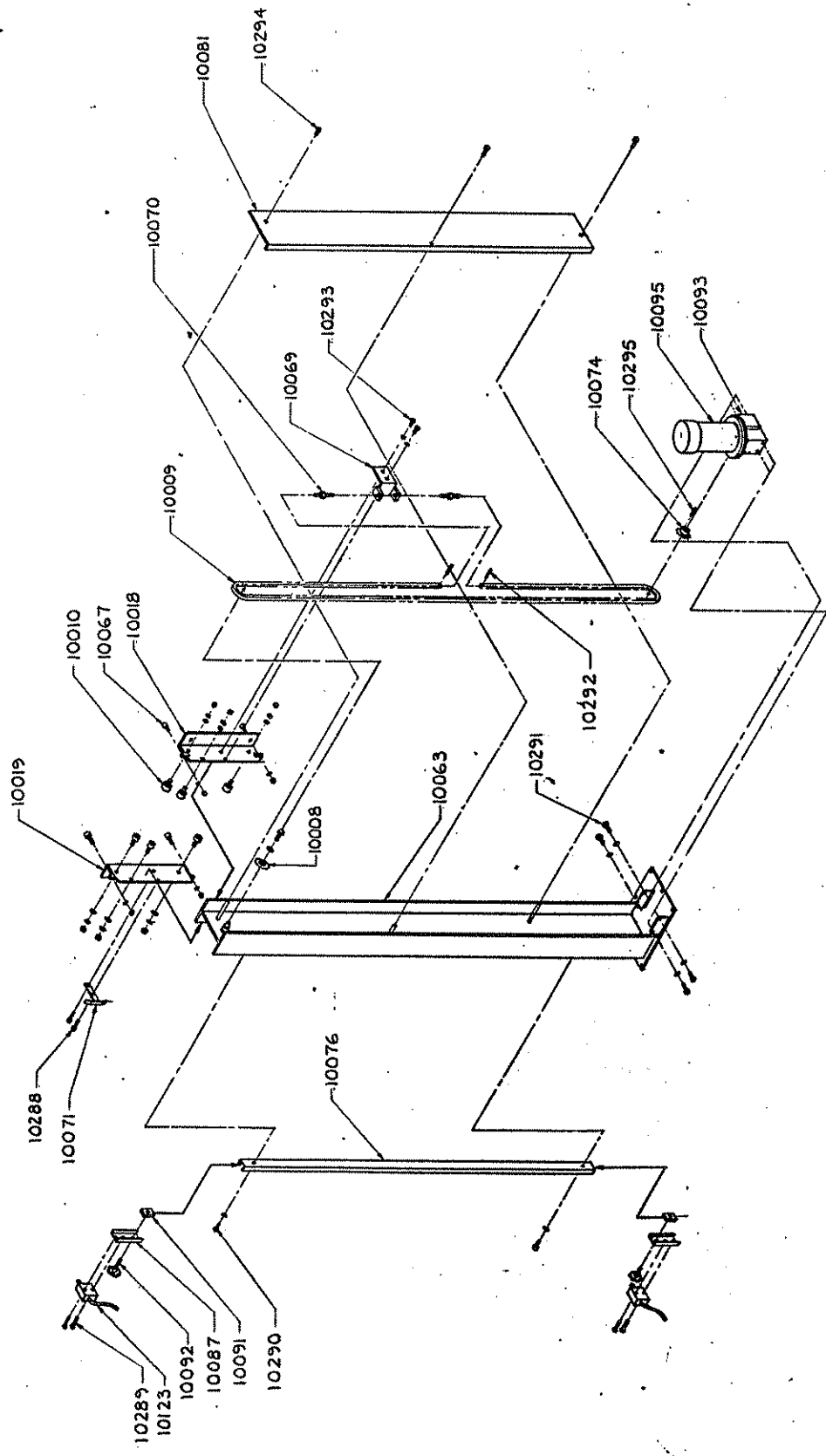
TABLE 1

Tower Parts List

Part Number	Description	Quantity
10008	Idler sprocket	1
10009	#50 chain	1
10010	Cam follower (1 3/8 inch O.D.)	6
10018	Left carriage holder	1
10019	Right carriage holder	1
10063	Tower	1
10067	Cam follower (1/2 inch O.D.)	4
10069	Chain tensioner	1
10070	Chain tensioning screw	2
10071	Limit switch actuator	1
10074	Drive sprocket	1
10076	Limit switch channel	1
10081	Chain cover	1
10087	Limit switch bracket	3
10091	Channel guide	3



10092	Knob	3
10093	Reducer	1
10095	Elevator motor (1/2 hp, 1750 rpm)	1
10123	Limit switch	3
10288	1/4-20 UNC x 1/2 SHCS	2
10289	Limit switch screw	6
10290	Channel screw (1/4-20 UNC x 1/2 SHCS)	2
10291	Transmission screw (3/8-16 UNC x 1 Hex bolt)	4
10292	Chain tensioner pin	2
10293	3/8-16 UNC x 3/4 Hex bolt	2
10294	Cover screw (1/4-20 UNC x 1/2 SHCS)	3
10295	3/16 inch square key	1

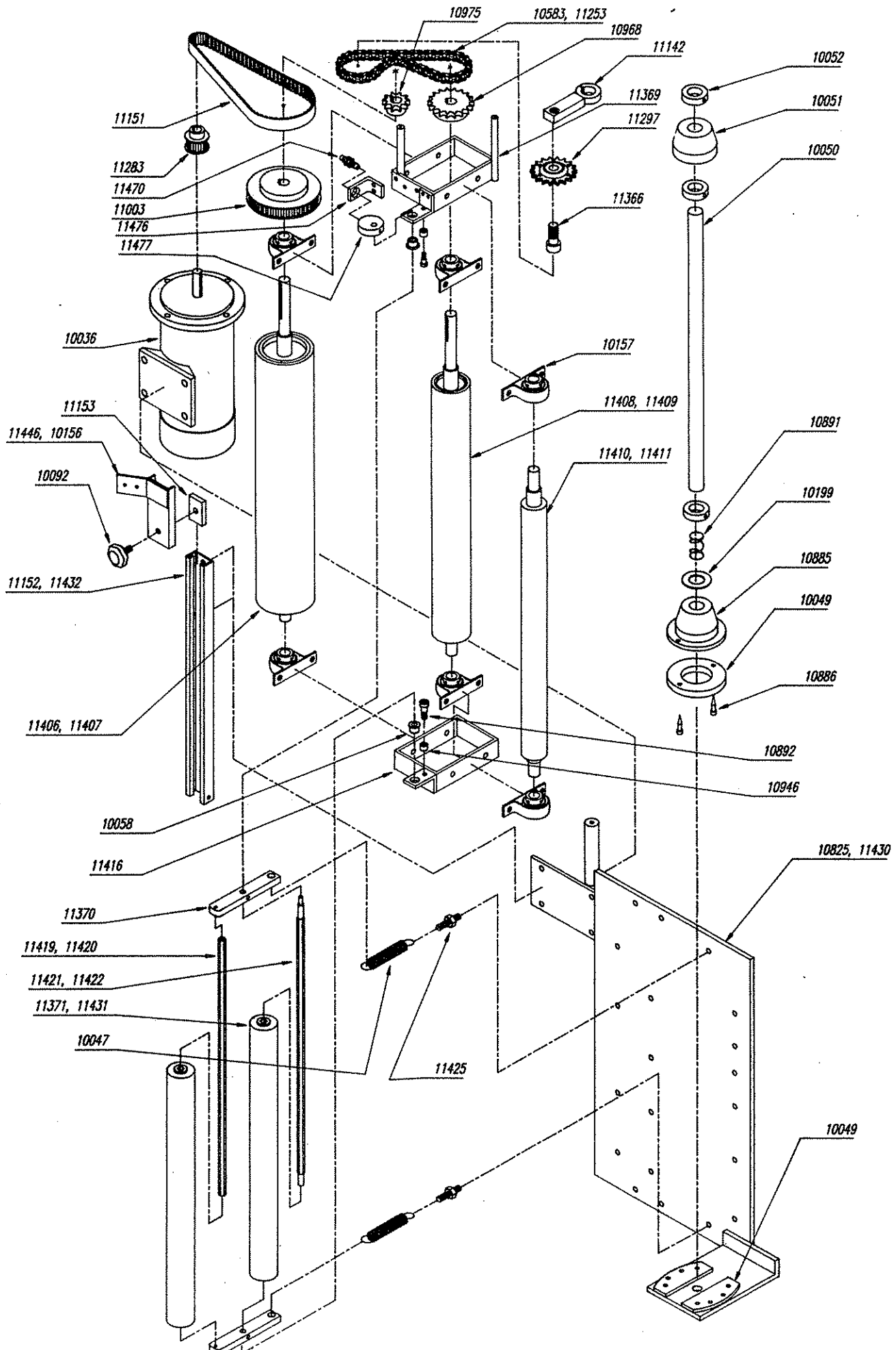


CARRIAGE PARTS LIST

<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 Standard, Low Profile base is shown on drawing number 200 98. Table 3 has the parts listed in order of part number. Note: the names given to the parts are generic.

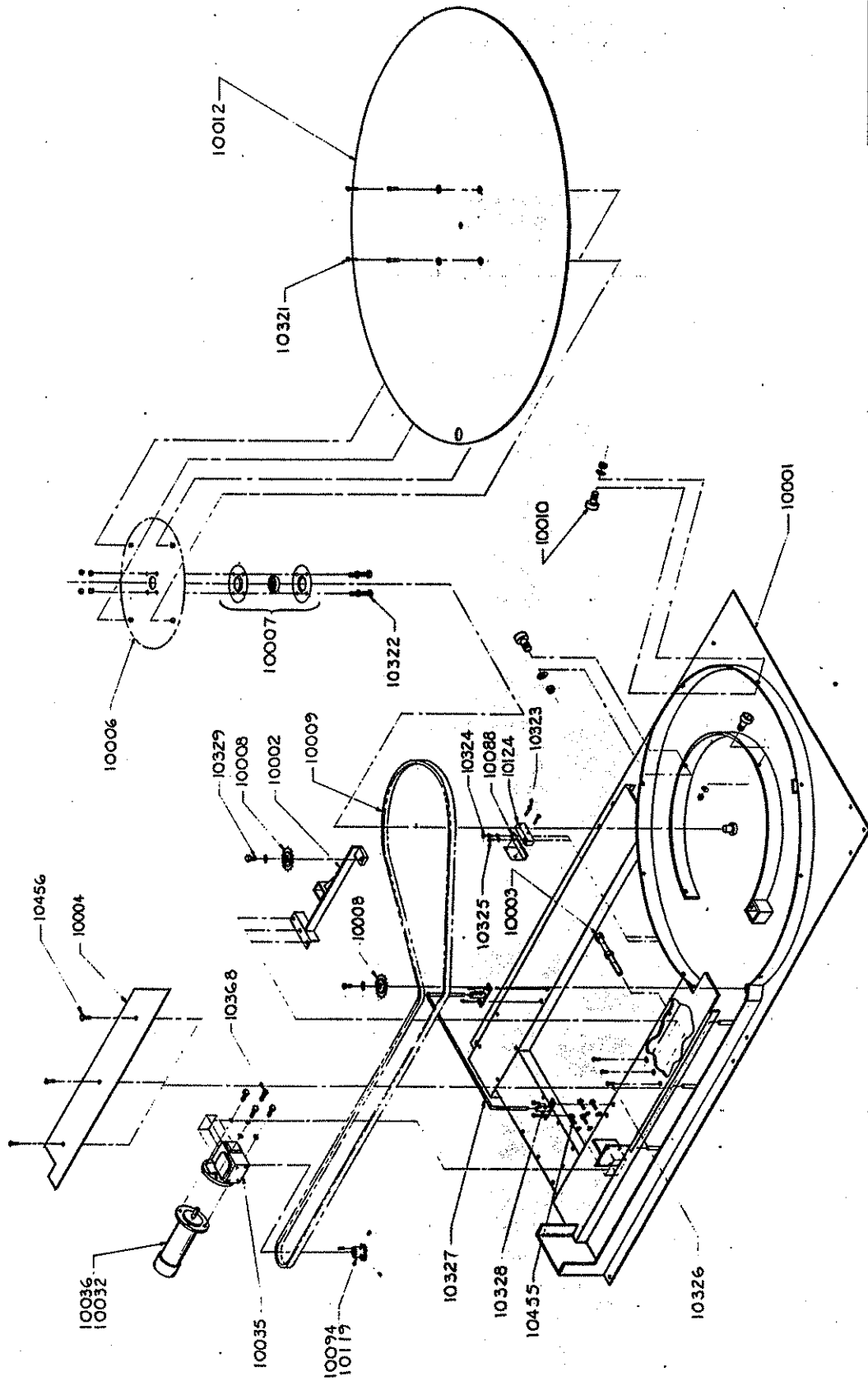
TABLE 3
Base And Turntable Parts List

Part Number	Description	Quantity
10001	Base	1
10002	Chain tensioner	1
10003	Tensioning screw	1
10004	Chain cover	1
10006	Turntable sprocket	1
10007	Center bearing unit	1
10008	Idler sprocket	2
10009	#50 chain	1
10010	Cam follower	12
10012	Turntable	1
10032	3/4 hp motor (44)	1
10035	Reducer	1
10036	1/2 hp motor (55)	1
10088	Proximity switch bracket	1
10124	Proximity switch	1
10094	Driver sprocket (44)	1
10119	Driver sprocket (55)	1
10321	3/8-16 UNC x 1 1/2 long SHCS	4



10322	3/8-16 UNC x 1 1/2 long hex bolts	4
10323	Proximity switch screw	2
10324	3/8-16 UNC x 1 1/2 long hex bolt	1
10325	3/8-16 UNC x 1 1/2 long hex bolt	1
10326	3/8-16 UNC x 1 long CHCS	3
10327	Roping bar	1
10328	Roping bar stand	2
10329	5/8-11 UNC x 1 1/2 long hex bolt	2
10368	3/8-16 UNC x 1 long hex bolt	4
10455	5/16-18 UNC x 1 long hex bolt	4
10456	10-24 UNC x 1 long CHCS	3





ORION PACKAGING MONTREAL	
REV. 1	REV. 1
DATE 03-14-82	DATE 03-14-82
BY 100000	BY 100000
CHKD 100000	CHKD 100000
APPD 100000	APPD 100000
STD. LOW PROFILE BASE ASSY	STD. LOW PROFILE BASE ASSY
L44 L-82	L44 L-82
320-70	320-70

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 10 inch slots behind the tower 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 bolts holding the ramp on the turntable.

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.

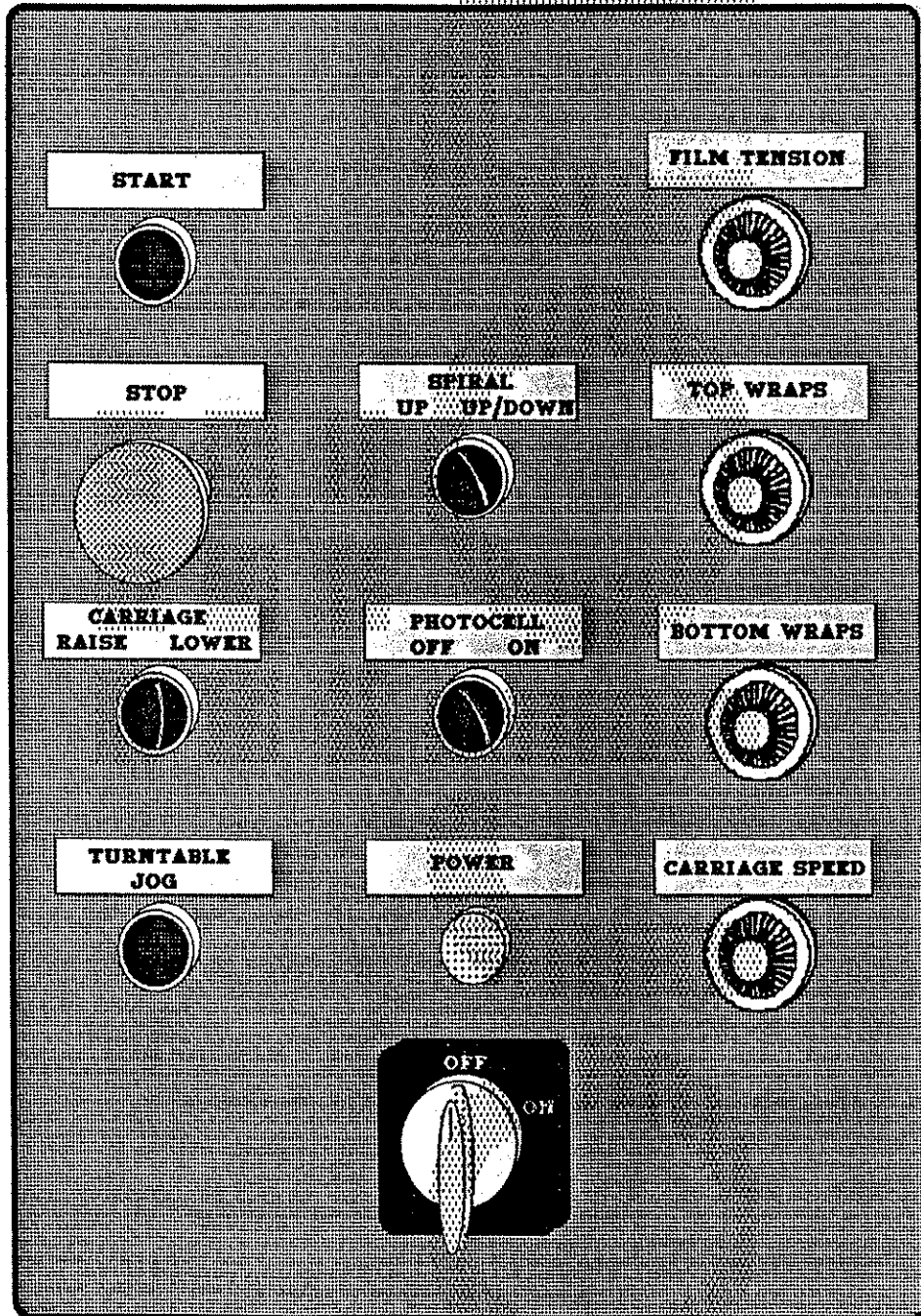
Items that are vulnerable to damage and must be inspected are the motor and transmission housings and connections at the base of the tower, and on the carriage, the photoswitch on the carriage, and the roping bar and stands.

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.

Before operating the machine the oil pockets underneath the table should be checked and filled if any oil is missing.



6.1 Power Switch

The Power Switch has two settings,

ON - Connects a 110 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. At this point 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 must be returned back to their home positions 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

This switch is a pushbutton switch that rotates the turntable clockwise (as viewed from the top) when held depressed. When the switch is released the turntable will stop turning.

6.5 Carriage Control Switch

The Carriage Control switch is a three position switch with a bistable action and has 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 directions.

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 photoswitch'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 presetch 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

There are two carriage speed controls on the panel,

CARRIAGE SPEED UP,

CARRIAGE SPEED DOWN.

The carriage speed controls can be used to control the amount of overlap the film will have on itself during a wrap. It is recommended to start with a RAPID upward wrap in order to stabilize the load early in the cycle.

The control potentiometers have 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 lower 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 10 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.

7.4 Turntable Speed Adjustments

The turntable speed may be changed by adjusting the controls on the 750 or 850 board inside the panel. The controls on the board regulate the steady-state speed, the jog speed, and the acceleration and deceleration of the turntable. The controls are labeled on the board and listed below:

ZERO - The zero adjustment controls the deadband voltage for the turntable motor; it should be adjusted so that the motor just begins to hum but does not turn.

PRESET 1 - The preset 1 controls the working speed of the turntable.

PRESET 2 - The preset 2 controls the jog speed of the turntable.

DN - The DN adjustment regulates the rate of deceleration of the turntable for when it reaches the end

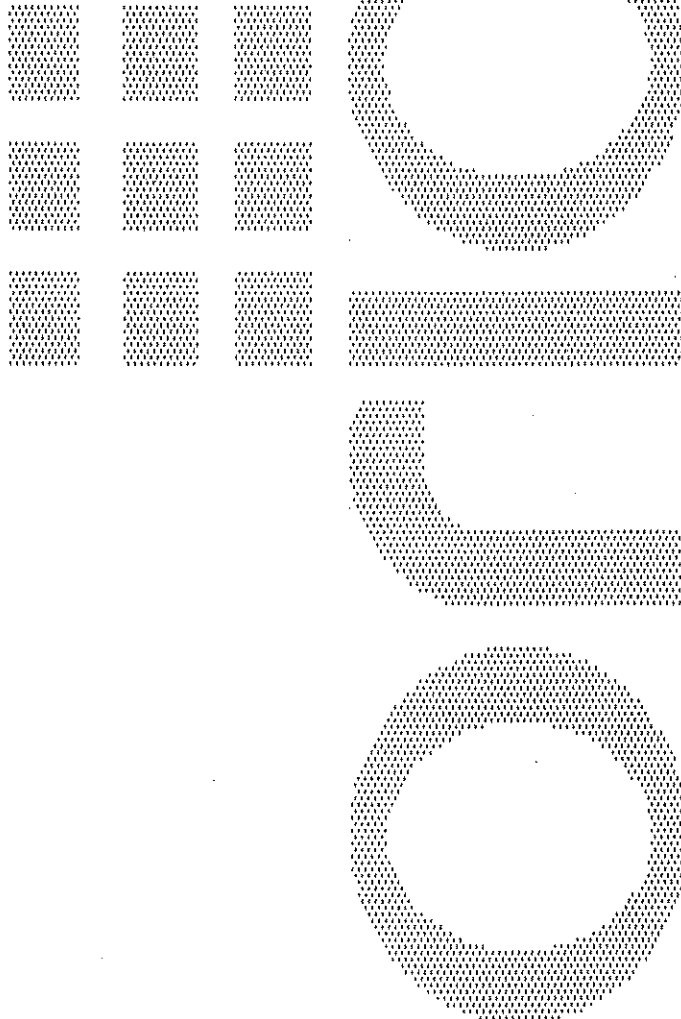


of the cycle.

UP - The UP adjustment regulates the rate of acceleration of the turntable for the beginning of the cycle.

IRC - The IRC needs only adjustment if there is a very large range of load weight; for most applications it will not need to be adjusted but if adjustment is necessary, contact your Orion representative.

CL - The CL is factory set and needs no further adjustment.



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.	Cities Cyl. Oil 180-5
Gulf Oil Corp.	Gulf Senate 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.	Velvata Oil J82
Union Oil Of Cal.	Red Line Worm Gear Lube 140

Reducing transmissions are found on the carriage, 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. Replace-



ment 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 tightening the 1" dia. screw on the base, next to the turntable.

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.

The cam followers under the turntable are wet with oil in order to keep the track properly lubricated. The oil pockets should be refilled every 200 hours of operation. The two oil pockets are found on the base, underneath the table.



8.5 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	Gearteeth Oil
BP	Energrease LS 2	Energol WRL
Castrol	Spherol 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	ECC

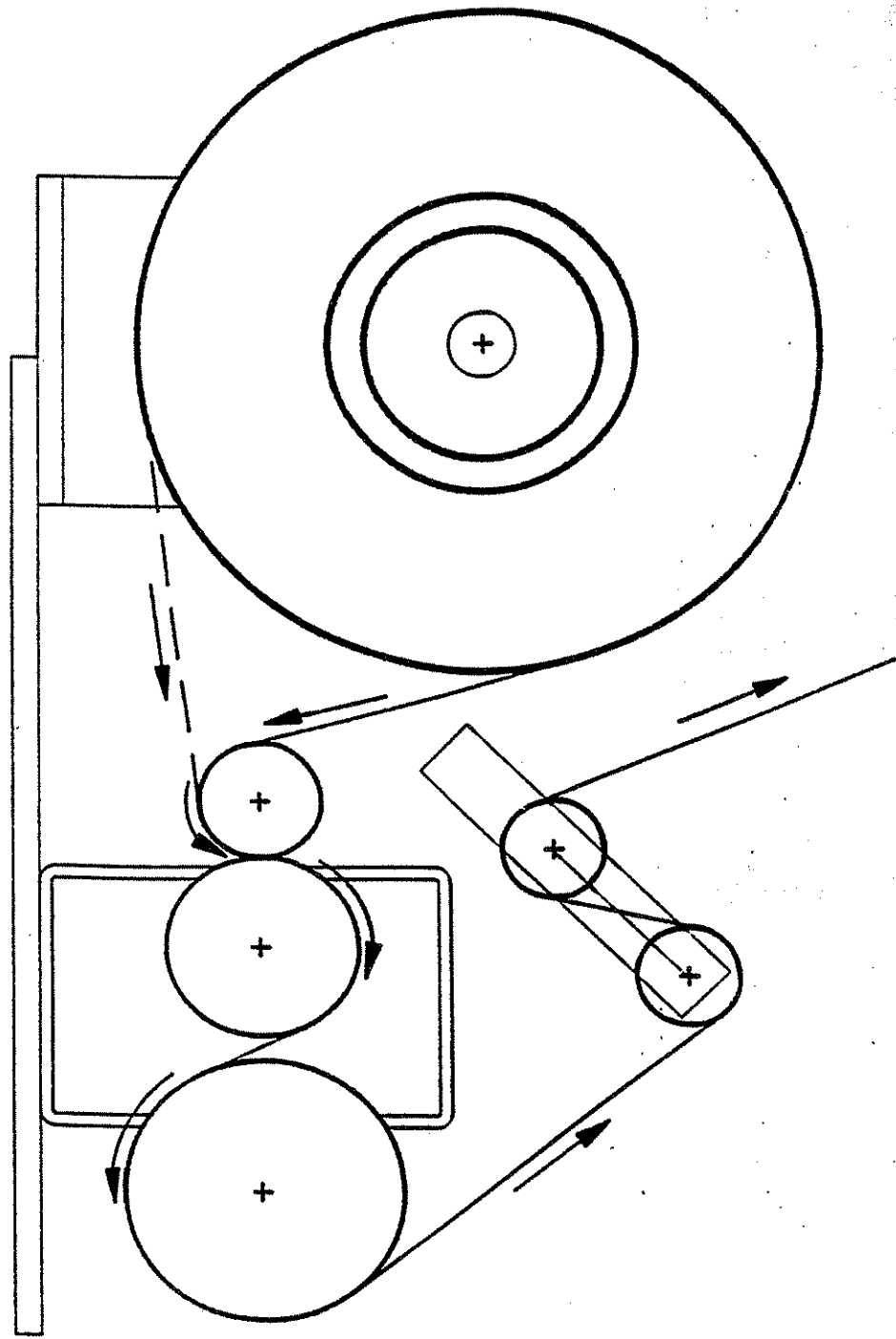
APPENDIX
C
O

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.

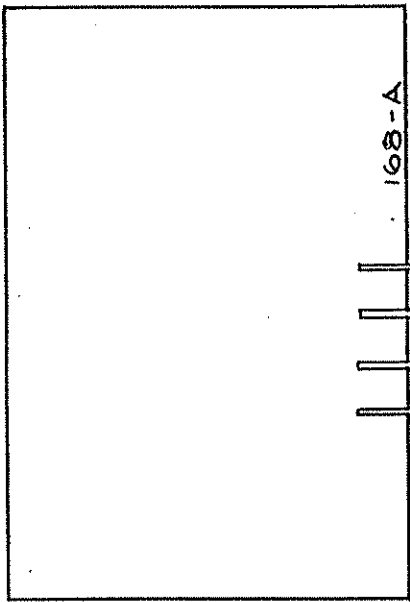
FILM FEED PATTERN for the
STANDARD CARRIAGE



WARNING: DISCONNECT POWER BEFORE FEEDING FILM

Electrical Boards' Chart for ORION Stretchwrappers

	168-4	168-A	236	336	750+	750M-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	



168-A
AC AC + -
120V DC

ORION PACKAGING INC

ÉCHELLE: N.T.S.
SCALE:

APPROUVE PAR:
APPROVED BY:

DATE: 16-9-87

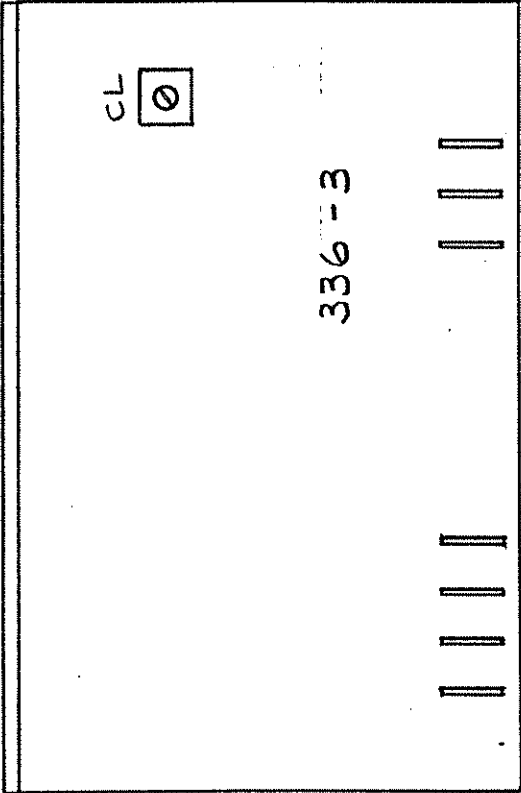
DESSINÉ PAR: VALENTINI
DRAWN BY:

REVISE PAR:
REVISED BY:

168-A

NUMÉRO DE DESSIN
DRAWING NUMBER

200 891 A



336-3

CW W CCW

A C D C
+ D C

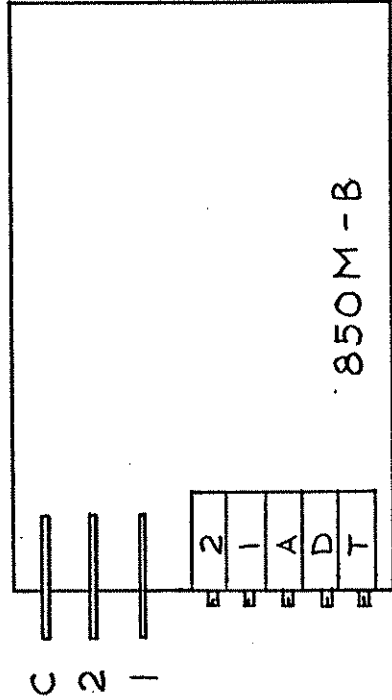
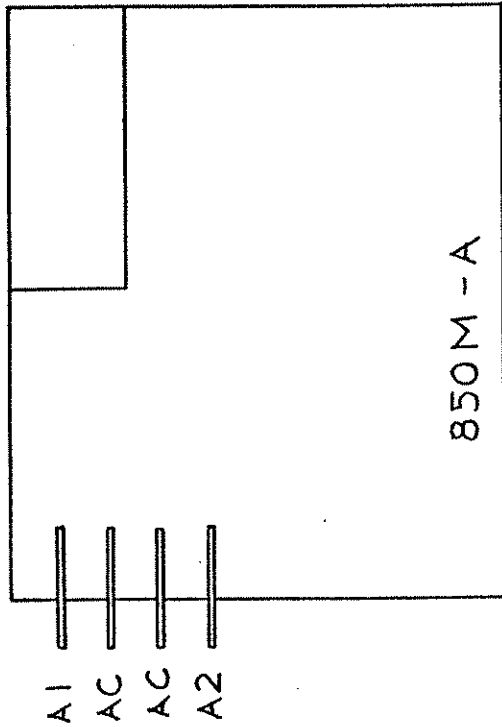
CL : CURRENT LIMITER

ORION PACKAGING INC.

ÉCHELLE: N.T.S. SCALE:	APPROUVÉ PAR: APPROVED BY:	DESSINÉ PAR: VALENTINI DRAWN BY:
DATE: 16-9-87	REVISÉ PAR: REVISED BY:	

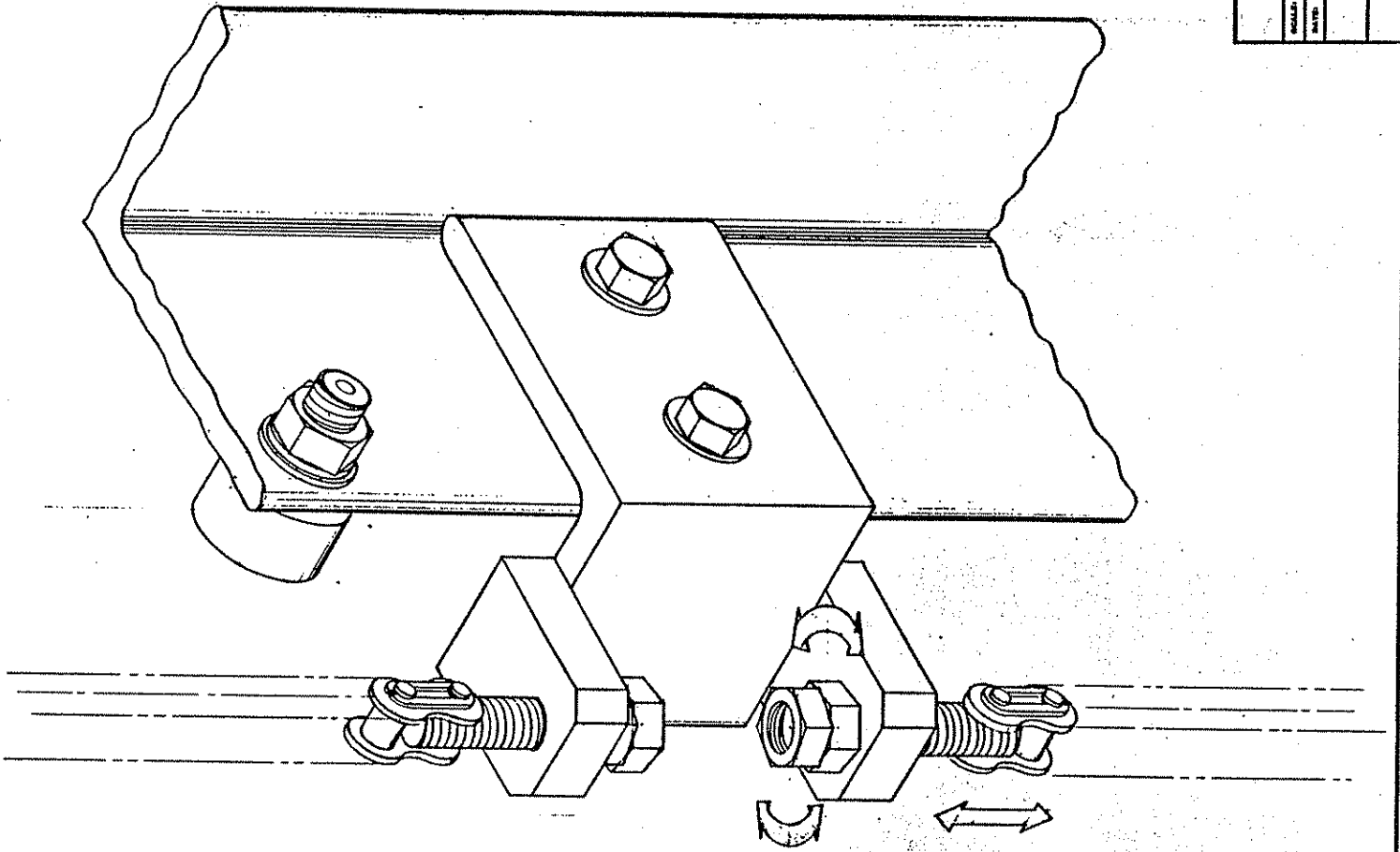
336-3

NUMÉRO 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.	
ÉCHELLE: N.T.S. SCALE:	APPROUVE PAR: APPROVED BY:
DESSINÉ PAR: VALENTINI DRAWN BY:	
REVISE PAR: REVISED BY:	
850 M	
DATE: 16-9-87	
NUMERO DE DESSIN DRAWING NUMBER	
200 889	



CHAIN TENSION
ADJUSTMENT

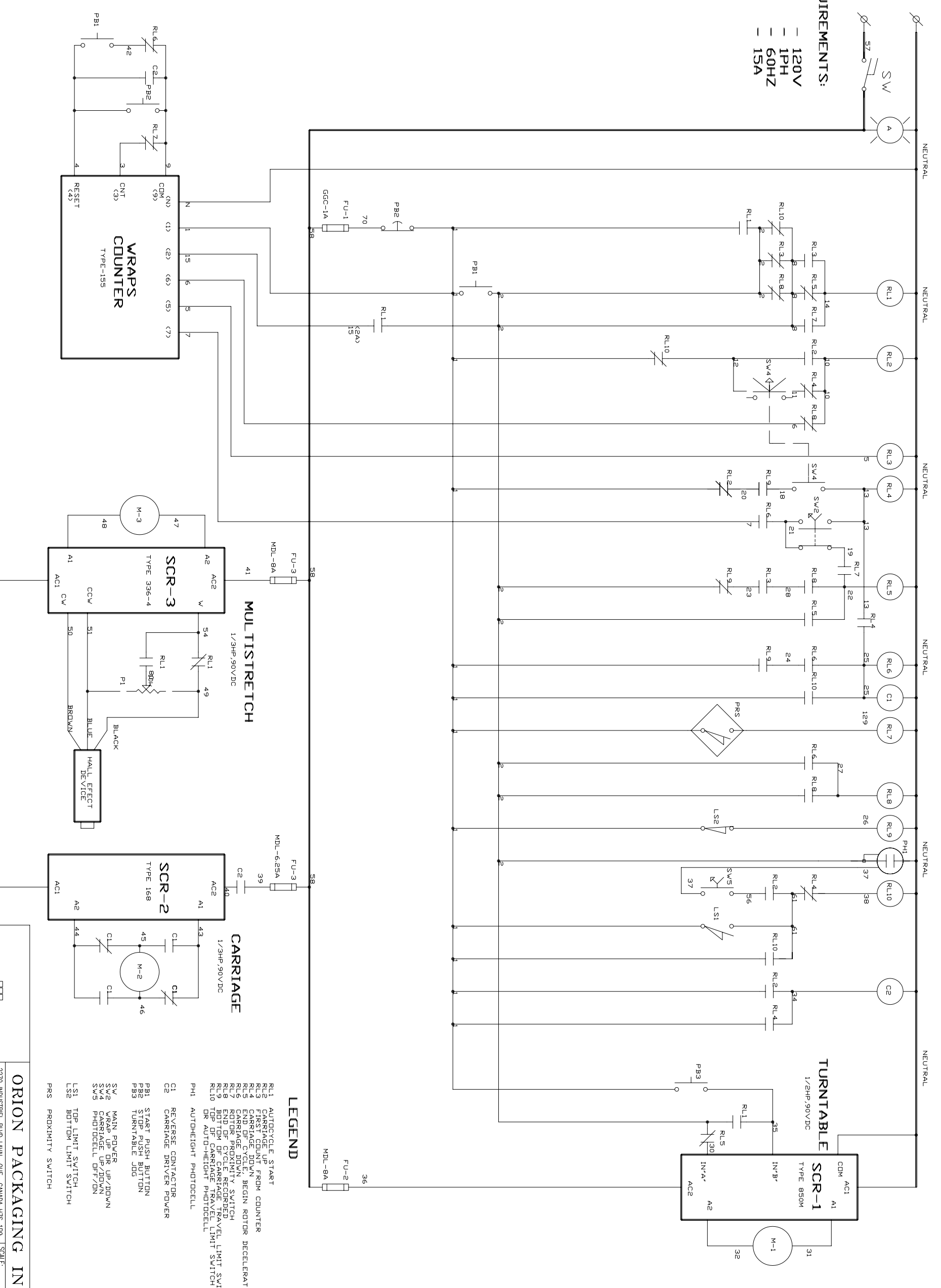
ORION PACKAGING

SCALE: N.T.S.
DATE: 10-7-86
APPROVED BY: [Signature]

CHAIN TENSIONER ASS'Y

200-192

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



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

ORION PACKAGING INC.

2270 INDUSTRIEL BLD LAML QUEBEC, CANADA H7S 1P9
 TEL: (450) 667-9789 FAX: (450) 697-6320
 APTX: BR: JBS DRAWN BY: O'DAO-SOFTWARE

H&L55-6;H&L66-6

SCALE: NTS

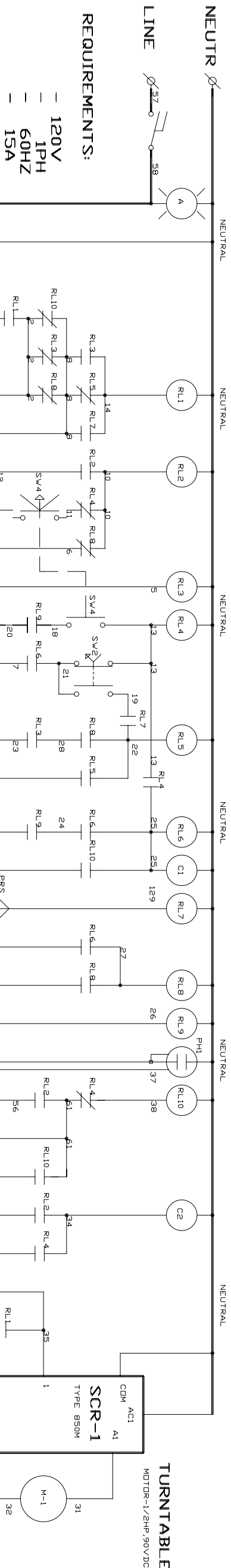
SIZE: DOCUMENT NO. 300 111 1

DATE: JAN-24-1990 SHEET: 1 OF 1

FILENAME: H&L66-6.DWG BASE:

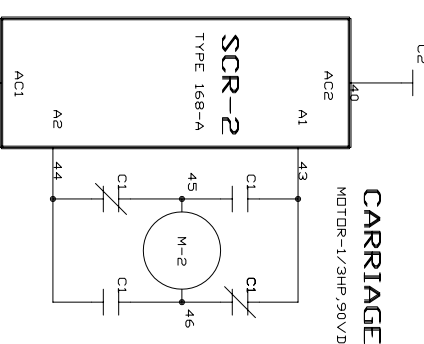
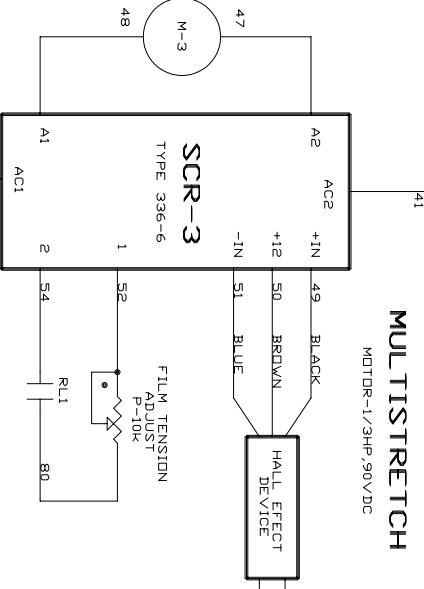
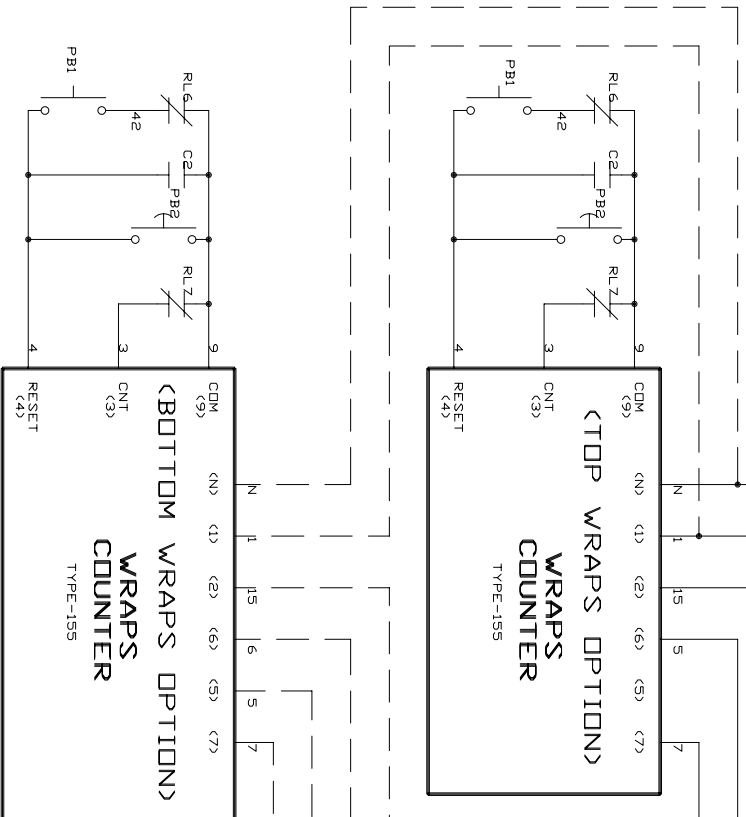
orion PACKAGING INC.

2270 INDUSTRIEL BLD., LAML QUEBEC, CANADA, H7S 1P9
 TEL: (450) 667-9789



REQUIREMENTS:

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



LEGEND

- RL1 AUTOCYCLE START
- RL2 CARRIAGE UP
- RL3 FIRST COUNT FROM COUNTER
- RL4 CARRIAGE DOWN BEGIN ROTOR DECELERATION
- RL5 CARRIAGE DOWN
- RL6 ROTOR PROXIMITY SWITCH
- RL7 END OF CYCLE RECORDED
- RL8 BOTTOM OF CARRIAGE PHOTOEYE LIMIT SWITCH
- RL9 PHOTOEYE LIMIT SWITCH
- RL10 OR AUTO-HEIGHT PHOTOCELL
- PH1 AUTOHEIGHT PHOTOCELL
- C1 REVERSE CONTACTOR
- C2 CARRIAGE DRIVER POWER
- PB1 START PUSH BUTTON
- PB2 STOP PUSH BUTTON
- PB3 TURNABLE JOG
- SW MAIN POWER
- SW1 WRAP UP OR UP/DOWN
- SW2 WRAP DOWN OR DOWN
- SW3 PHOTOCELL OFF/DON
- SW5 PHOTOCELL OFF/DON
- LS1 TOP LIMIT SWITCH
- LS2 BOTTOM LIMIT SWITCH
- PRS PROXIMITY SWITCH

NOTE: ALL MOTORS 1/2HP FOR 55 SERIES

ORION PACKAGING INC.

2270 INDUSTRIEL BLVD LAM, QUE., CANADA H7S 1P9		SCALE: NTS
TEL: (450) 667-9769		
FAX: (450) 667-6320		
APPR. BY: J.B.S. DRAWN BY: G.D.D.-SOFTWARE		
TITLE: H&L66/55-6C		WITH TOP WRAPS OPTION FIRST
SIZE: DOCUMENT NO. C	JOB # STANDARD	300 249 1
DATE: DECEMBER-09-1991	SHEET: 1 OF 1	REV:
FILENAME: H&L66-6C.DWG	BASE:	