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OPERATION MANUAL

For All Inquiries
Please Contact
Our Local Distributor

FOR U.S.A. (Only)
1-800-333-6556

Thank you for choosing ORION'S 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 advanced control systems mean that ORION equipment can be operated safely and efficiently without the need for special operator expertise and skills.

Please read this manual carefully and keep it handy. Following these simple operating instructions will insure the safe and efficient performance of this machine and simple maintenance procedures will guarantee 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
- 3) Subassembly (see PART LIST)

H/L 55-13 (96T)
H/L 66-13 (100T)
Prog. Version 13.0
Dwg. # 301 785

SAFETY

ORION'S stretch wrappers should be operated with caution and common sense as any other industrial equipment. To prevent a potential 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 be disconnected prior to all inspection, maintenance or repair work.

ORION PACKAGING SYSTEMS INC.
SEMI-AUTOMATIC SPECIFICATIONS - EFFECTIVE MARCH 15, 2000

ORION MATRIX® SERIES MODEL L-66

Spiral Semi-Automatic Medium Heavy Duty Low Profile

2000-0910885

Maximum Load Size	55"W x 55"L x 84"H
Weight Capacity	4,000 lbs. Dynamic, 20,000 lbs. Static
Utilities	115/1/60 15 Amp Service
Turntable	59" Diameter Structural Steel Plate Dura-Glide™ Turntable Support System Quiet in Operation, Maintenance Free 3" Height Floor to Top of Turntable
Turntable Drive	0 - 14 RPM Variable Turntable Speed Variable Speed Drive Motor Heavy Duty Chain Drive with Tensioner Electronically Adjustable Acceleration/Deceleration (Soft Start) Positive Alignment Feature
Control Features	CSA Approved, NEMA 12 Control Panel State-of-the-Art Allen Bradley MicroLogix Programmable Logic Controller User Friendly Controls with Non-Proprietary Pushbuttons, and Switches Revo-Logic™ Exact Wrap Counting Technology 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 Film Carriage Raise/Lower Switch (Manual) Cycle Pause for Stopping the Wrap Cycle Without Resetting Reinforce Wrap for Banding Photocell for Automatic Load Height Detection with On/Off Switch Turntable Jog Pushbutton Selectable Bottom Wraps First / Top Wraps First Operation
Film Delivery	20" Orion Insta-Thread™ Powered Prestretch Film Delivery System Precision Ground, Polyurethane Pre-Stretch Rollers for Consistent, Maximum Film Yield 245% Standard Pre-Stretch Ratio (Adjustable from 100% to 425%) 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 Adjustable Film Roping Bar on Chassis for Stronger Interlocking of Load and Pallet
Film Carriage Elevator Drive	Heavy Duty ANSI Chain Carriage Lift Variable Speed Drive Motor <u>Multi-Point UHMW Precision Carriage Guidance System</u>
Structural Features	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 Structural Steel Tube Mast Design Hinged Mast for Ease of Shipping, Portability
Estimated Shipping Weight	1,650 lbs.

Visit our Distributor Support Website at www.support.orionpackaging.com

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 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:

- motors and transmissions (transmissions may require purge plugs which could have been unplugged for the transport purpose).
 - junction boxes
 - electrical conduits
 - proximity and limit switches
 - photocells
3. Check the turntable assembly 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 operating manual envelope attached to the panel enclosure.

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).

NOTE: Mongoose M66IS or M67IS the "Z" stand **must be bolted to the floor by the 5/8"** or stronger anchors

- 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 degree 6').
- The conveyor roller deviation from horizontal must not exceed 1/16" on the distance of 52" (angle: 0 degree 4').

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.

MACHINE OPERATION

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 proceeding the machine operation familiarize yourself with the EMERGENCY-STOP button and all functions, switches and pushbuttons.

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 on by pressing the STOP button (may also be used for the choosing the range of counts of the top and bottom wraps - see TOP WRAPS and BOTTOM WRAPS).

NOTICE: In case of emergency, the push-pull STOP button interrupts all the machine electrical circuits. To continue the cycle the STOP push button should be pulled out and START button pressed for the machine restarting. Double pressing of the push - pull STOP button will reset the machine program and machine will be ready to apply the wrapping cycle from its beginning.

WRAP PATTERN SELECTOR SWITCH "SPIRAL" Up / Up/Down

The Pattern Selector Switch " SPIRAL" positions:

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).

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 be in bottom position, turntable will slow down and stop in home position.

Machine is shipped pre-programmed in Top Wraps First Sub-Mode, in order to change Sub-Mode from Top Wraps First to Bottom Wraps First see instructions below.

Before proceeding ensure that machine is in MANUAL, STANDBY MODE (machine is powered on and all machine manual functions are enabled)

- Press the STOP (Red) Button
- To Re-program machine to BOTTOM WRAPS FIRST Sub-Mode, Switch and hold "Carriage Raise/Lower" Selector Switch in LOWER position and maintain for approximately 12 seconds.
- Pull the STOP (Red) push-button out.
- Perform standard machine reset procedure by double push-pull operation of the red mushroom stop button.
- At this point machine is ready and BOTTOM WRAPS FIRST Sub-Mode is now activated.

To Re-program machine to TOP WRAPS FIRST Sub-Mode follow procedures above, with the exception of step 2. Switch and hold "Carriage Raise/Lower" Selector Switch in RAISE position.

At this point machine is ready and TOP WRAPS FIRST Sub-Mode is now activated.

CARRIAGE CONTROL SWITCH

The CARRIAGE CONTROL switch is a three-position switch with the following:

RAISE - raises the carriage until the top limit switch on the tower is activated.

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

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

TURNTABLE JOG & REINFORCE WRAP

The turntable jog switch will rotate the turntable low speed when the switch positioned on the TOWER / TURNTABLE JOG. When the switch is released, the turntable (rotary tower) will stop. The switch is inoperative during the wrap cycle.

When the same switch is positioned on the REINFORCE WRAP the carriage will be stationary until the switch is released.

PHOTOCELL ON/OFF SWITCH

The photocell switch has two settings:

ON - when turned ON, the photocell instructs the carriage to stop and begin the top wrap 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 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 when the top limit switch has been activated.

FILM TENSION

Film tension may be adjusted using the film tension control knob. It has a range of tension from 0 to 10 (0 to 4 the low range, 4 to 8 the most useful range for most of the films used by our customers, 8 to 10 as a very high range which may break some films).

CARRIAGE SPEED

The carriage speed potentiometer control can be used to control the amount of overlap the film will have during the wrap. The potentiometer has settings from 0 to 10, the higher settings being the fastest. High settings mean less film overlap because of faster carriage speed and low settings mean more film overlap because of lower carriage speed.

TOP WRAPS 1, 2, 3...9

Three-position switch controls the number of wraps that may be applied on the top of the load. The machine is preset RANGE # 1 (top wraps: 1 or 2 or 3). To change the values of wrap see TOP & BOTTOM WRAP COUNTS CHANGE.

BOTTOM WRAPS 1, 2, 3...9

Three-position switch controls the number of wraps that may be applied on the bottom of the load. The machine is preset with RANGE # 1 (bottom wraps: 1 or 2 or 3) which may be applied. To change the values of wrap see TOP & BOTTOM WRAP COUNTS CHANGE.

TOP & BOTTOM WRAP COUNTS CHANGE

The Top & Bottom Wrap Selector Switches have three (3) ranges of wrap counts and operate independently of each other.

Range #1	Wrap values of 1-2-3
Range #2	Wrap values of 4-5-6
Range #3	Wrap values of 7-8-9

For the selection of any of these ranges for top and bottom wraps please do as follows:
Before proceeding ensure that machine is in MANUAL, STANDBY MODE (machine is powered on and all machine manual functions are enabled)
Press the STOP (red) Button

Set the Top and Bottom wrap count selector switch to the position corresponding with the desired count range.

- 1 = Range #1
- 2 = Range #2
- 3 = Range #3

Press the START (Green) pushbutton and maintain for approximately 12 seconds.

Pull the STOP (Red) pushbutton out.

Perform standard machine reset procedure by double push-pull operation of the red mushroom stop button.

At this point machine is ready and new preset values are loaded.

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 procedure adjust the wrapping cycle parameters i.e. top wraps, bottom wraps, height photocell on/off, film tension, carriage speed (those 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 (multistretch 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.

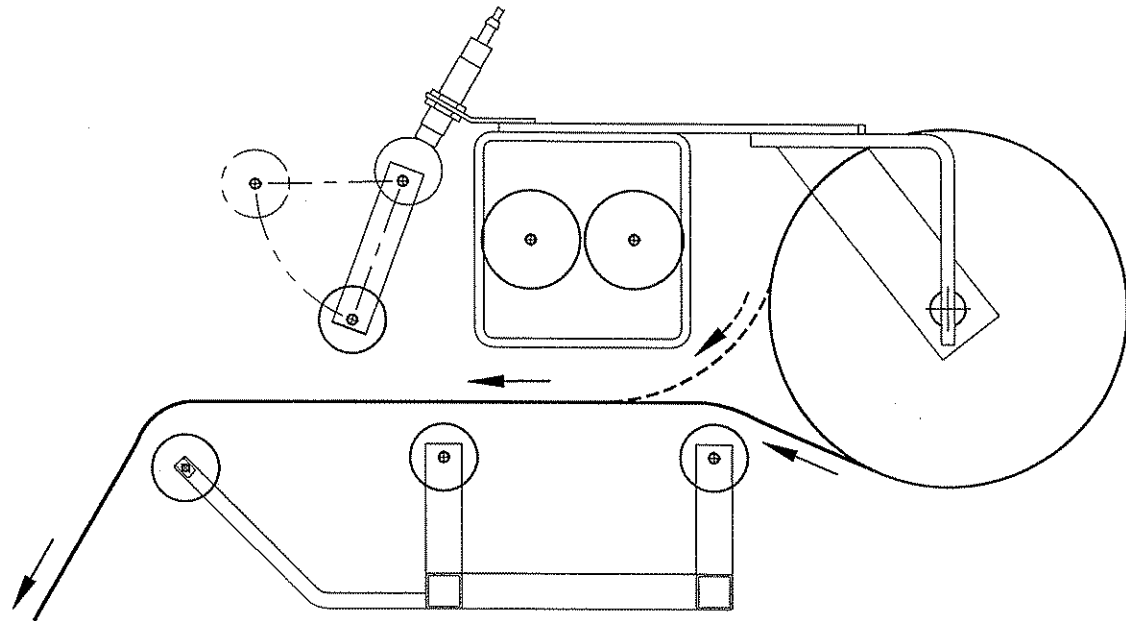


Fig. 1 OPEN CRADLE

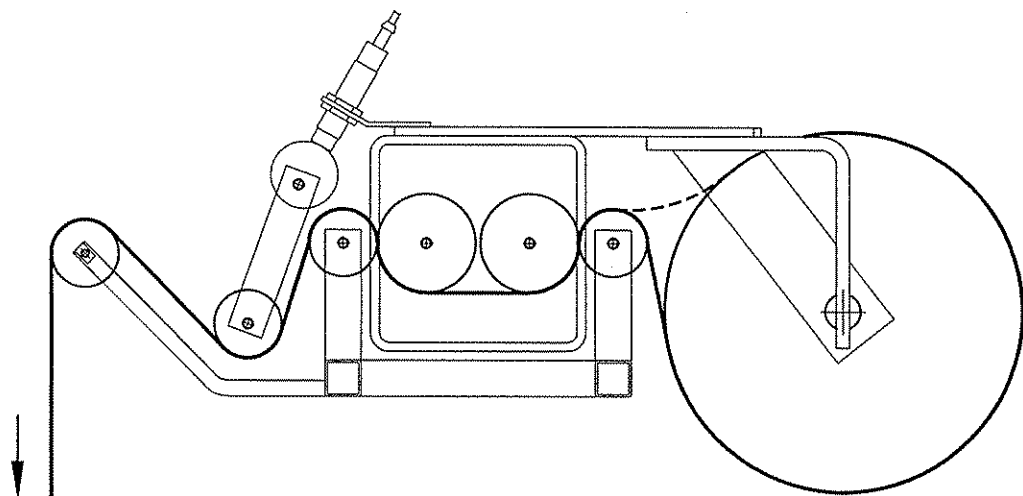


Fig. 2 CLOSED CRADLE

FILM QUICK THREADING

UPDATED FEB-15-99

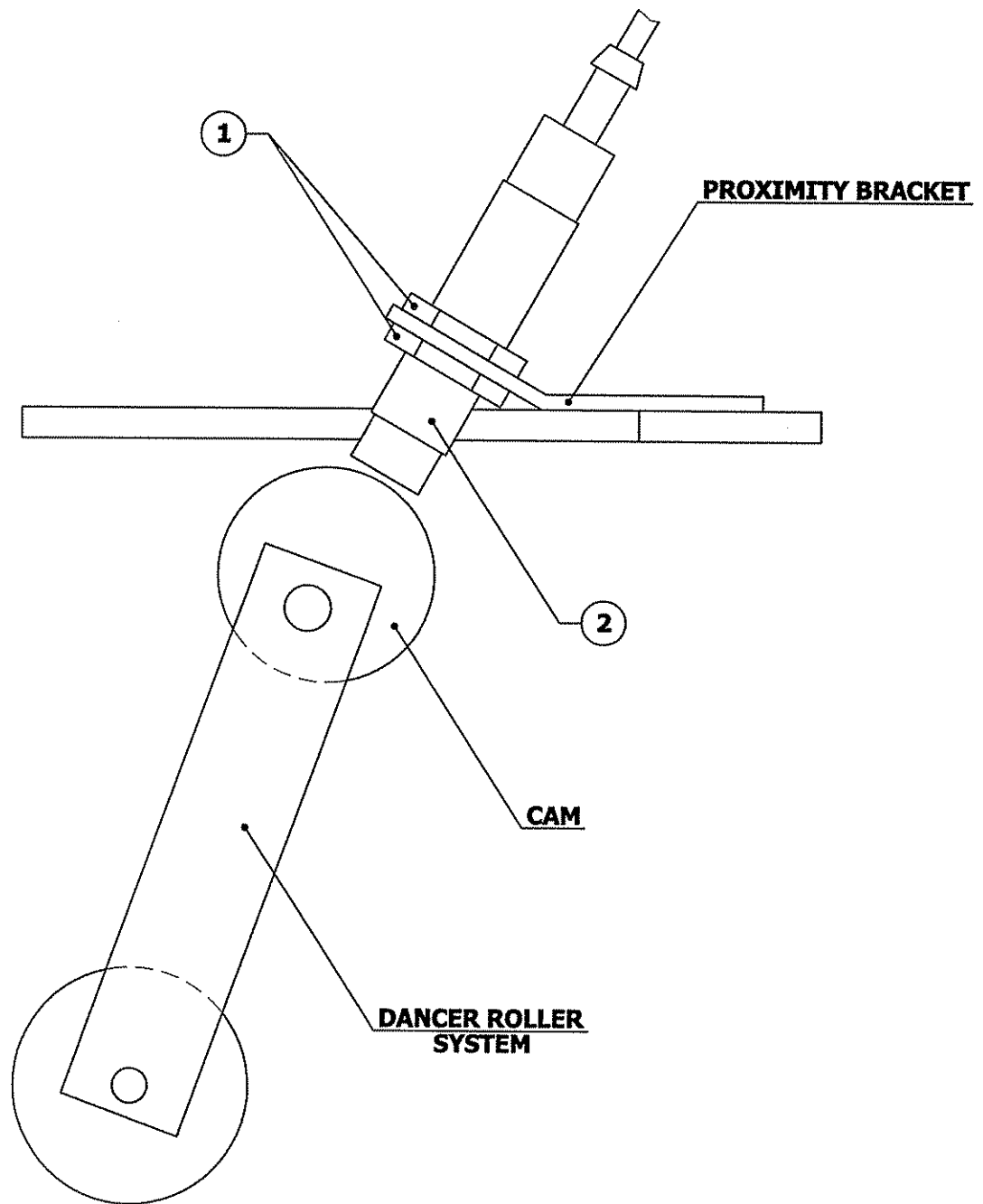
DWG #418180

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.

Adjustment instructions:

- 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
- turn the trim pot SPAN (Board 336-8 or 336-9) adjust the moment when motor starts to turn when dancer roller moved from its home position up to 1 1/2”.



PROXIMITY SENSOR FEED BACK ADJUSTMENT

UPDATED FEB-15-99

DWG #419139

MACHINE MAINTENANCE

All general information about machine maintenance is based on normal machine working conditions: indoors, 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 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 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 Suerr 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.

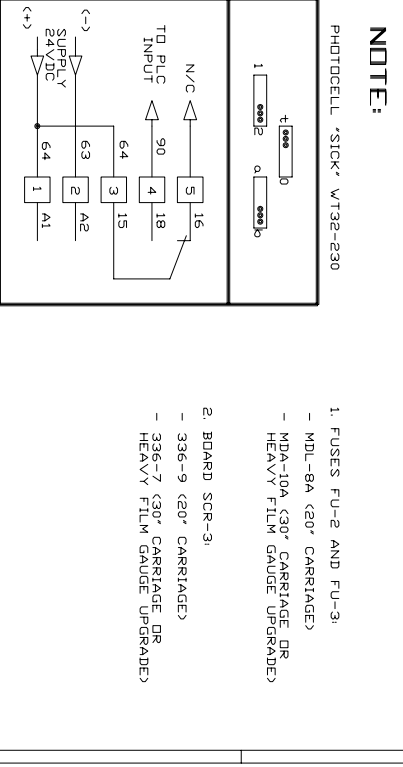
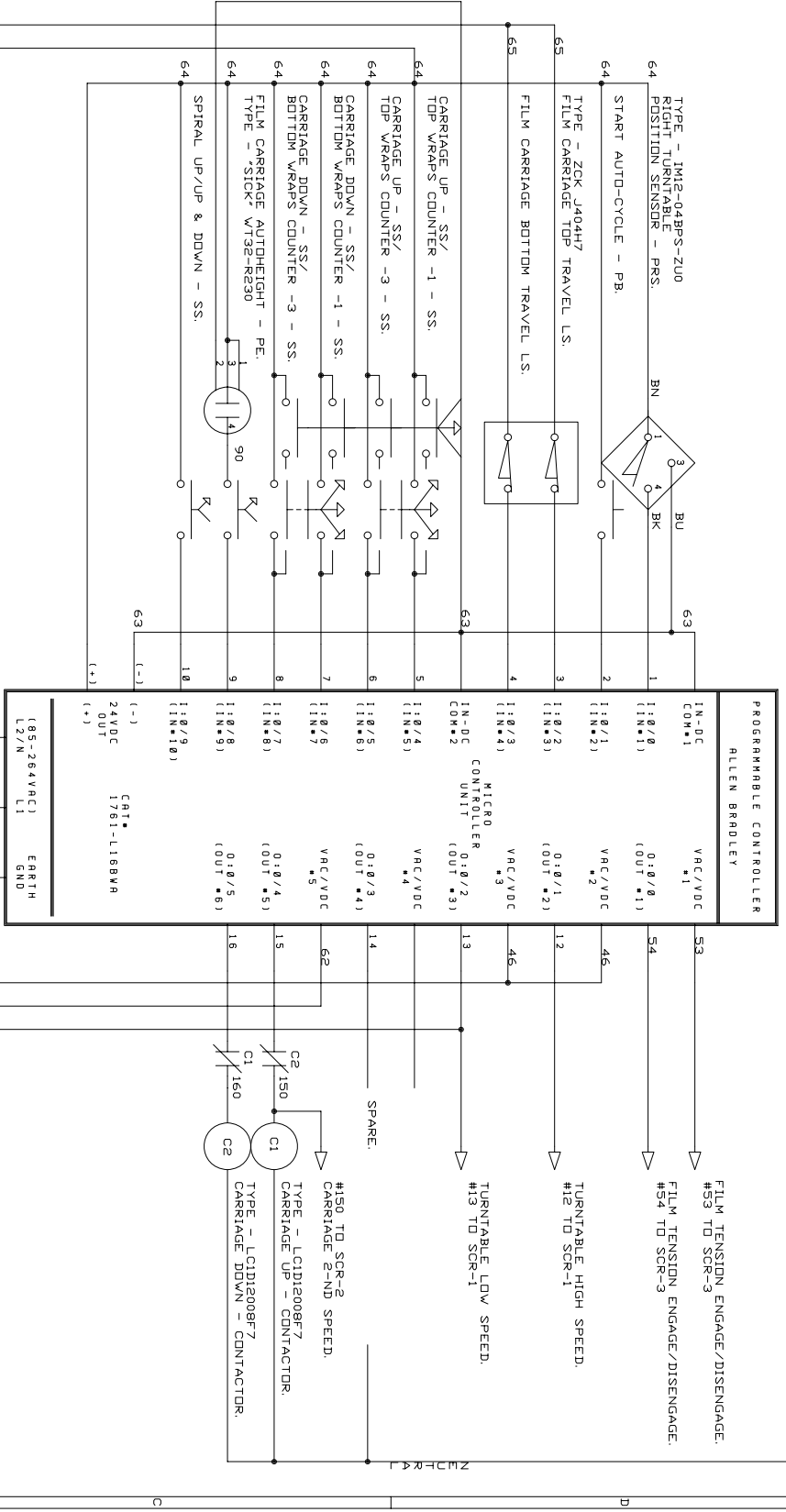
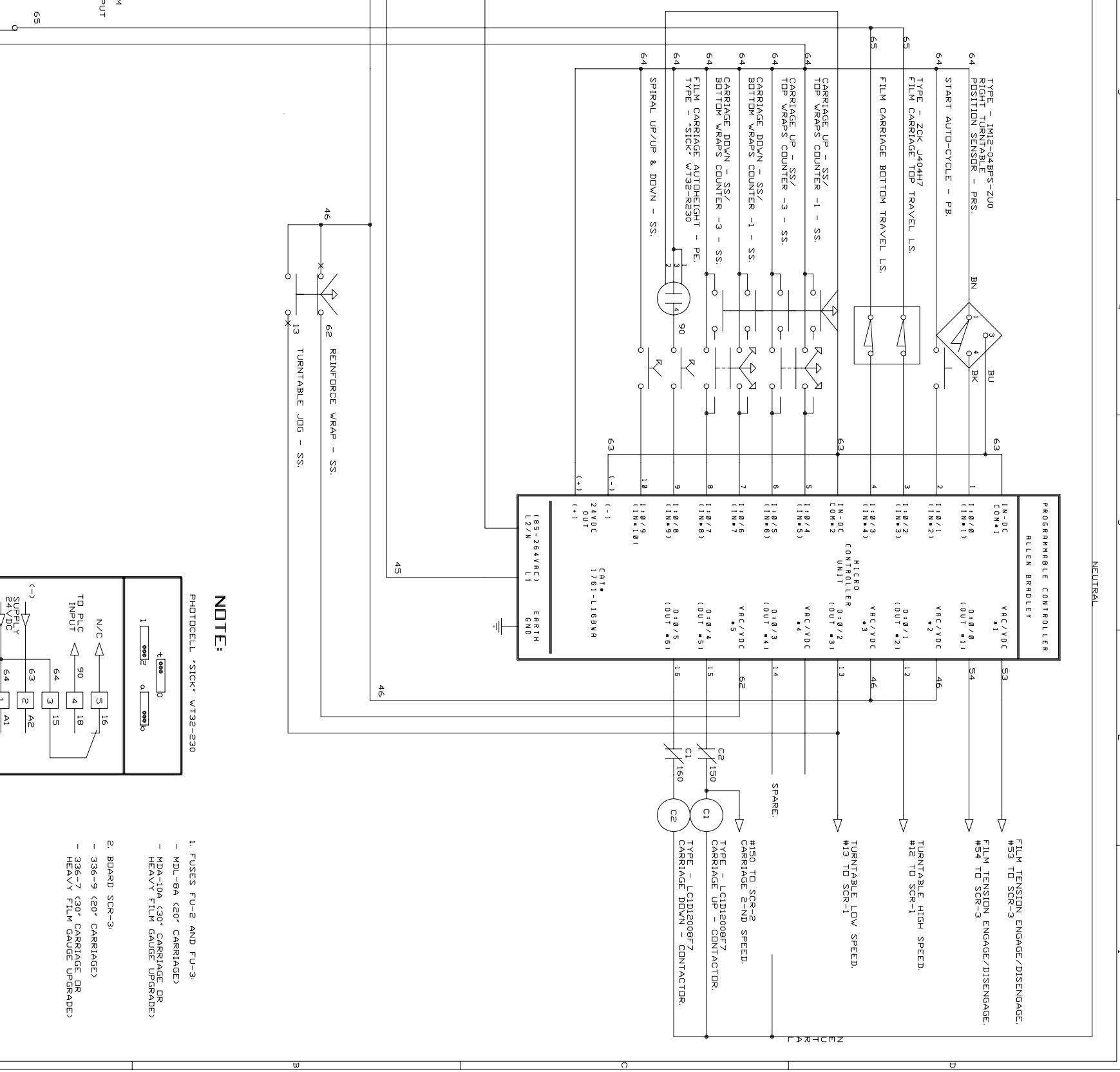
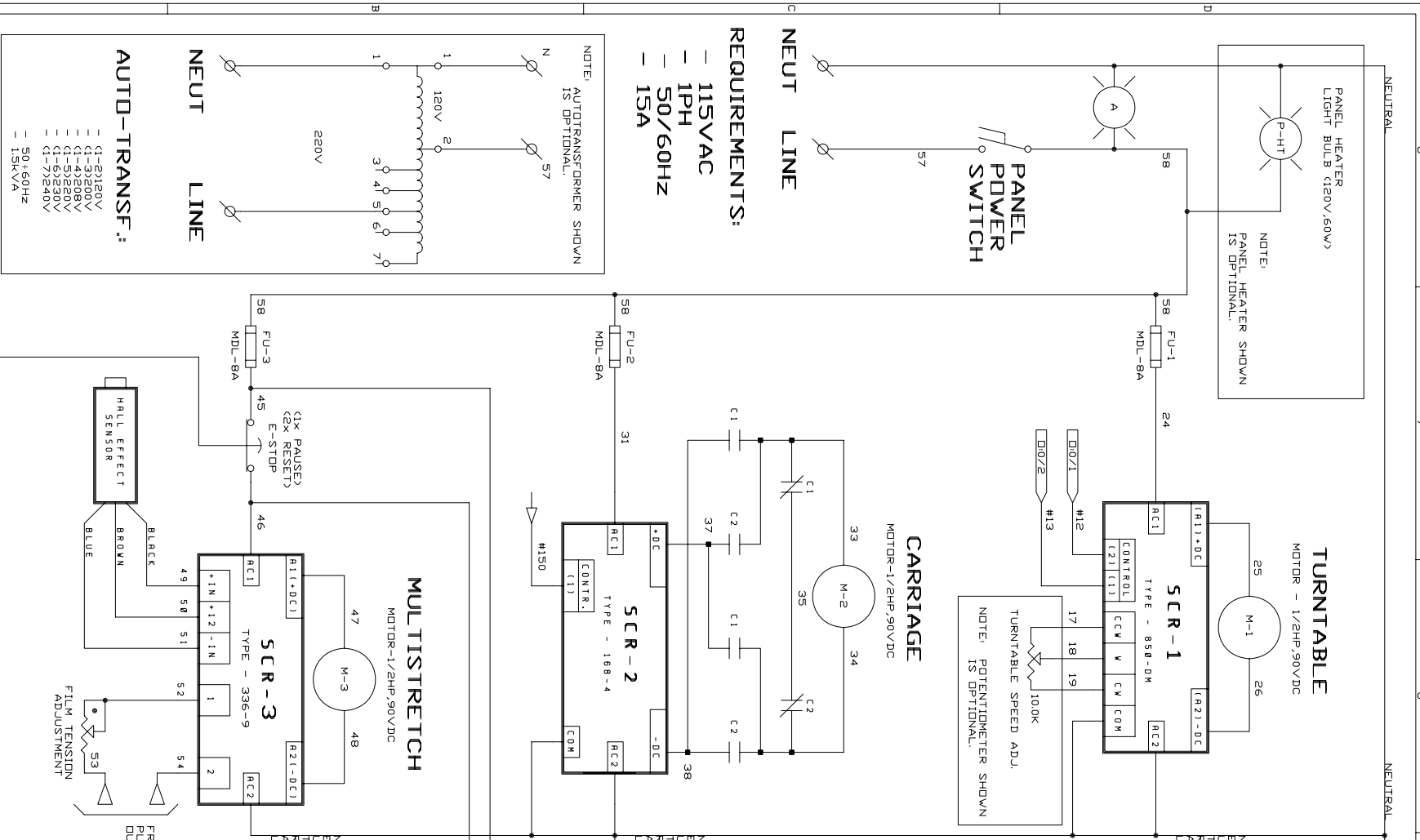
As the chain lubricants please use the most common chain lubricants on the market. With time, the chain will tend to stretch. A loose chain should be tightened at the chain tensioner, or by moving the reducer on its mounting plate.

NOTICE: Chain tension first adjustment must be done after the first two weeks of machine usage.

PNEUMATIC SYSTEM MAINTENANCE (when applicable)

The air supply system must be checked weekly and must be free from the moisture. In cold environments, it may be necessary to drain the air supply system daily and lubricate using SAE #10 oil.

The air lubricator should be filled to approximately 3/4" of its full capacity.



ORION
PACKAGING INC. MONTREAL

ORION PACKAGING INC.

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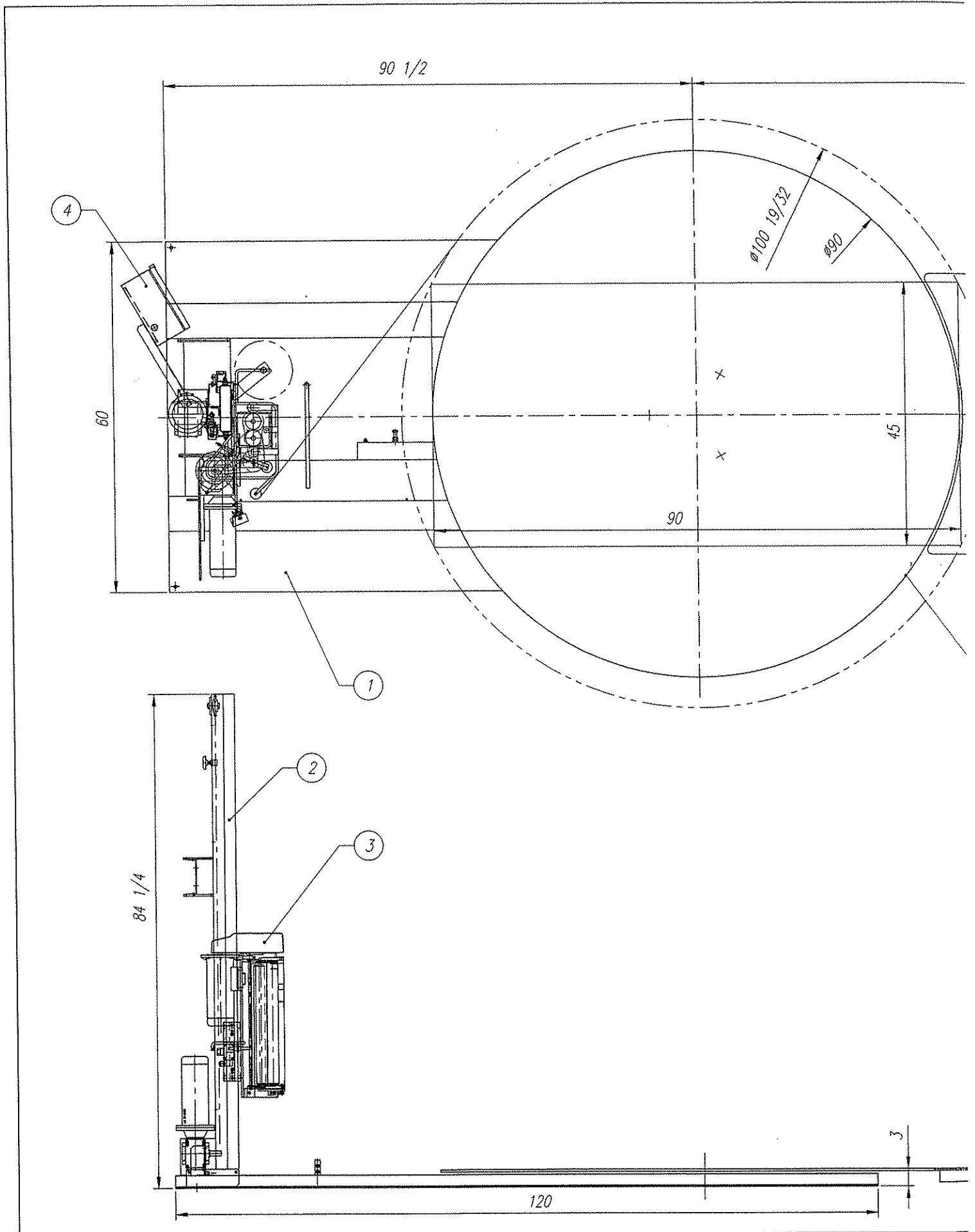
SIZE DOCUMENT NO. **301 785** REV **3**

PANEL SIZE 548 ESCHIG1206
DATE: JAN-04-1999 SHEET 1 OF 1
STICKER 500 049 (FRENCH)
FILENAME: HL66-13SCH BASE: 1

SEMI-AUTOMATIC STANDARD ASSEMBLY PART LIST

NOTE:

- Quantities listed in order of part number.
- The names given to the parts are generic.



121 7/16

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5


6

6	EL. WALKIE RAMP			1	
5	90" DIA. TURNTABLE			1	
4	CONTROL PANEL			1	
3	20" INSTA-THREAD FILM CARRIAGE			1	
2	HINGE TOWER ASSEMBLY			1	
1	L66/13B BASE ASSEMBLY			1	
No.	DESCRIPTION	DWG SIZE	PART No.	Q'ty	WEIGHT

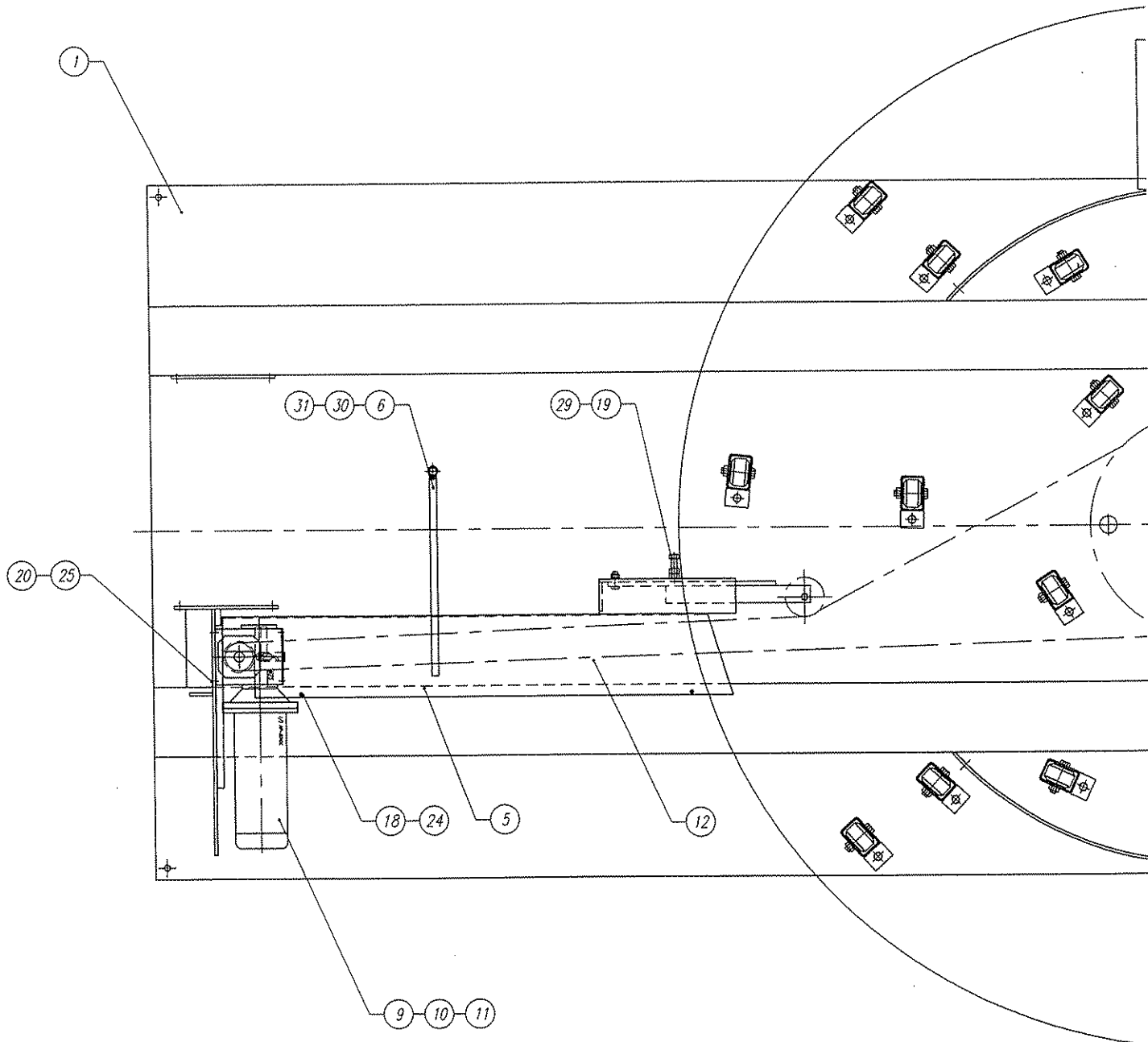
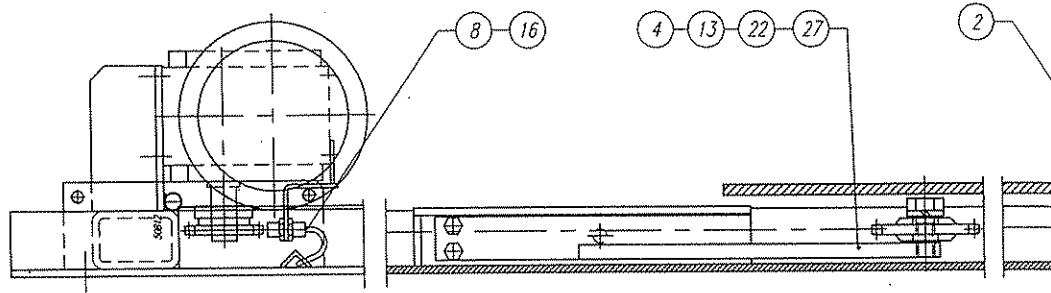
REMARKS: 90" DIA. TURNTABLE, 24" BASE EXT, 20" IT CARR, EL. WALKIE RAMP

REMARKS: -

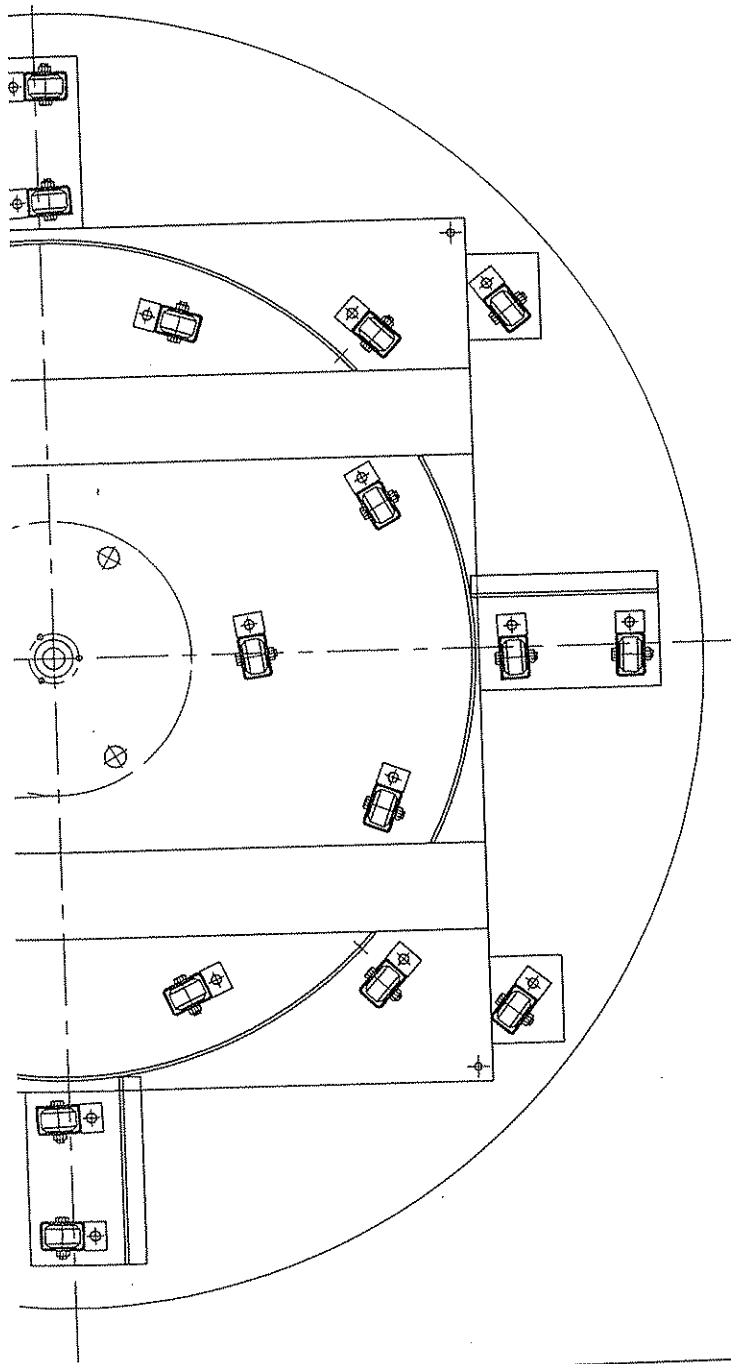
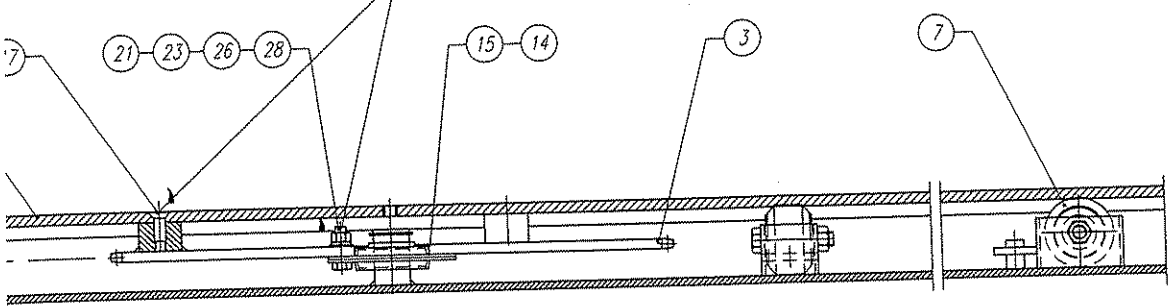
L66/13B - "VITRA" - LAYOUT

 2270 INDUSTRIEL LAVAL QUEBEC, CANADA, H7S 1P9 TEL: (450) 667-9769	DATE:	AUG-07-2000	SCALE:	1 : 10	
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	CHECKED BY:		DRAWING SIZE:	D	
	ASSEMBLY DWG:	APPROVAL	JOB No.:	10885	DRAWING No.:

1 : 4



LOCTITE # 262 (1 DROP ON EACH BOLT)



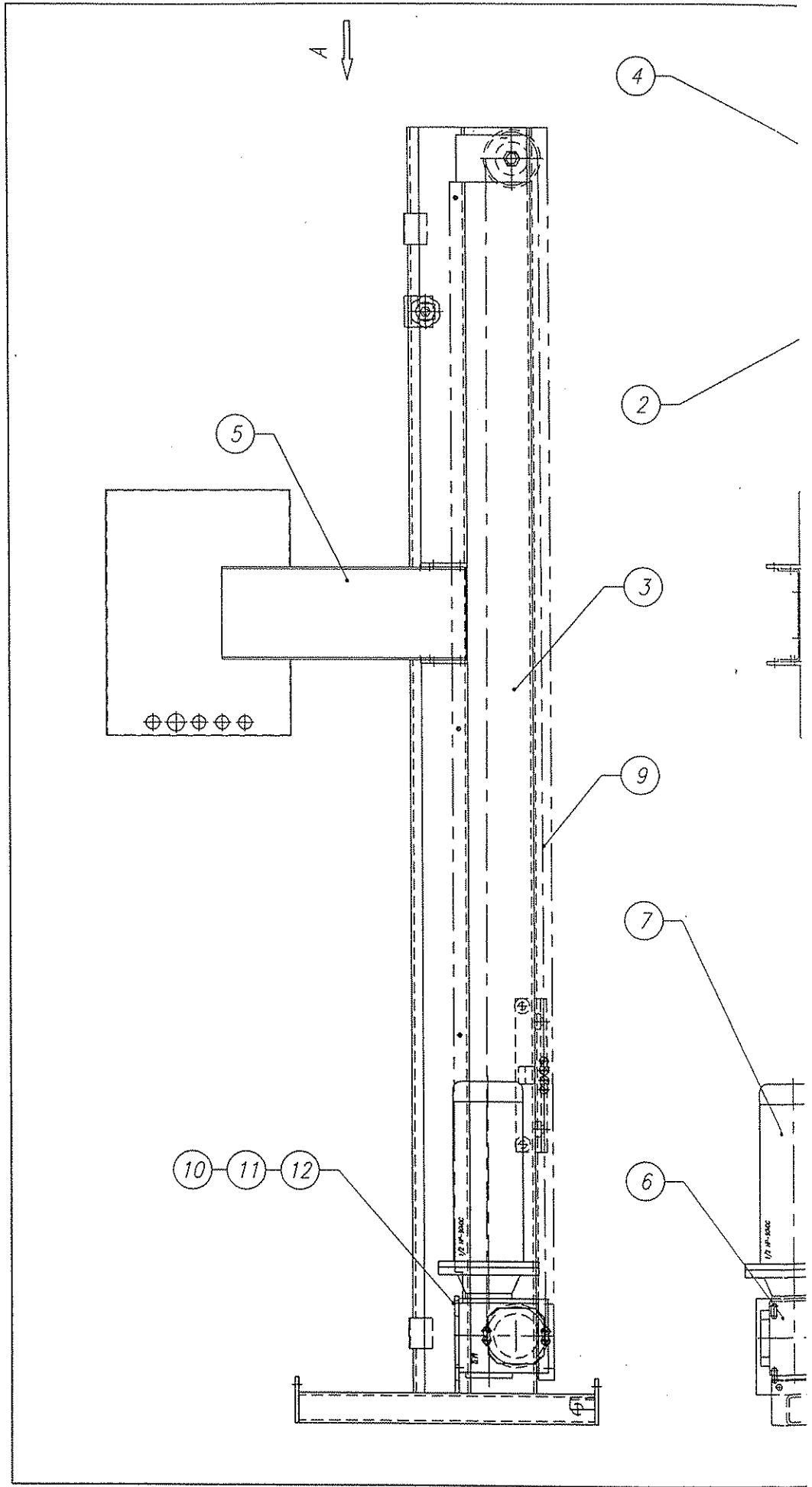
31	HEX. NUT		013407	2	
30	HEX. HEAD SCREW		014157	2	
29	HEX NUT		011266	1	
28	HEX NUT		011128	3	
27	SPRING WASHER		012721	1	
26	SPRING WASHER		011390	3	
25	SPRING WASHER		012724	4	
24	SPRING WASHER		011393	2	
23	FLAT WASHER		010948	3	
22	HEX HEAD SCREW		010329	1	
21	HEX HEAD SCREW		012406	3	
20	HEX HEAD SCREW		010291	4	
19	HEX. HEAD SCREW		013989	1	
18	PAN PHILL		012049	2	
17	FLAT SOCKET SCREW		013842	3	
16	PROXIMITY SWITCH		013848	1	
15	STAMP HOUSING FLANGE BEARING		013654	1	
14	EXTERNAL RETAINING RING		013655	1	
13	IDLER SPROCKET		010008	1	
12	CHAIN		010009	1	
11	SPROCKET		010435	1	
10	REDUCER		015191	1	
9	EL. MOTOR		010036	1	
8	PROXIMITY SWITCH BRACKET	A	423499	1	
7	"DURA-GLIDE" CASTER 2.33" DIA. - ASSEMBLY	A	416055	26	
6	ROPING BAR	A	413868	1	
5	CHAIN GUARD	A	421338	1	
4	CHAIN TIGHTENER ARM	A	411592	1	
3	SPROCKET	A	406338	1	
2	90" DIA. TURNABLE DISK (REVOLOGIC)	B	428911	1	
1	L66/14 H BASE-- WELDING	D	428908	1	
No.	DESCRIPTION	DWG SIZE	PART No.	Q'ty	WEIGHT

REMARKS: -

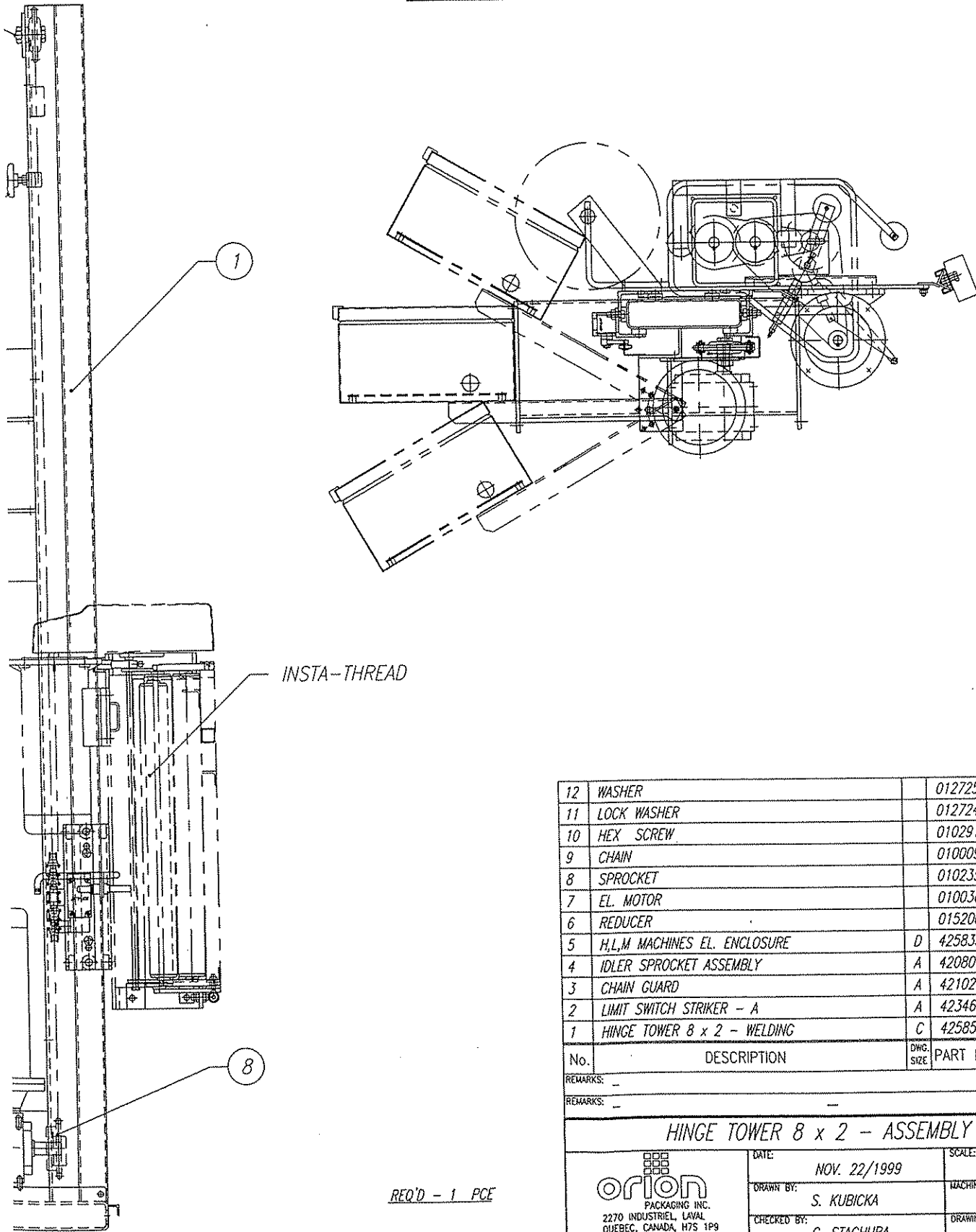
REMARKS: -

L66/13-90" DIA. T.T. BASE ASSEMBLY

<p>ORION PACKAGING INC. 2270 INDUSTRIEL, LAVAL QUEBEC, CANADA, H7S 1P9 TEL.: (514) 667-9769</p>	DATE:	AUG-23-2000	SCALE:	1 : 8	
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	CHECKED BY:		DRAWING SIZE:	C	
	ASSEMBLY DWG:		JOB No.:	10885	DRAWING No.:



VIEW - A



INSTA-THREAD

REQ'D - 1 PCE

12	WASHER		012725	4	
11	LOCK WASHER		012724	4	
10	HEX SCREW		010291	4	
9	CHAIN		010009	1	
8	SPROCKET		010235	1	
7	EL. MOTOR		010036	1	
6	REDUCER		015200	1	
5	H,L,M MACHINES EL. ENCLOSURE	D	425833	1	
4	IDLER SPROCKET ASSEMBLY	A	420809	1	
3	CHAIN GUARD	A	421023	1	
2	LIMIT SWITCH STRIKER - A	A	423469	1	
1	HINGE TOWER 8 x 2 - WELDING	C	425854	1	
No.	DESCRIPTION	DWG. SIZE	PART No.	Q'ty	WEIGHT

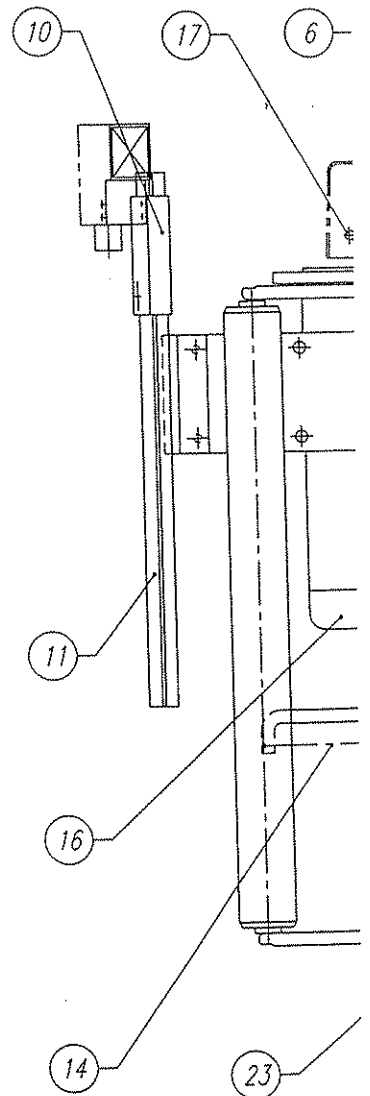
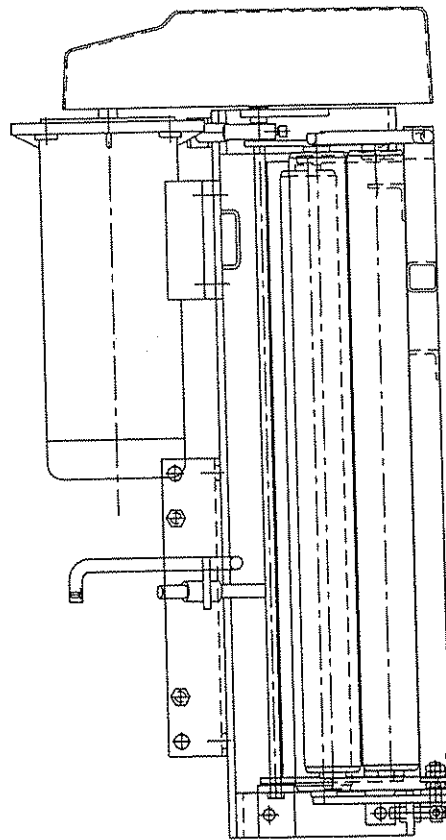
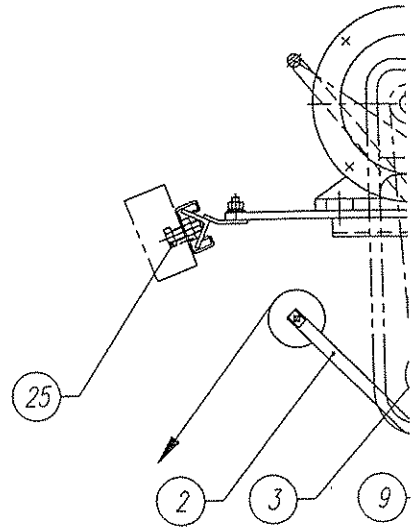
REMARKS: -

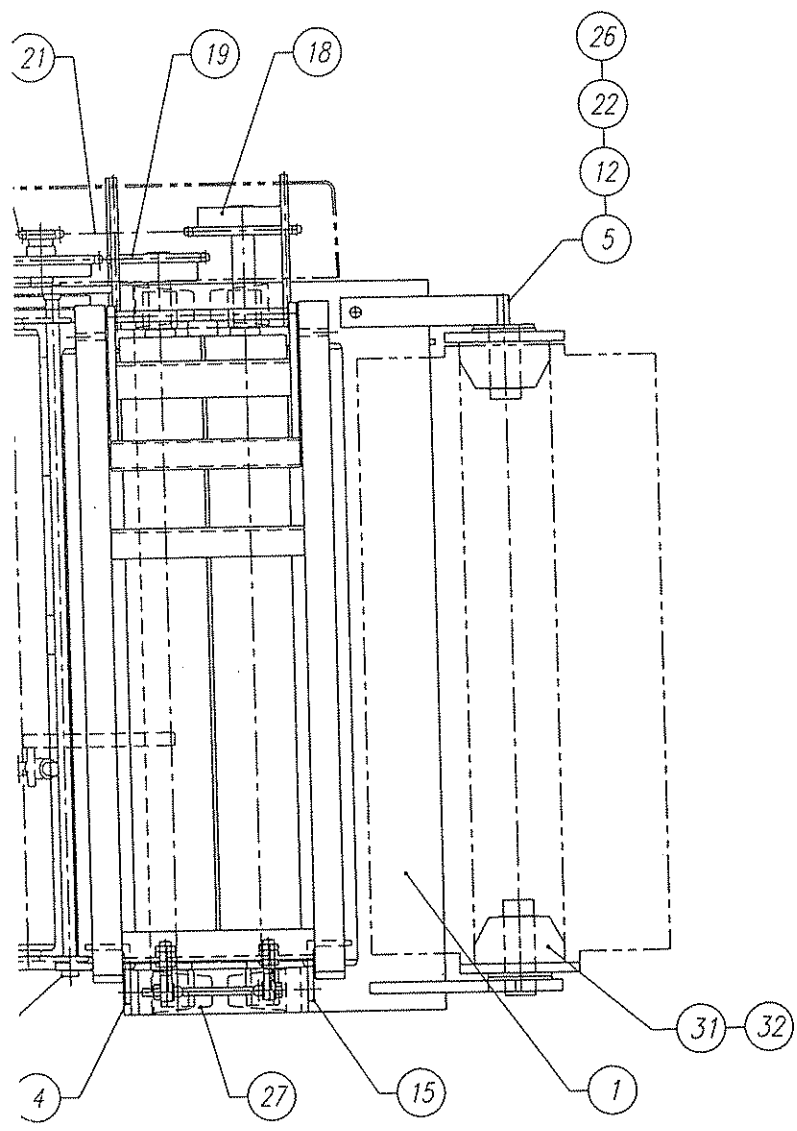
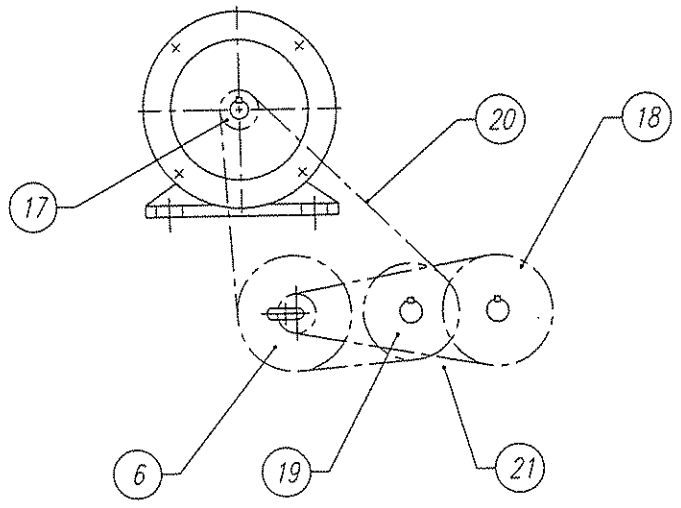
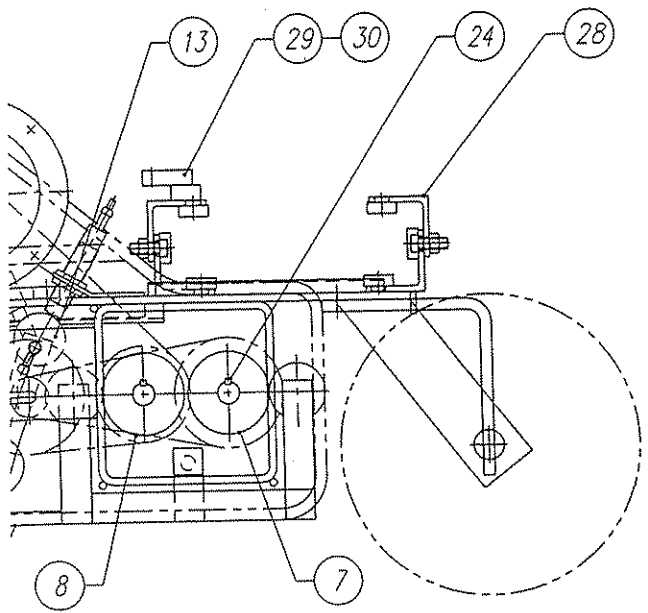
REMARKS: -

HINGE TOWER 8 x 2 - ASSEMBLY

<p>ORION PACKAGING INC. 2270 INDUSTRIEL, LAVAL QUEBEC, CANADA, H7S 1P9 TEL.: (514) 667-9769</p>	DATE:	NOV. 22/1999	SCALE:	1 : 6	
	DRAWN BY:	S. KUBICKA	MACHINE TYPE:	H,L66,55	
	CHECKED BY:	G. STACHURA	DRAWING SIZE:	C	
	ASSEMBLY DWG.:	425852 B	JOB No.:	STD/14.1	DRAWING No.:

PRESTRETCH CHANGE AVAILABILITY			
No.	DESCRIPTION	PART No.	PRESTRETCH %
18	DRIVE SPROCKET	401317	395 %
		401316	380 %
		011463	350 %
		011462	320 %
		011461	305 %
		011460	290 %
		011459	275 %
		011458	260 %
		011457	245 %
		011456	230 %
		011455	215 %
		011454	200 %
		011453	185 %
		010968	170 %
		011452	155 %
		011451	140 %
		013134	125 %
		012403	110 %
012402	95 %		
010748	80 %		



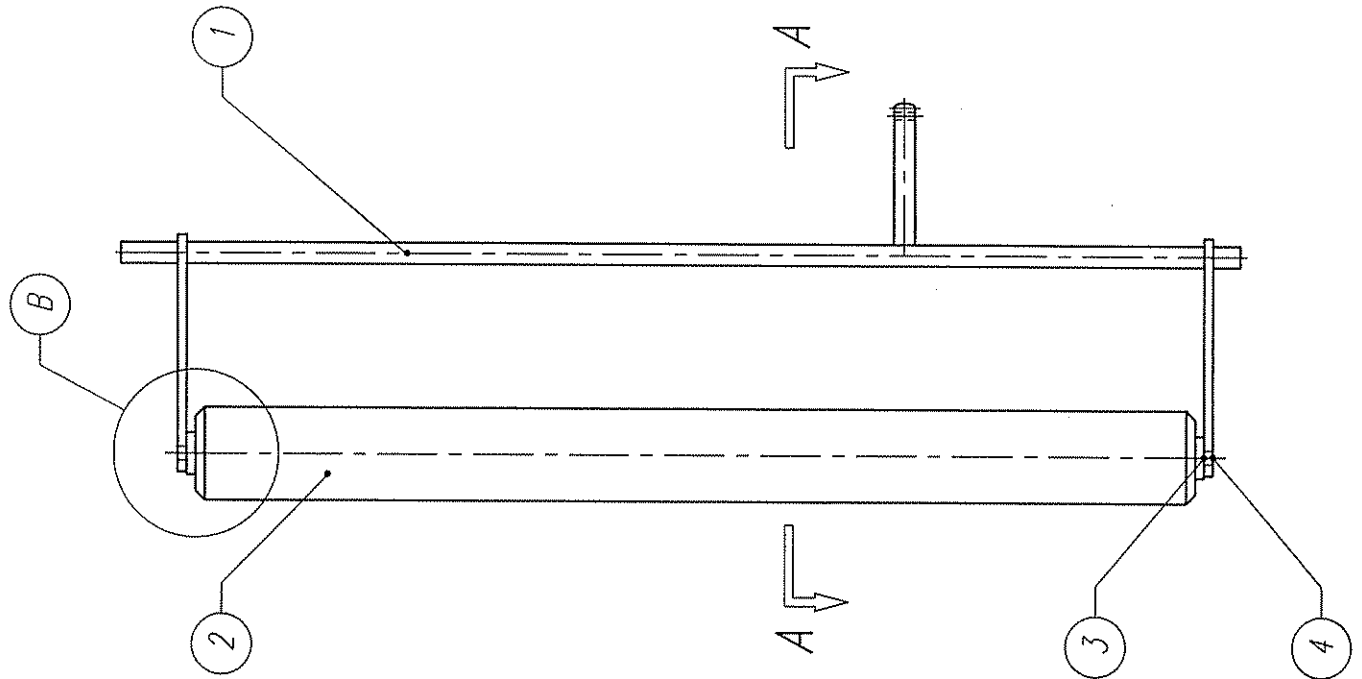


32	WASHER	A	425793	1	
31	BOTTOM SPOOL	A	425792	1	
30	SLIDE BOTTON	A	420001	12	
29	CARRIAGE CHAIN ATTACH. ANGLE	A	420000	1	
28	CARRIAGE ATTACHMENT ANGLE	A	419999	1	
27	PILLOW BLOCK		011192	4	
26	FLAT WASHER		012323	1	
25	BLACK KNOB		010092	1	
24	SQ. KEY		010227	3	
23	FL.BRONZE BUSHING		014247	2	
22	SELF SEATING RETAINING RING		013860	2	
21	CHAIN		010583	1	
20	CHAIN		010583	1	
19	SPROCKET		011454	1	
18	SPROCKET (245 %)		011457	1	
17	SPROCKET	A	415109	1	
16	ELECTRIC MOTOR		010036	1	
15	CRADLE ROLLER OPENING LOCK	A	409469	2	
14	EXTENSION SPRING	B	403118	1	
13	PROXIMITY SENSOR CAM	A	413744	1	
12	SPOOL	A	405855	1	
11	PHOTOCELL CHANNEL - 20, CW ROT'N	A	414304	1	
10	PHOTOCELL BRACKET	A	416832	1	
9	FIBERGLASS COVER - CW ROT'N	B	414305	1	
8	RUBBER ROLLER - 2 (20" FILM)	A	420917	1	
7	RUBBER ROLLER - 1 (20" FILM)	A	420916	1	
6	DOUBLE SPROCKET	A	414546	1	
5	TOP MANDREL	A	414193	1	
4	DANCER ROLLER BRACKET	A	413745	1	
3	DANCER ROLLER ASSEMBLY - 20 (FRL)	A	414194	1	
2	CRADLE ROLLER ASSEMBLY - 20 (FRL)	C	422327	1	
1	INSTA-THREAD BACK PLATE (20-FRL)	C	422058	1	
No.	DESCRIPTION	DWG. SIZE	PART No.	Q'ty	WEIGHT

REMARKS:
REMARKS:

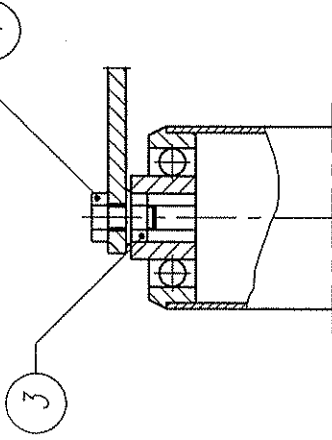
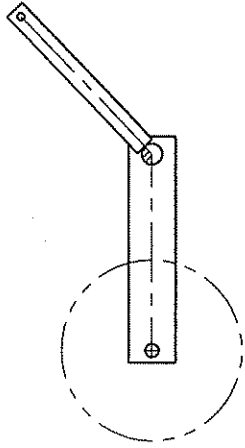
20" INSTA-THREAD ASSEMBLY (FRL)

<p>ORION PACKAGING INC. 2270 INDUSTRIEL, LAVAL QUEBEC, CANADA, H7S 1P9 TEL: (514) 667-9769</p>	DATE: NOV-17-1999	SCALE: 1 : 4
	DRAWN BY: ROGER F.	MACHINE TYPE: H, L55/13
CHECKED BY:	DRAWING SIZE: C	DRAWING No.:
ASSEMBLY DWG. No.: 423064	JOB No.: STD	422047



A - A

DETAIL "B"
1 : 2




No.	DESCRIPTION	DWG. SIZE	PART No.	Q'ty	WEIGHT
4	HEX HEAD SCREW		012475	2	
3	FLANGE NUT		014164	2	
2	ALUMINIUM ROLLER - 20	A	402789	1	
1	DANCER ROLLER CRADLE - 20 (FRL)	A	414195	1	

REMARKS:

REMARKS:

DANCER ROLLER ASSEMBLY - 20 (FRL)


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

DATE: SEP. 29/1998

SCALE: 1 : 4

DRAWN BY: ROGER F.

MACHINE TYPE: ALL/12

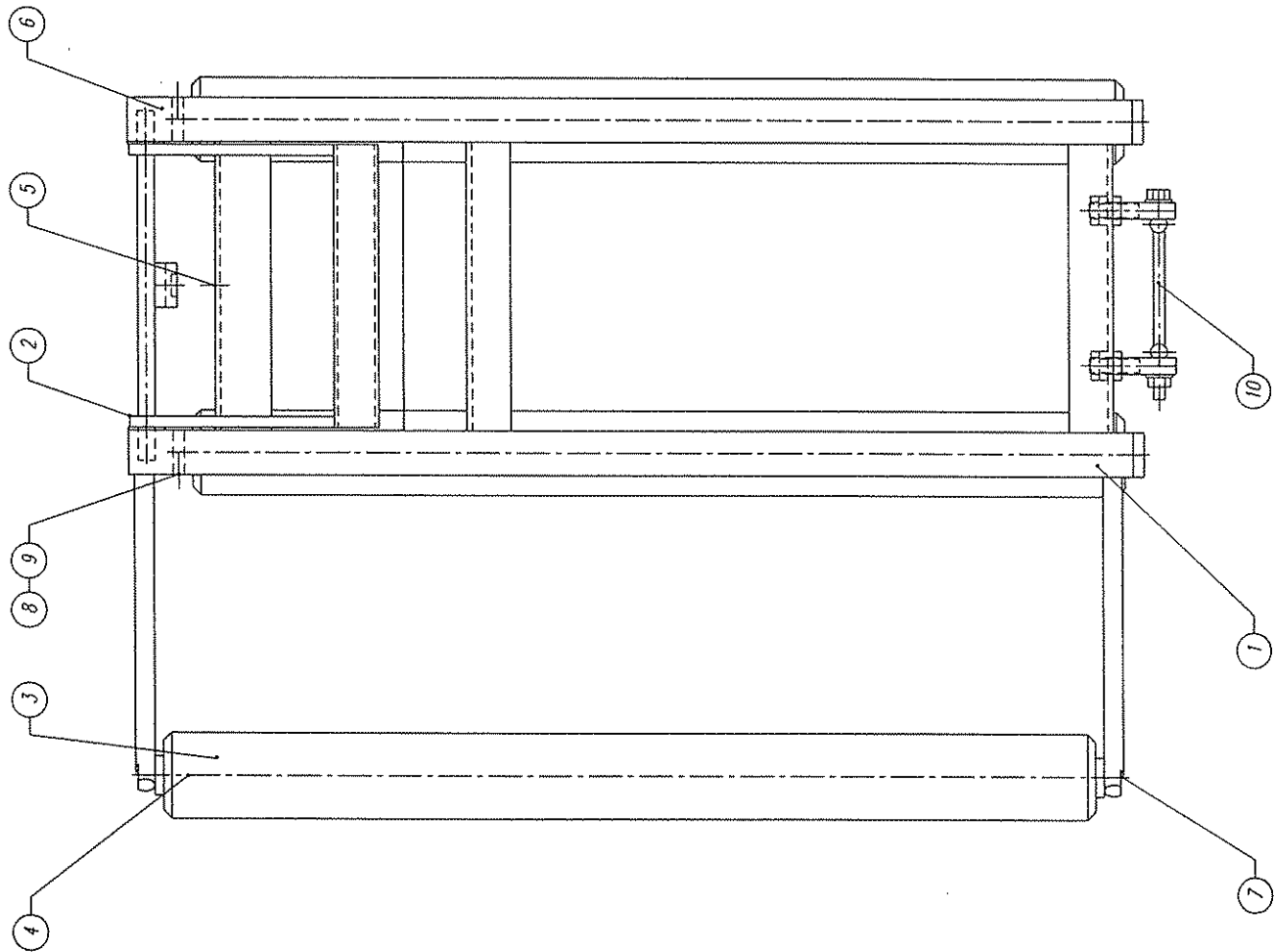
CHECKED BY:

DRAWING SIZE: A

ASSEMBLY DWG.:

JOB No.: STD - 12.1

DRAWING No.: 414194



No.	DESCRIPTION	QTY	WEIGHT
10	CRADLE HINGE ASSY	A 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 - 21 5/16 LG	A 412449	3
3	ALUMINUM ROLLER 1.9 DIA - 20 LG	A 402789	3
2	LOCK	A 412542	1
1	CRADLE ROLLER FRAME - 20" (FRL)	B 422328	1

REWORKS: REPLACES THE SAME DWG / FROM JAN-25-99

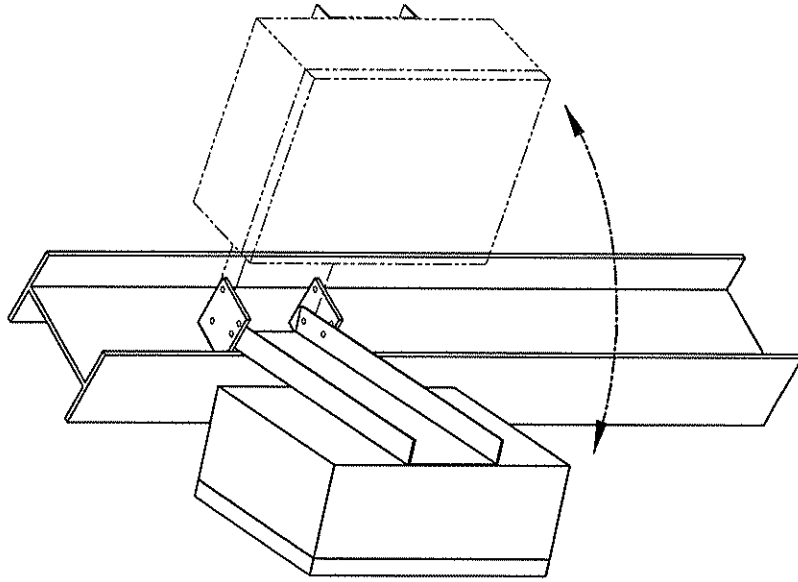
DATE: DEC-15-99
 DRAWN BY: S. KUBICKA
 CHECKED BY:
 2270 INDUSTRIAL LANE
 WILSONVILLE, OR 97148
 TEL: (503) 667-3785

ORION PACKAGING INC.
 2270 INDUSTRIAL LANE
 WILSONVILLE, OR 97148
 TEL: (503) 667-3785

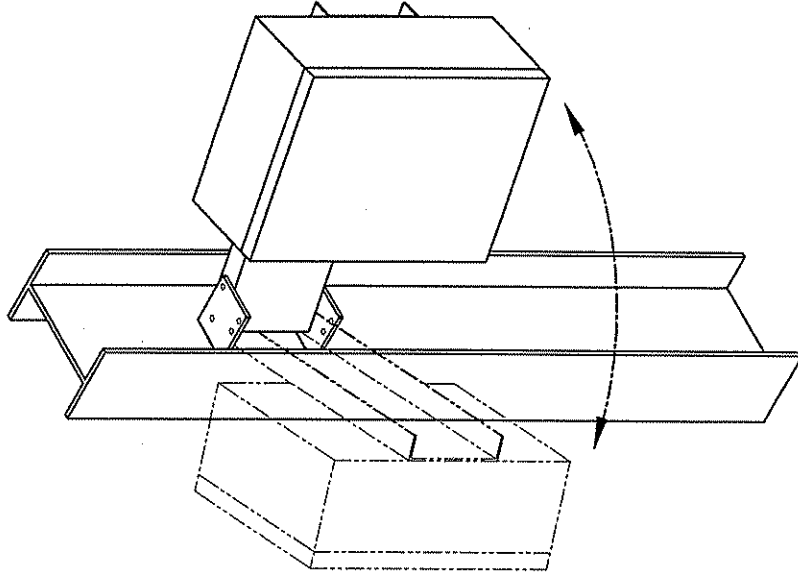
CRADLE ROLLER ASSEMBLY - 20 (FRL)
 SCALE: 1 : 2
 DRAWING NO: 422327
 REV: C
 STD
 422047 C

APPENDIX 1

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



Position 1



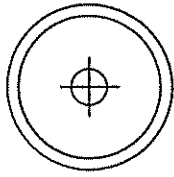
Position 2

CONTROL PANEL MOUNT TWO POSITIONS

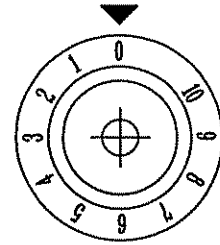
UPDATED FEB-15-99

DWG #418990

START

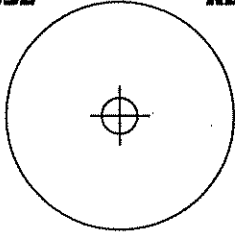


FILM TENSION



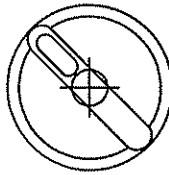
STOP

**1x
PAUSE**

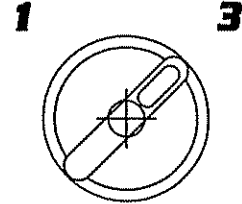


**2x
RESET**

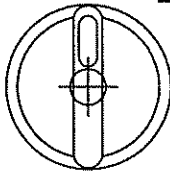
**SPIRAL
UP UP/DOWN**



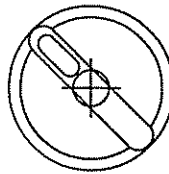
**TOP WRAPS
2**



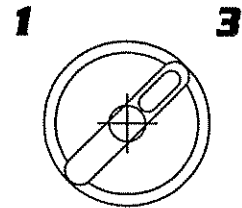
REINFORCE WRAP TOWER T.TABLE JOG



PHOTOCELL OFF ON

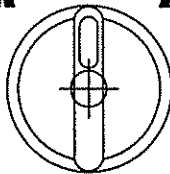


**BOTTOM WRAPS
2**



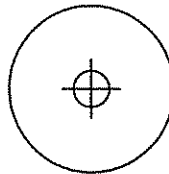
CARRIAGE LOWER RAISE

LOWER

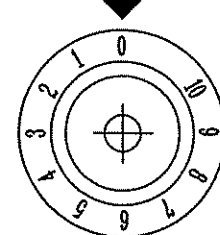


RAISE

POWER



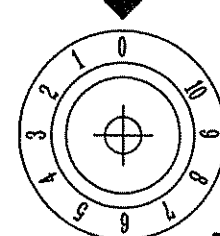
CARRIAGE SPEED UP

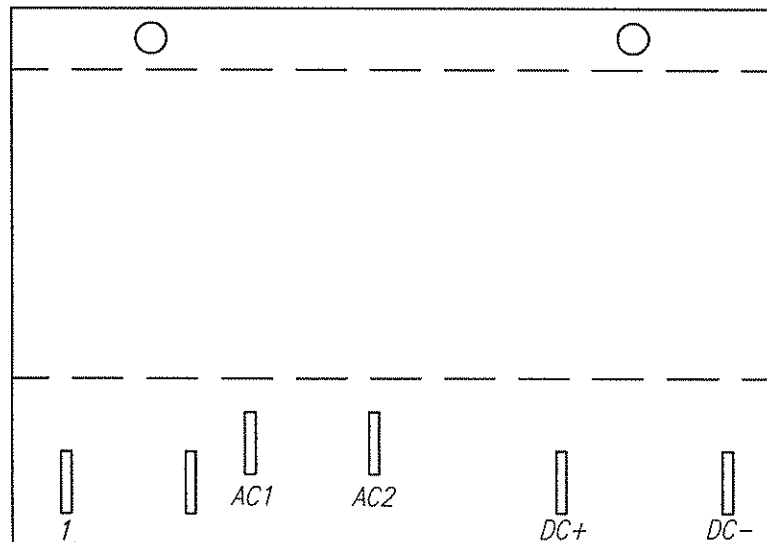
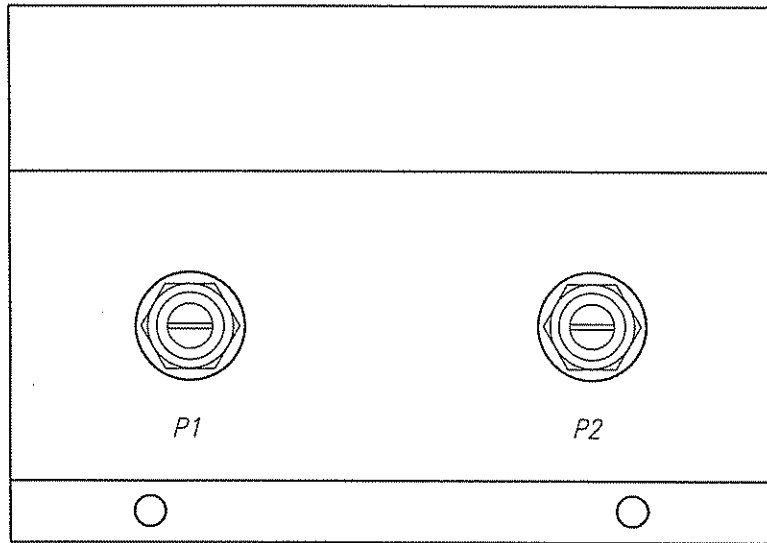


WARNING!

DANGEROUS OR FATAL ELECTRIC SHOCKS MAY RESULT IF POWER TO THE MACHINE IS NOT DISCONNECTED BEFORE OPENING THE PANEL. DISCONNECT POWER TO THE MACHINE BEFORE OPENING THE PANEL.

CARRIAGE SPEED DOWN

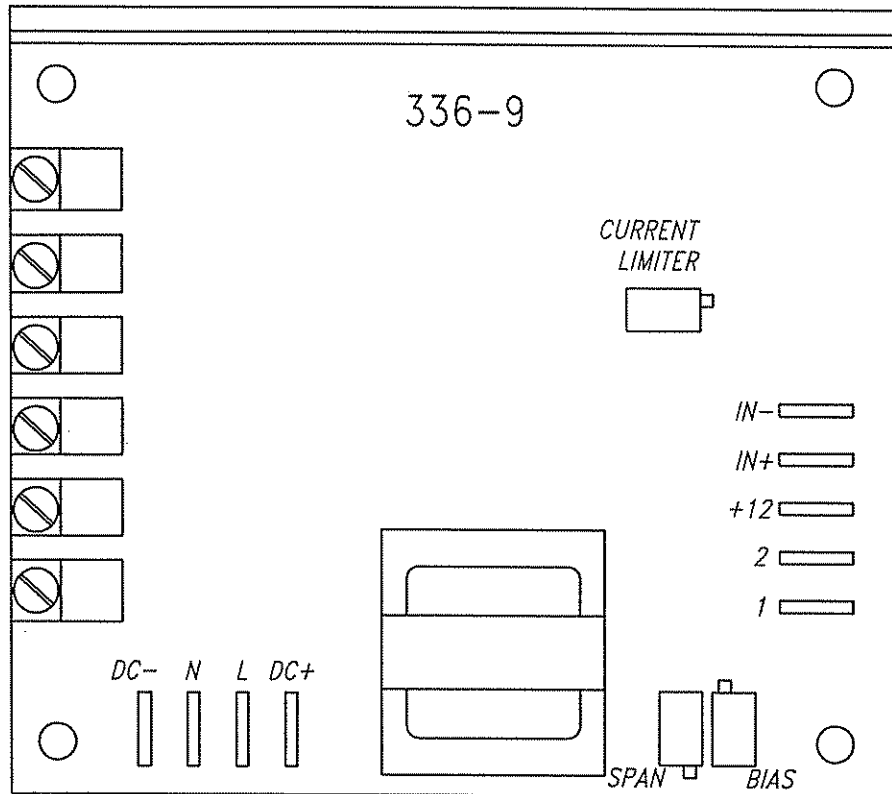




1 : CONTROL
 AC1: AC INPUT
 AC2: AC INPUT
 DC+: ARMATURE CONTROL
 DC-: ARMATURE CONTROL

POTS: SPEED ADJUSTEMENT.

168-4 CARRIAGE
 DOUBLE SPEED BOARD



DC+: ARMATURE CONTROL

N: AC NEUTRAL

L: AC LINE

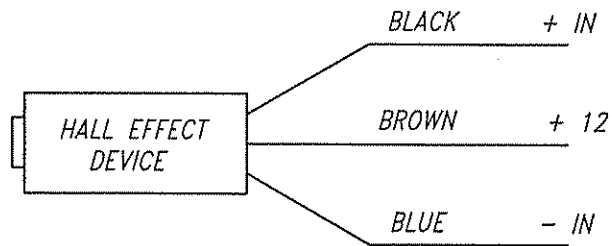
DC-: ARMATURE CONTROL

POTENTIOMETER

SPAN: HALL EFFECT SENSITIVITY CONTROL

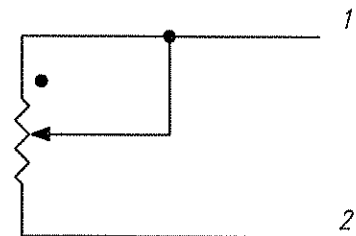
BIAS: SYSTEM BIAS (FACTORY SET)

CURRENT LIMITER: (FACTORY SET)

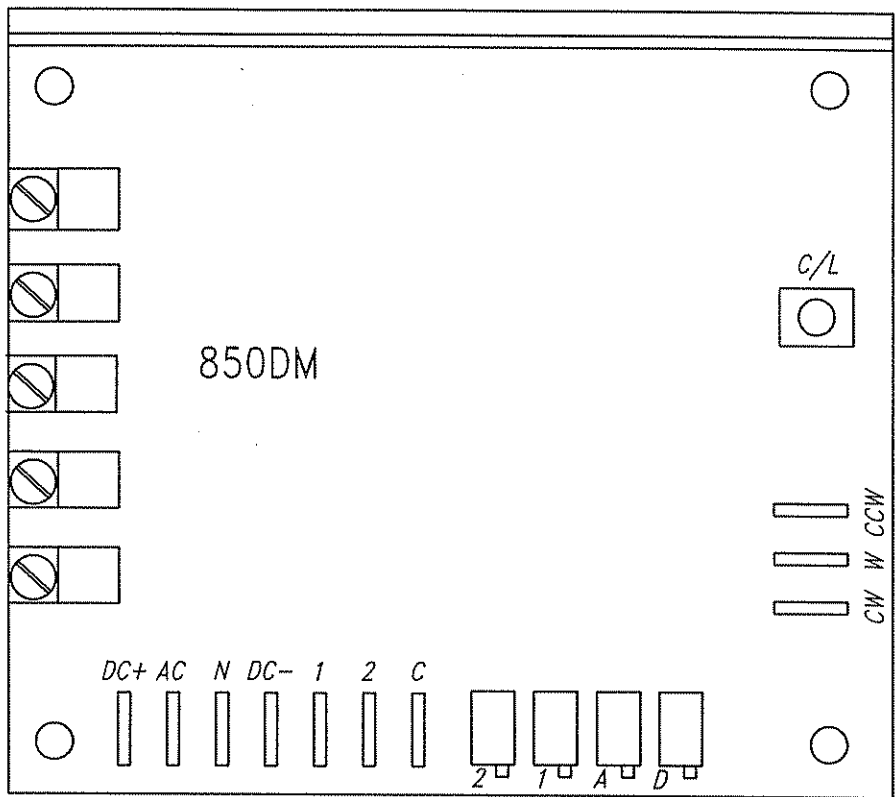


FILM TENSION ADJUSTMENT

REMOTE POTENTIOMETER



336-9
MULTISTRETCH BOARD



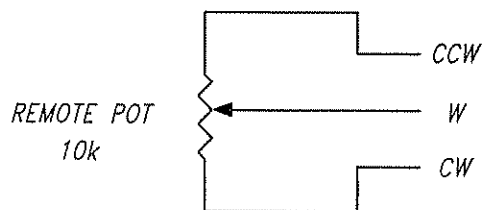
2-ND SPEED (HIGH)
 REMOTE ADJUSTMENT
 (IF NOT USED-PUT JUMPER
 BETWEEN "CW" & "W").

TERMINALS:

DC+: ARMATURE CONTROL.
 AC: AC (HOT) POWER INPUT.
 N: AC NEUTRAL.
 DC-: ARMATURE CONTROL.
 C: CONTROL COMMON.
 2: SPEED CONTROL (HIGH).
 1: SPEED CONTROL (JOG).

POTENTIOMETERS:

2: HIGH SPEED ADJUSTMENT.
 1: JOG SPEED ADJUSTMENT.
 A: ACCELERATION ADJUSTMENT.
 D: DECELERATION ADJUSTMENT.
 C/L: CURRENT LIMIT.

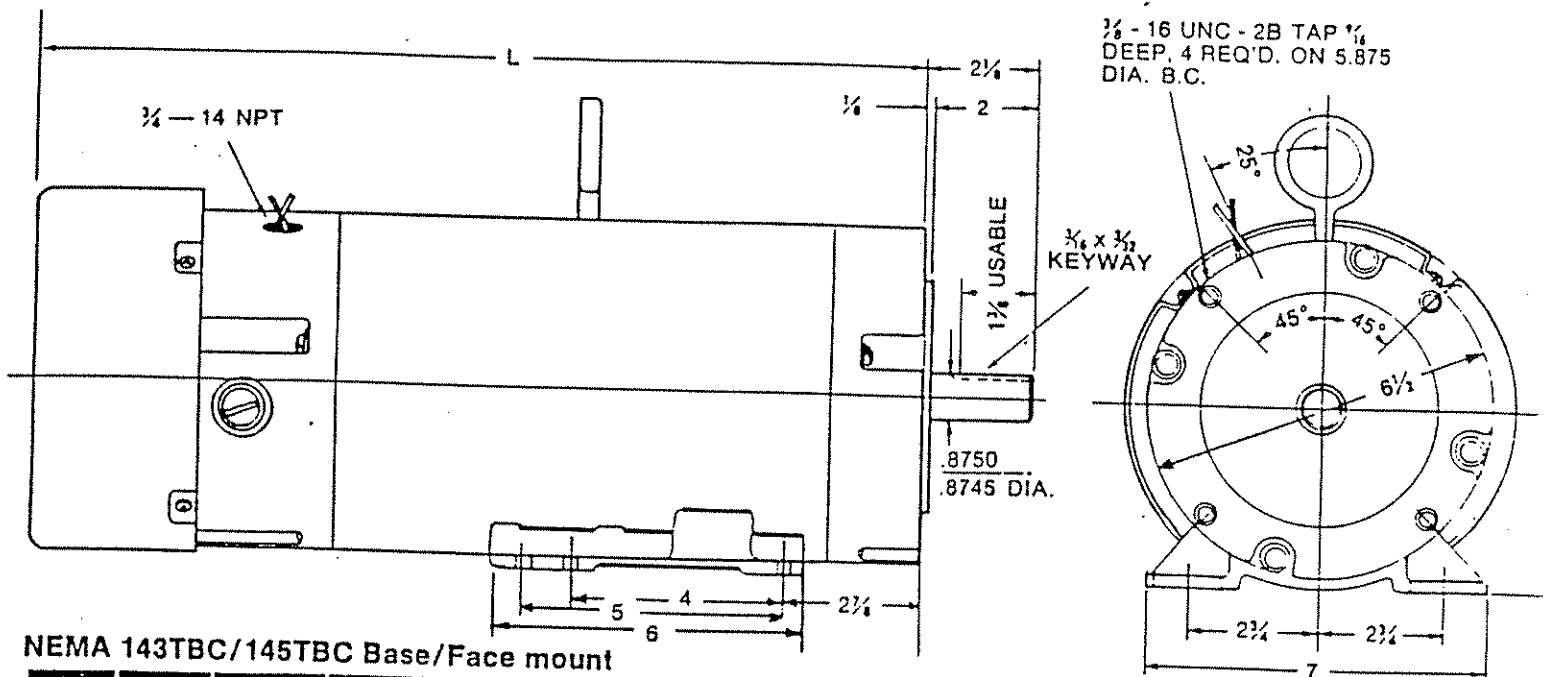


850DM 2 SPEED DC
 MOTOR CONTROL BOARD

APPENDIX 2

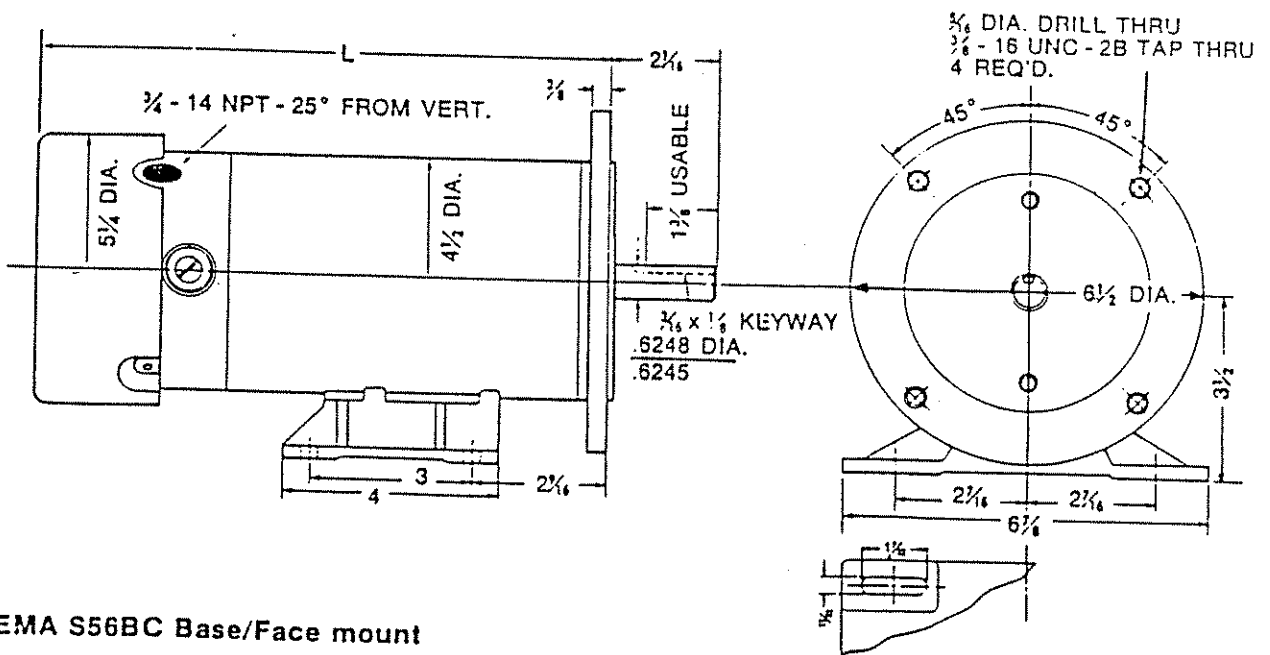
Motor dimensions

TEFC P/M motor



NEMA 143TBC/145TBC Base/Face mount

H.P.	RPM	VOLTS	AMPS	L	DUTY
1.5	1800	180	8.2	15 1/2	CONT.
2	1800	180	11.6	16 1/2	CONT.



NEMA S56BC Base/Face mount

180 V.

H.P.	RPM	VOLTS	AMPS	L	DUTY
1/2	1725	180	2.8	10 3/4	CONT.
3/4	1725	180	3.5	12 3/4	CONT.
1	1725	180	5.35	14 3/4	CONT.

90 V.

H.P.	RPM	VOLTS	AMPS	L	DUTY
1/2	1725	90	5.35	10 3/4	CONT.
3/4	1725	90	8.1	12 3/4	CONT.
1	1725	90	10.6	14 3/4	CONT.

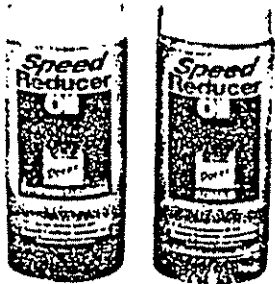
Lubrication

REDUCERS MAY BE FILLED TO THE PROPER LEVEL AT THE FACTORY WITH AGMA No. 8 compounded oil. AFTER INSTALLATION OF THE BREATHER PLUG, UNIT IS READY FOR USE.

Before installing breather plug, refer to instruction tag and determine proper position according to reducer mounting.

We recommend an initial oil change after 250 hours of operation, then every six months or every 2500 hours of service under Class I Service. If fluctuating temperatures, humid, dirty or corrosive environment, oil changes should be made more frequently. Frequency can be established by oil sample analysis.

KEEP YOUR OIL CLEAN



Doerr Electric replacement oil

To order oil, request:

Doerr part no. 00019001 — synthetic AGMA #7EP
(-40°F to 150°F)

Doerr part no. 00019101 — AGMA #8 (50°F to 125°F)

Oil is packed 12 one quart bottles per carton, minimum ship one carton.

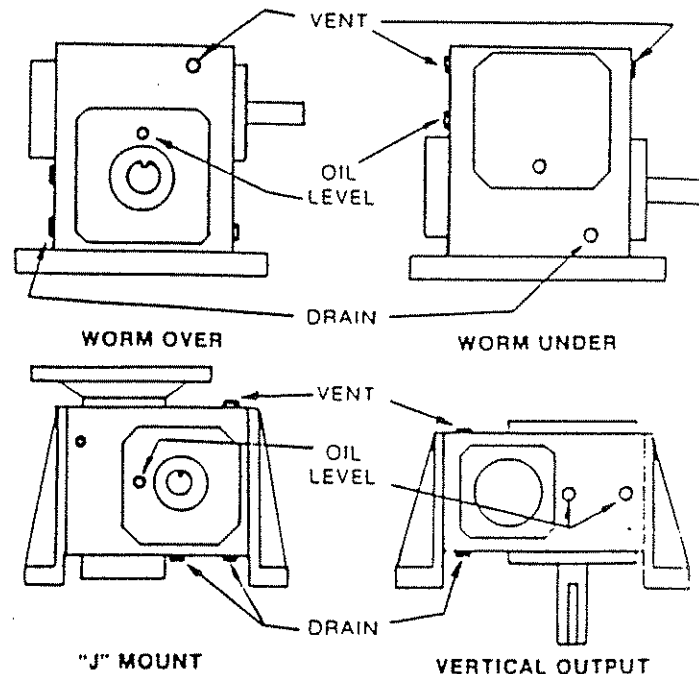
Contact DEC Service Dept. for order information.

OIL CAPACITIES*

UNIT TYPE	UNIT SERIES			
	133	175	200	262
Worm Over	14	20	27	49
Worm Under	17	22	28	49
Vertical Output	10	15	20	37
"J" Mount	13	18	23	38

*Capacities in approximate ounces. On double reduction units determine capacity of both primary and secondary reducers.

OIL LEVELS*



*On double reduction units fill and vent each unit to levels shown.

RSLogix 500 Project Report



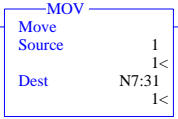
LOADING INITIAL VALUES. (HL55:HL66)-13 (C1-96T); "V13.0"; JOB# STD.; DWG# 301 785, JAN-07-1999.

0000

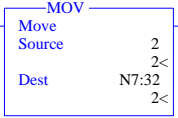
First Pass



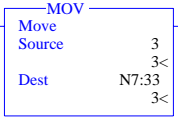
RANGE #1:
1-VALUE=1



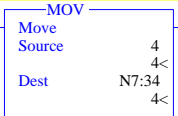
RANGE #1:
2-VALUE=2



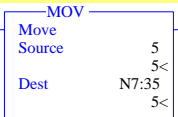
RANGE #1:
3-VALUE=3



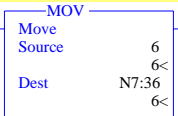
RANGE #2:
1-VALUE=4



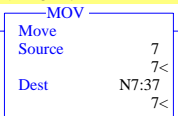
RANGE #2:
2-VALUE=5



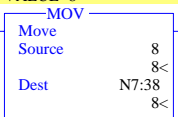
RANGE #2:
3-VALUE=6



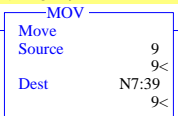
RANGE #3:
1-VALUE=7



RANGE #3:
2-VALUE=8



RANGE #9:
3-VALUE=9



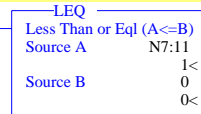
INITIAL LOADING OF RANGE #1 VALUES FOR TOP & BOTTOM WRAPS COUNTERS PARAMETERS.

0001

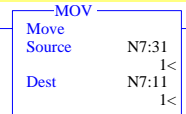
First Pass

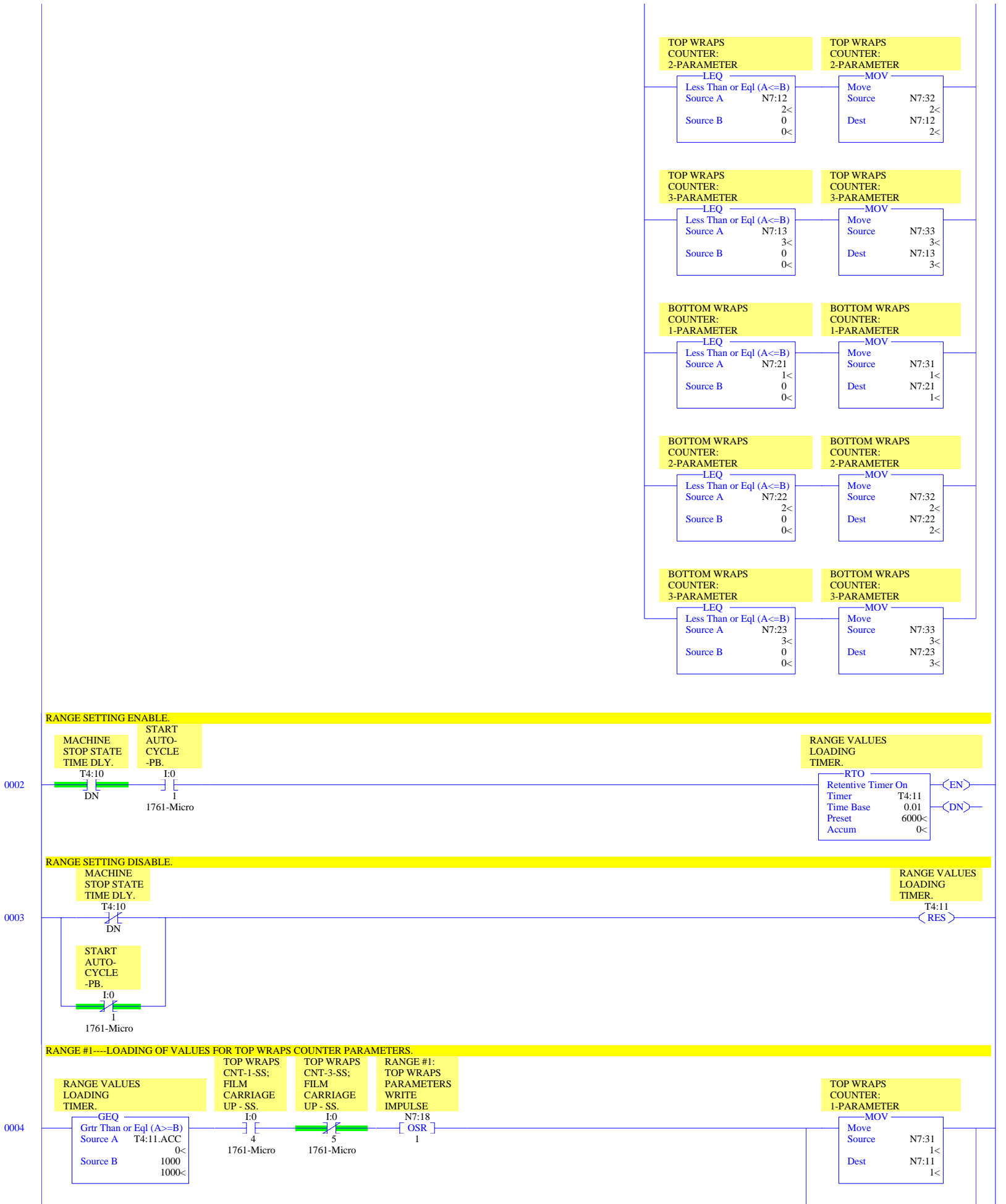


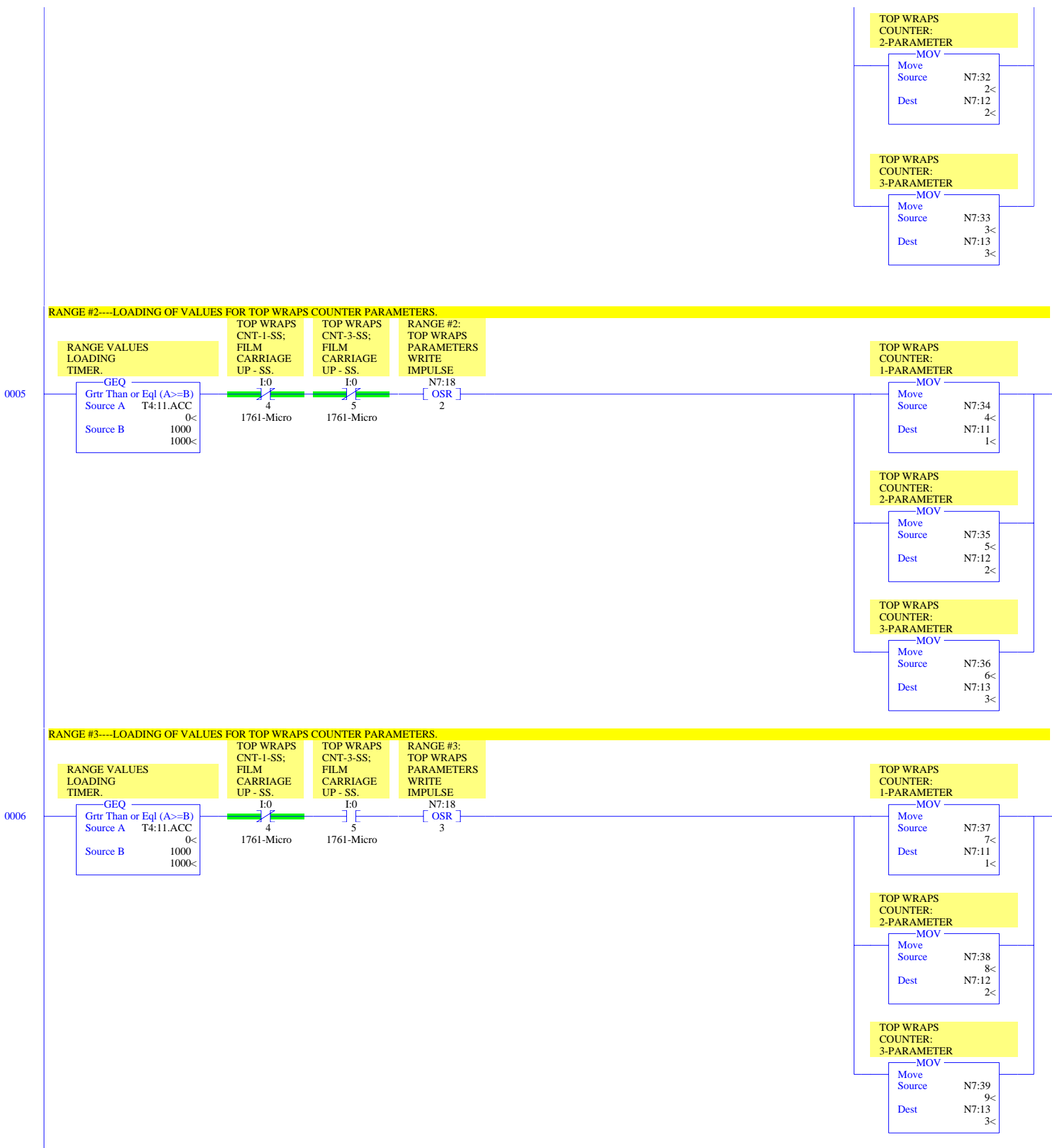
TOP WRAPS
COUNTER:
1-PARAMETER

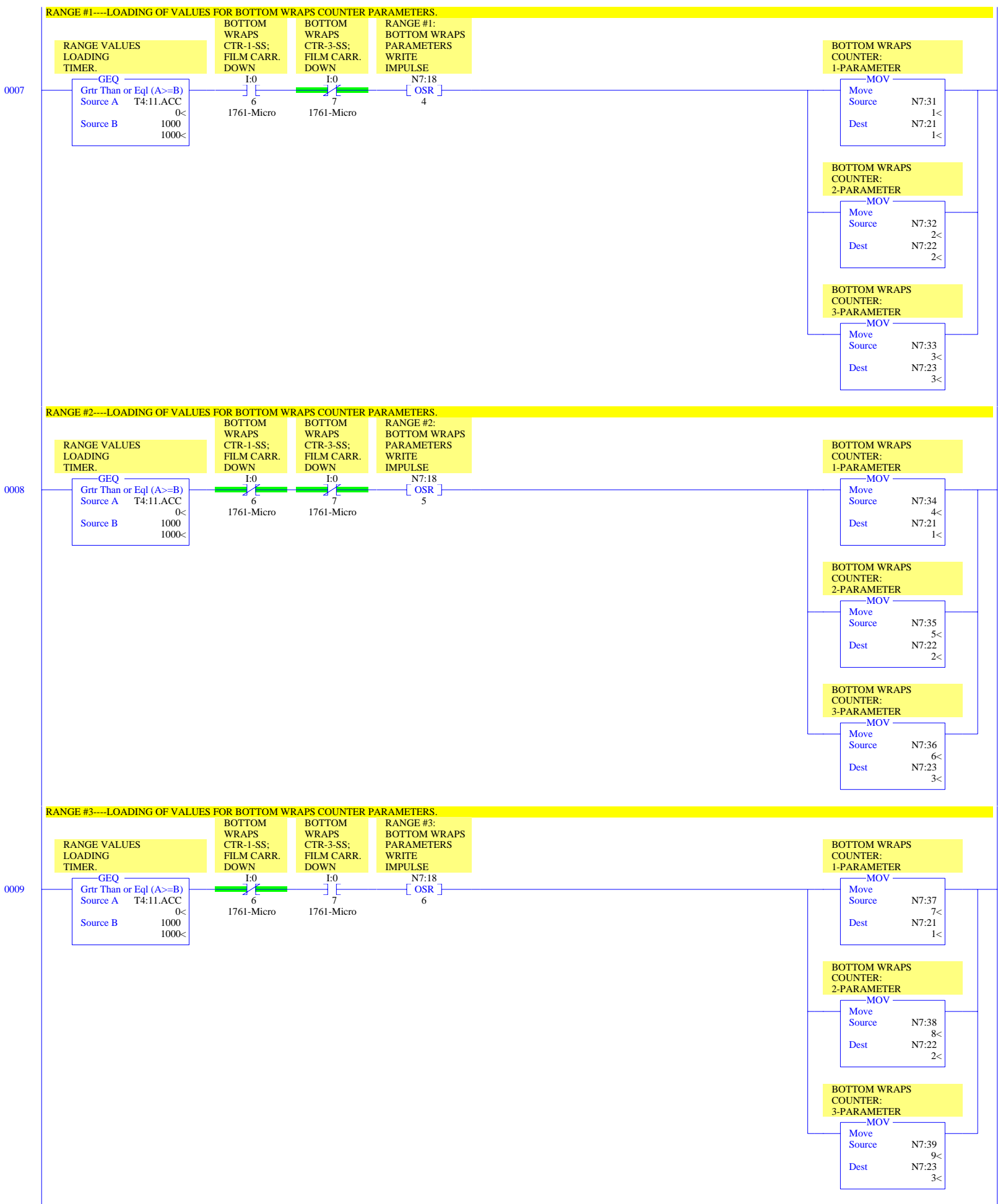


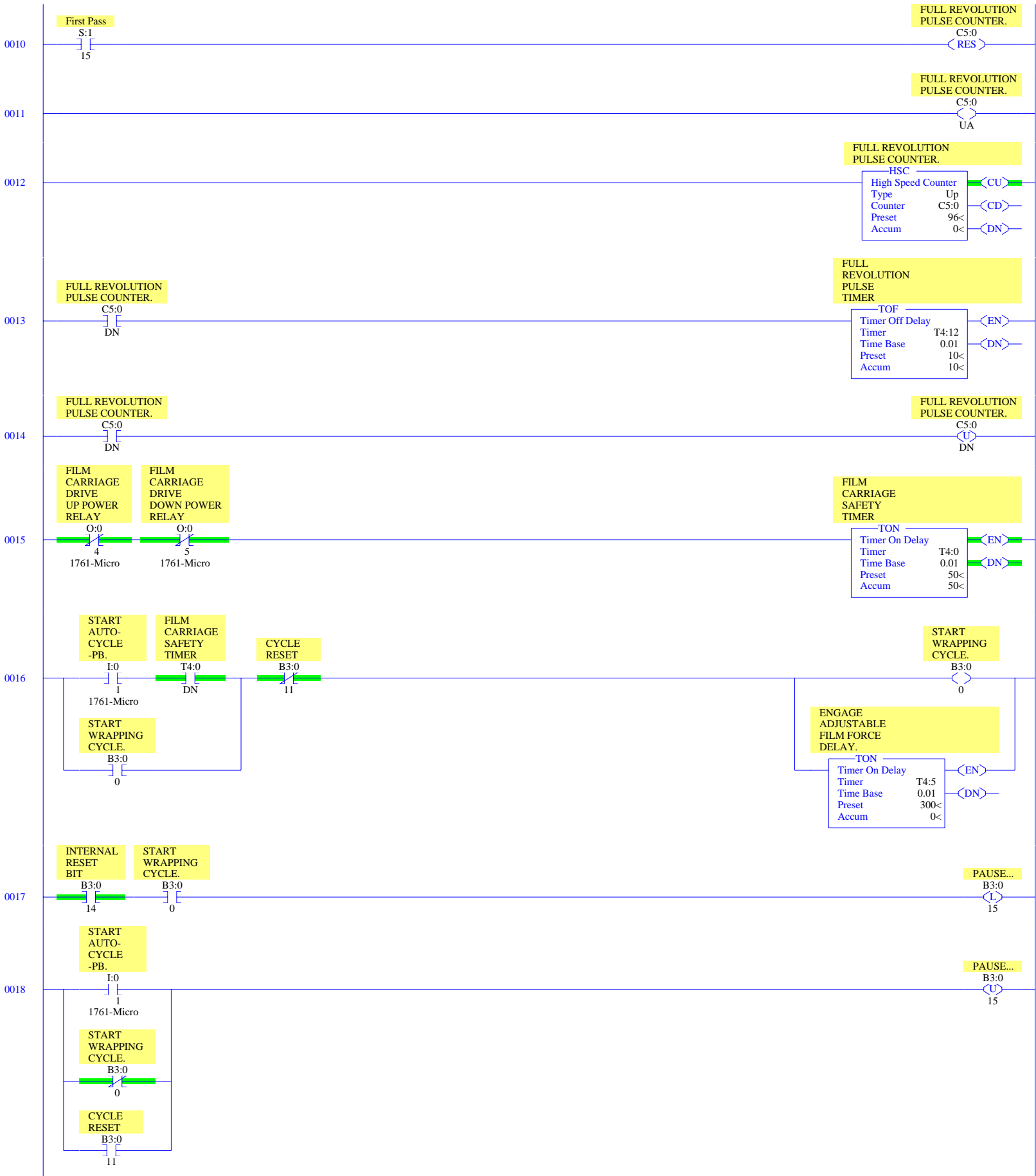
TOP WRAPS
COUNTER:
1-PARAMETER

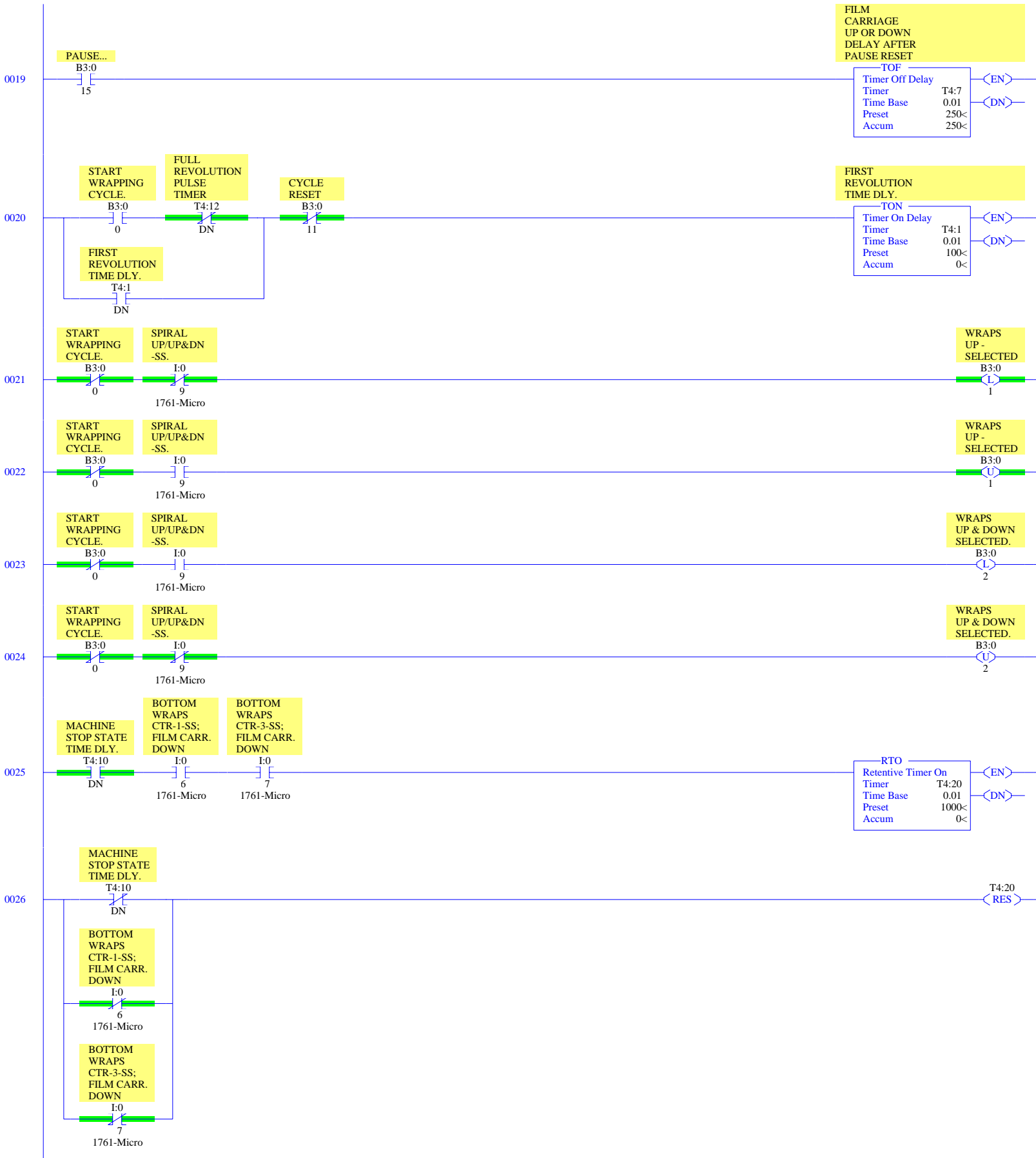


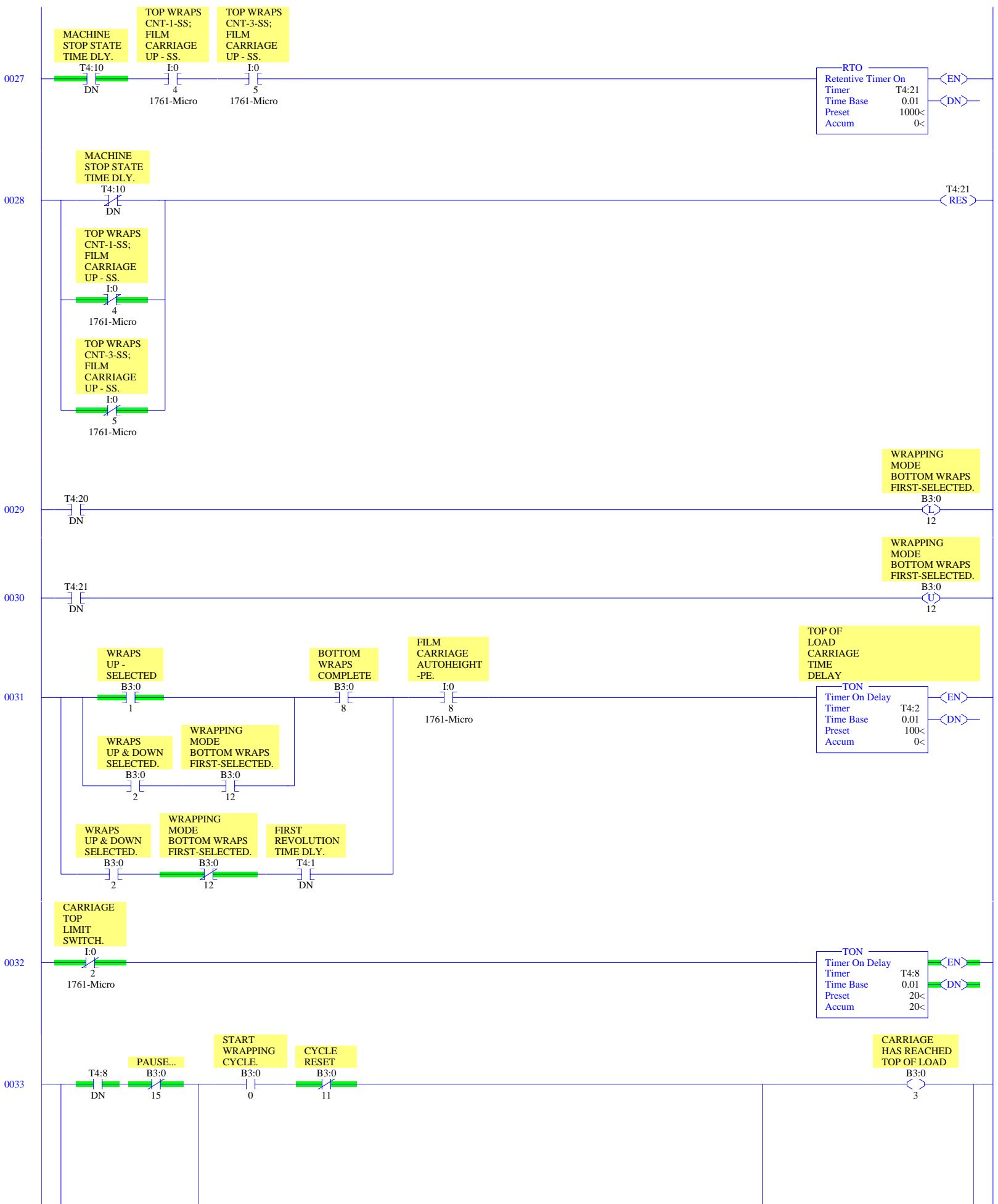


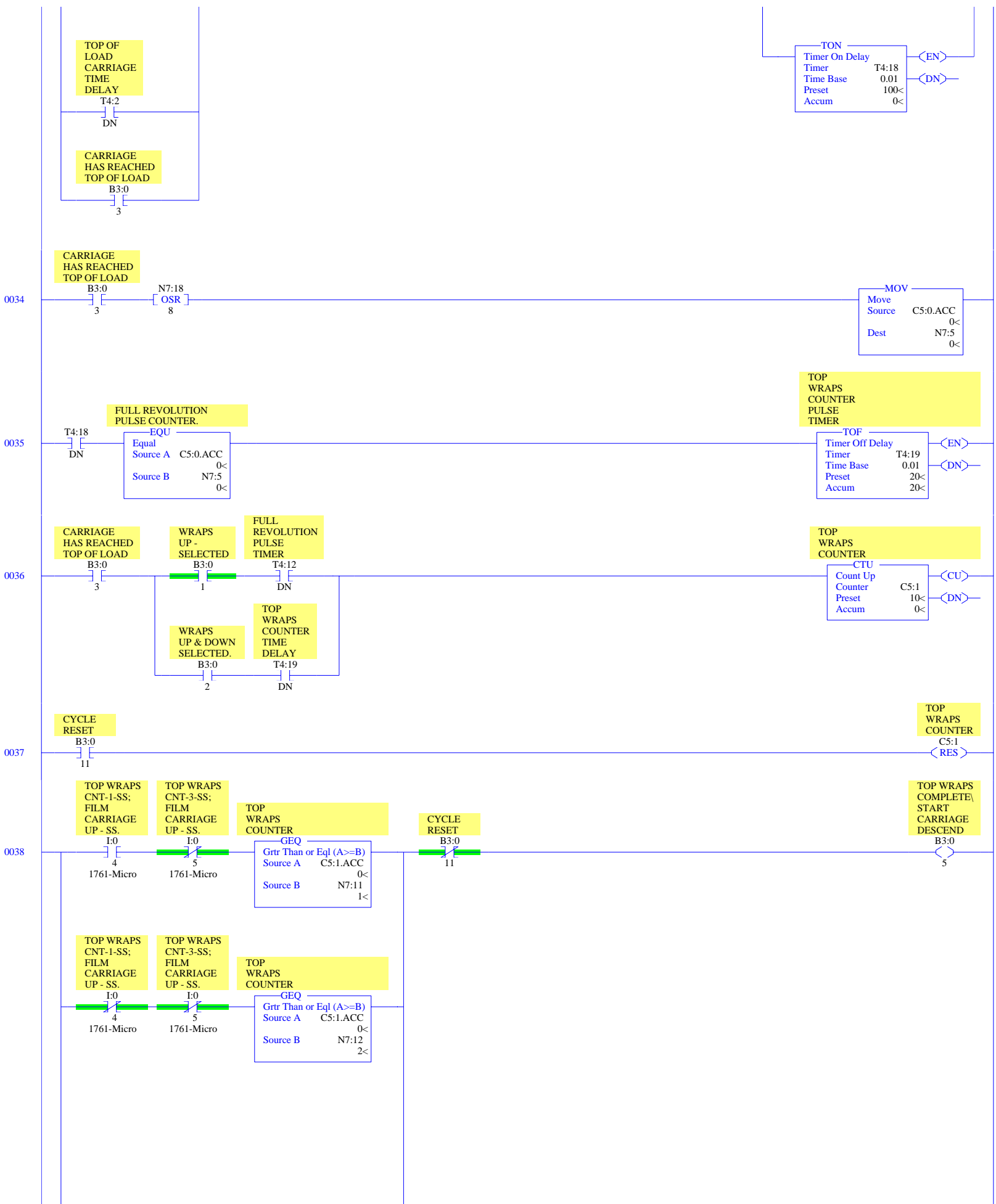


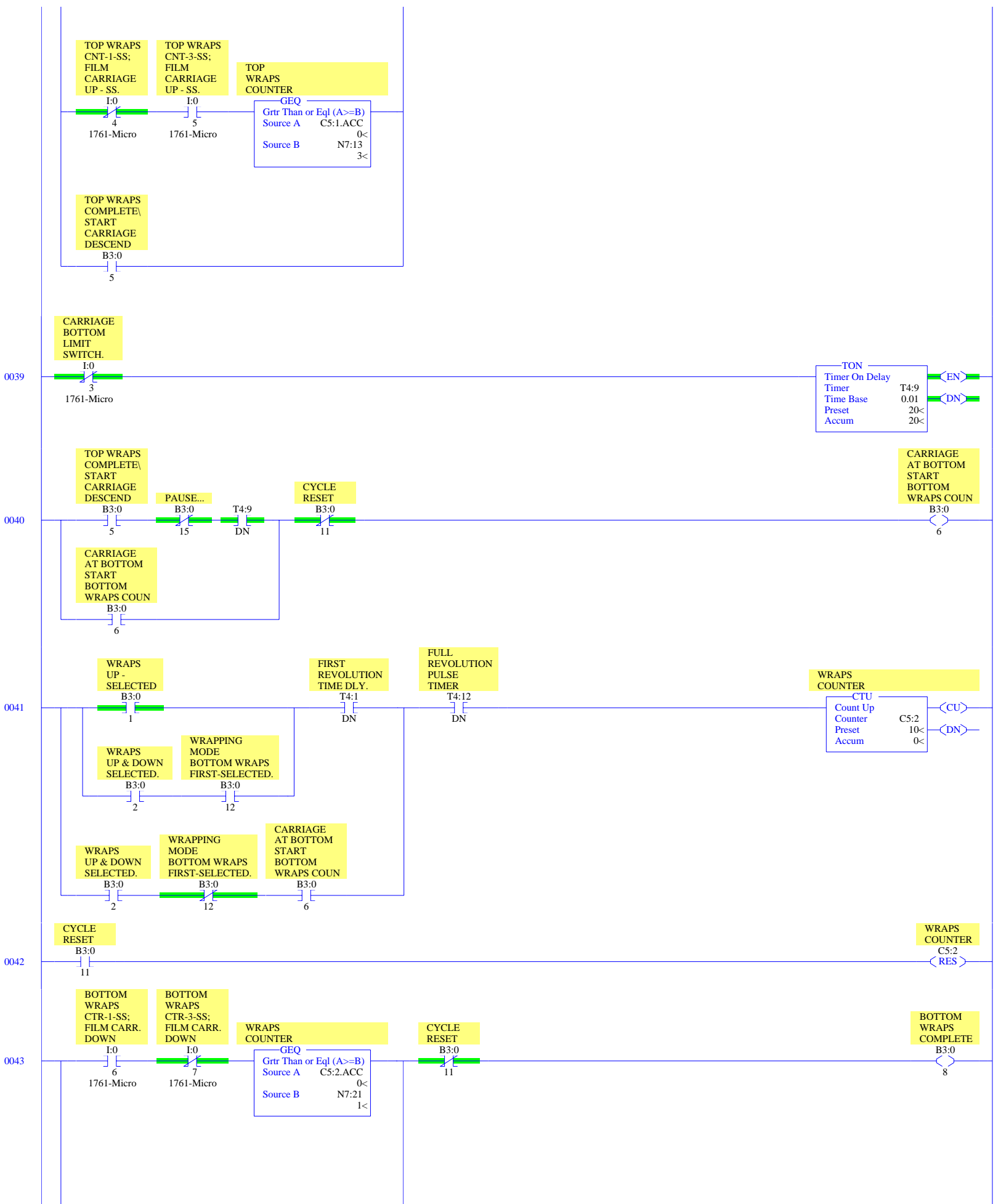


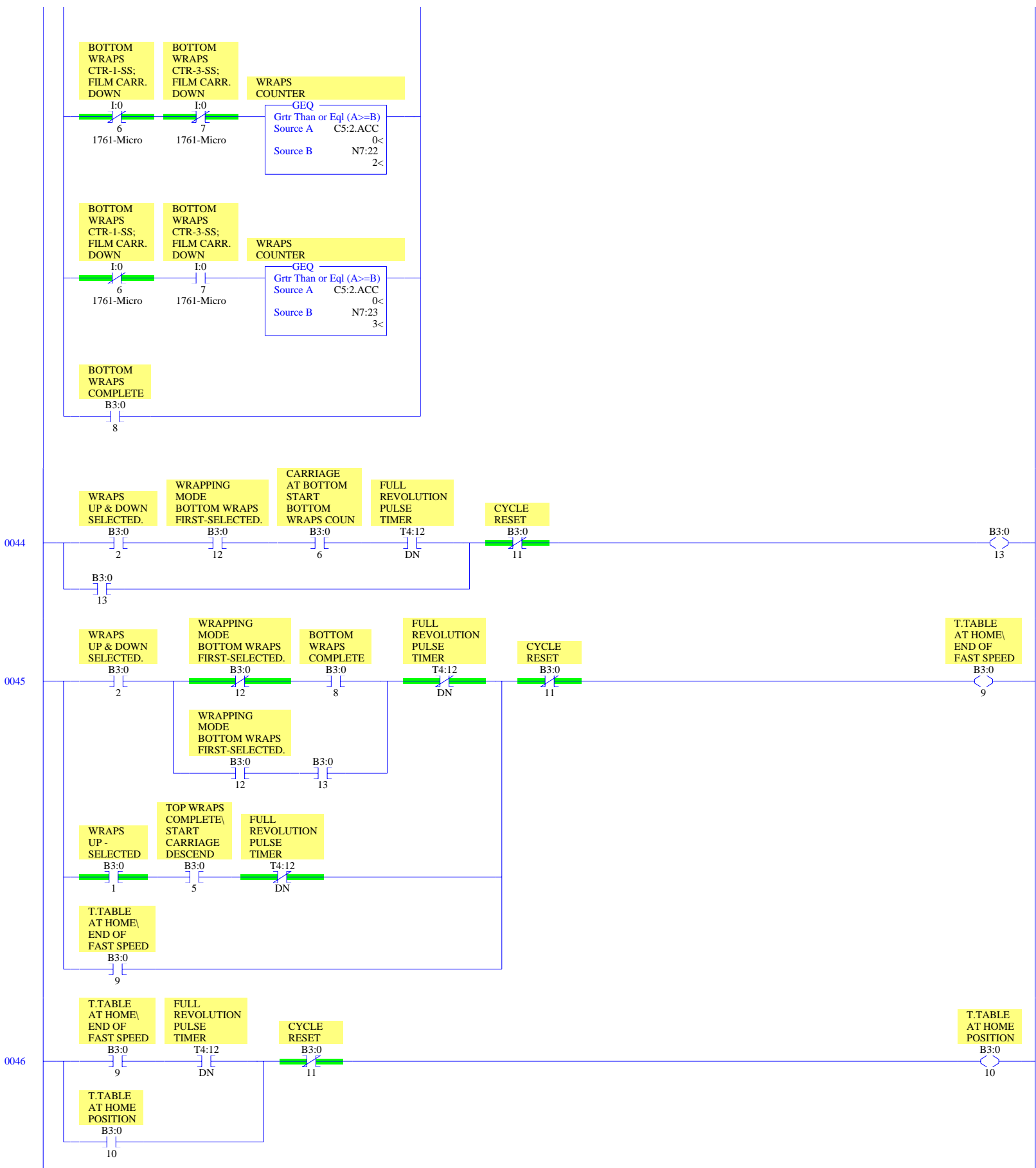


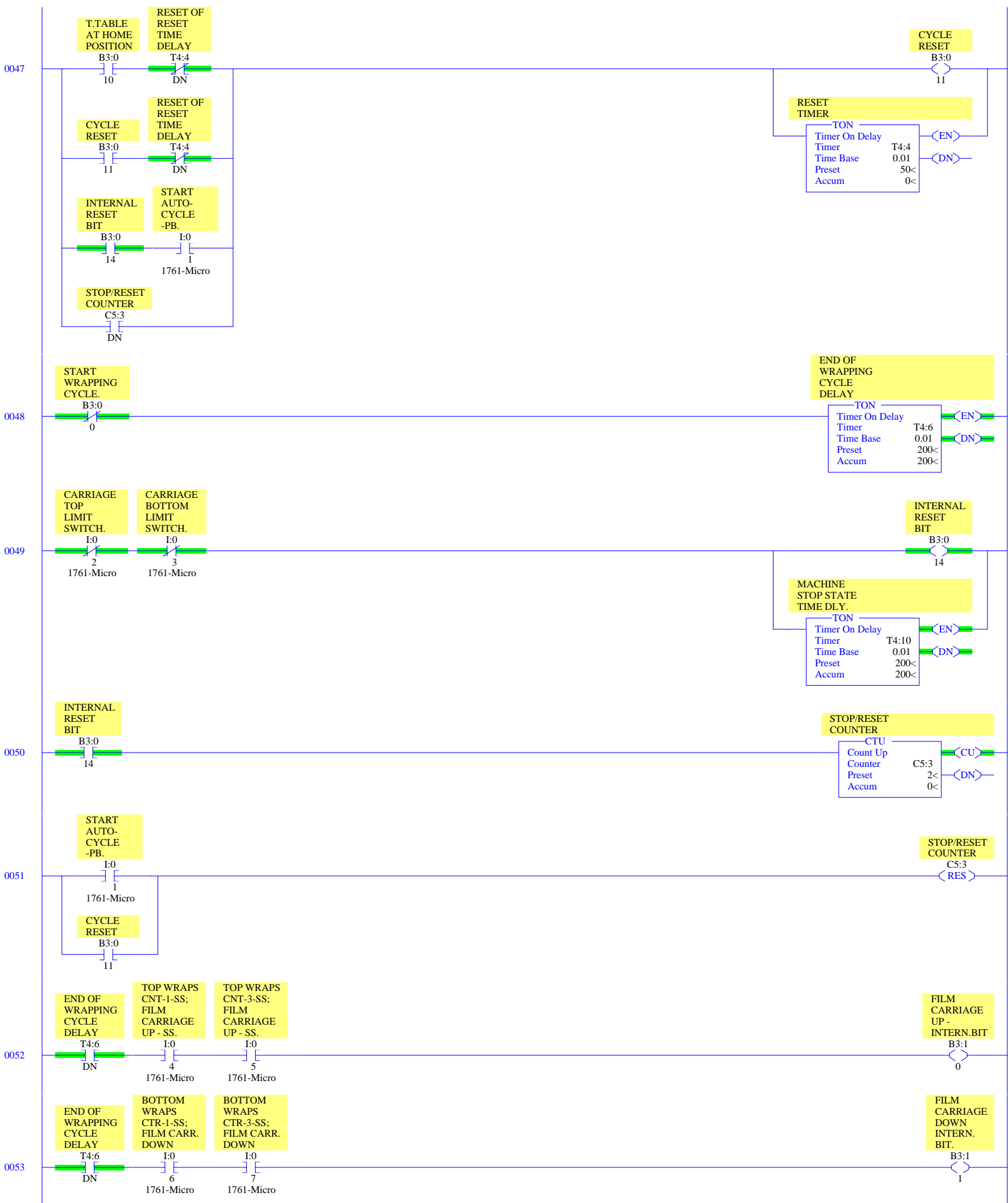


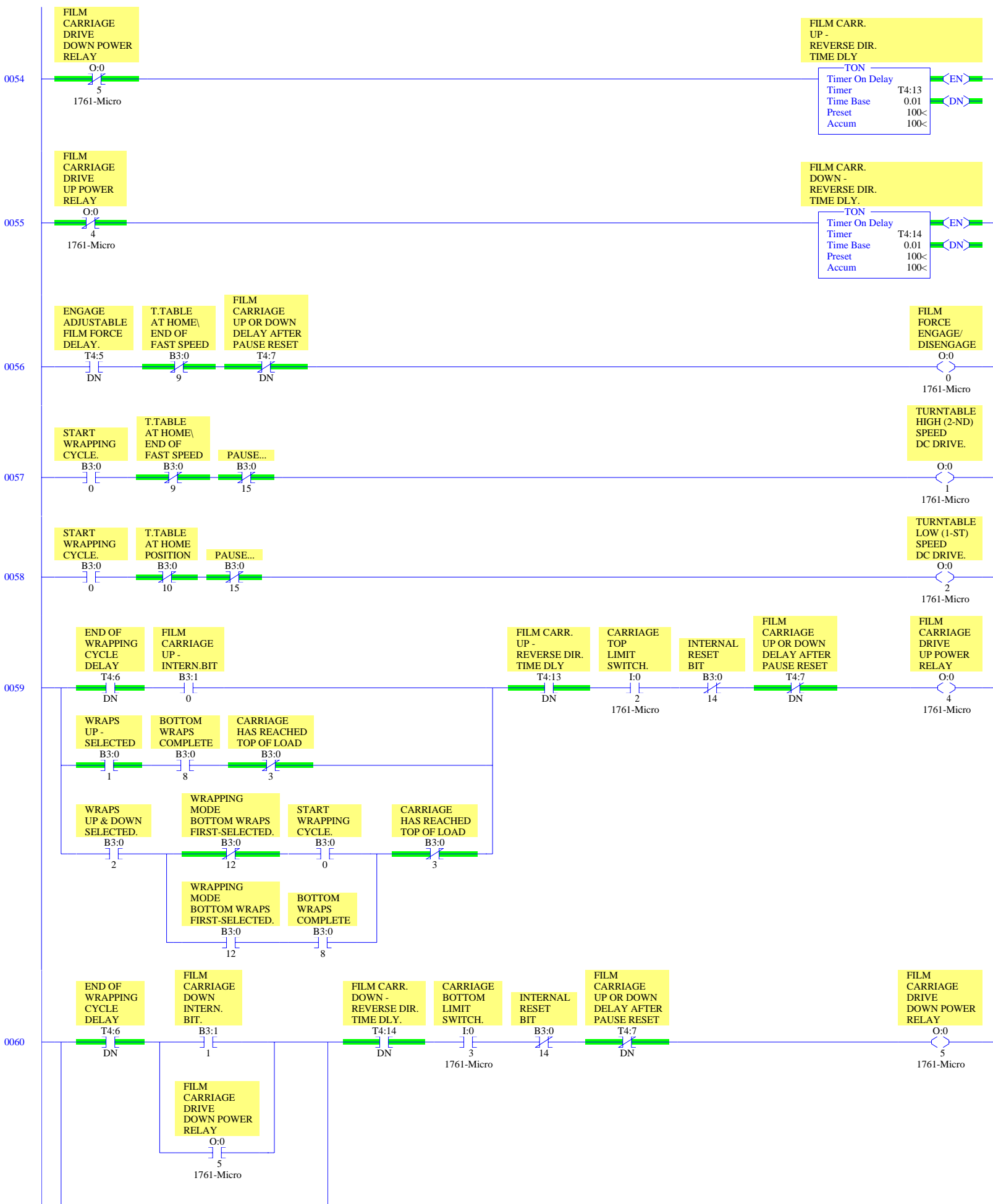


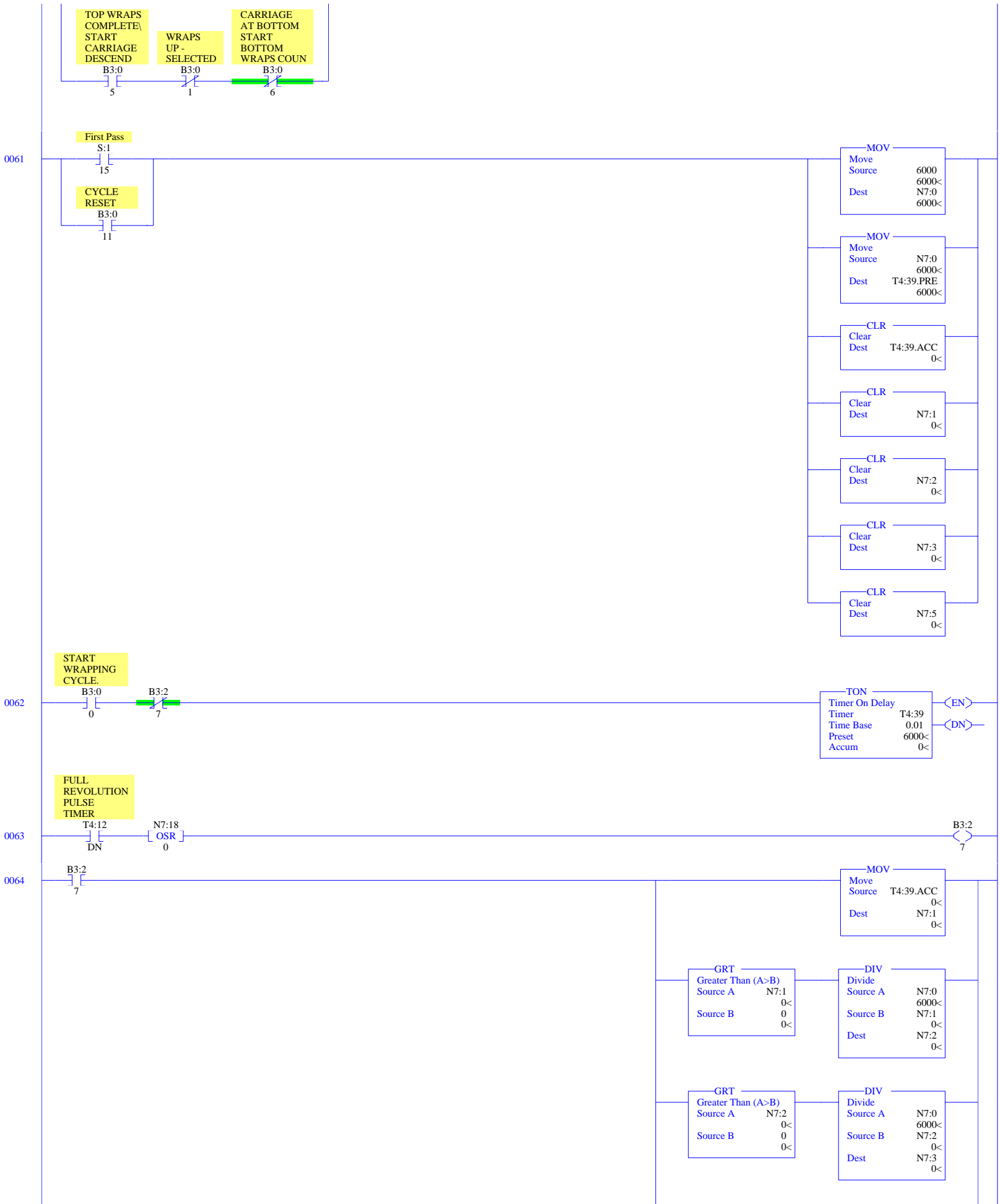














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RSLogix 500 Cross Reference Report - Sorted by Address

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O:0/0      - FILM FORCE ENGAGE/ DISENGAGE
            OTE - File #2 - 56
O:0/1      - TURNTABLE HIGH (2-ND) SPEED      DC DRIVE.
            OTE - File #2 - 57
O:0/2      - TURNTABLE LOW (1-ST)  SPEED DC DRIVE.
            OTE - File #2 - 58
O:0/4      - FILM      CARRIAGE  DRIVE UP POWER RELAY
            OTE - File #2 - 59
            XIO - File #2 - 15, 55
O:0/5      - FILM      CARRIAGE  DRIVE  DOWN POWER RELAY
            OTE - File #2 - 60
            XIC - File #2 - 60
            XIO - File #2 - 15, 54
I:0/1      - START      AUTO-      CYCLE      -PB.
            XIC - File #2 - 2, 16, 18, 47, 51
            XIO - File #2 - 3
I:0/2      - CARRIAGE  TOP      LIMIT      SWITCH.
            XIC - File #2 - 59
            XIO - File #2 - 32, 49
I:0/3      - CARRIAGE  BOTTOM    LIMIT      SWITCH.
            XIC - File #2 - 60
            XIO - File #2 - 39, 49
I:0/4      - TOP WRAPS CNT-1-SS; FILM      CARRIAGE  UP - SS.
            XIC - File #2 - 4, 27, 38, 52
            XIO - File #2 - 5, 6, 28, 38
I:0/5      - TOP WRAPS CNT-3-SS; FILM      CARRIAGE  UP - SS.
            XIC - File #2 - 6, 27, 38, 52
            XIO - File #2 - 4, 5, 28, 38
I:0/6      - BOTTOM     WRAPS      CTR-1-SS; FILM CARR. DOWN
            XIC - File #2 - 7, 25, 43, 53
            XIO - File #2 - 8, 9, 26, 43
I:0/7      - BOTTOM     WRAPS      CTR-3-SS; FILM CARR. DOWN
            XIC - File #2 - 9, 25, 43, 53
            XIO - File #2 - 7, 8, 26, 43
I:0/8      - FILM      CARRIAGE  AUTOHEIGHT -PE.
            XIC - File #2 - 31
I:0/9      - SPIRAL UP/UP&DN  -SS.
            XIC - File #2 - 22, 23
            XIO - File #2 - 21, 24
S:1/15     - First Pass
            XIC - File #2 - 0, 1, 10, 61
S:5/0      - Overflow Trap
            OTU - File #2 - 64
B3/0       - START WRAPPING  CYCLE.
            OTE - File #2 - 16
            XIC - File #2 - 16, 17, 20, 33, 57, 58, 59, 62
            XIO - File #2 - 18, 21, 22, 23, 24, 48
B3/1       - WRAPS UP - SELECTED
            OTL - File #2 - 21
            OTU - File #2 - 22
            XIC - File #2 - 31, 36, 41, 45, 59
            XIO - File #2 - 60
B3/2       - WRAPS UP & DOWN  SELECTED.
            OTL - File #2 - 23
            OTU - File #2 - 24
            XIC - File #2 - 31, 36, 41, 44, 45, 59
B3/3       - CARRIAGE HAS REACHED TOP OF LOAD
            OTE - File #2 - 33
            XIC - File #2 - 33, 34, 36
            XIO - File #2 - 59
B3/5       - TOP WRAPS COMPLETE\ START CARRIAGE DESCEND
            OTE - File #2 - 38
            XIC - File #2 - 38, 40, 45, 60
B3/6       - CARRIAGE AT BOTTOM START BOTTOM WRAPS COUN
            OTE - File #2 - 40
            XIC - File #2 - 40, 41, 44
            XIO - File #2 - 60
B3/8       - BOTTOM WRAPS COMPLETE
            OTE - File #2 - 43

```


RSLogix 500 Cross Reference Report - Sorted by Address

```

B3/9      - XIC - File #2 - 31, 43, 45, 59
           - T.TABLE AT HOME\ END OF FAST SPEED
           OTE - File #2 - 45
           XIC - File #2 - 45, 46
           XIO - File #2 - 56, 57
B3/10     - T.TABLE AT HOME POSITION
           OTE - File #2 - 46
           XIC - File #2 - 46, 47
           XIO - File #2 - 58
B3/11     - CYCLE      RESET
           OTE - File #2 - 47
           XIC - File #2 - 18, 37, 42, 47, 51, 61
           XIO - File #2 - 16, 20, 33, 38, 40, 43, 44, 45, 46
B3/12     - WRAPPING MODE BOTTOM WRAPS FIRST-SELECTED.
           OTL - File #2 - 29
           OTU - File #2 - 30
           XIC - File #2 - 31, 41, 44, 45, 59
           XIO - File #2 - 31, 41, 45, 59
B3/13     - OTE - File #2 - 44
           XIC - File #2 - 44, 45
B3/14     - INTERNAL RESET BIT
           OTE - File #2 - 49
           XIC - File #2 - 17, 47, 50
           XIO - File #2 - 59, 60
B3/15     - PAUSE...
           OTL - File #2 - 17
           OTU - File #2 - 18
           XIC - File #2 - 19
           XIO - File #2 - 33, 40, 57, 58
B3/16     - FILM CARRIAGE UP - INTERN.BIT
           OTE - File #2 - 52
           XIC - File #2 - 59
B3/17     - FILM CARRIAGE DOWN INTERN. BIT.
           OTE - File #2 - 53
           XIC - File #2 - 60
B3/39     - OTE - File #2 - 63
           XIC - File #2 - 64
           XIO - File #2 - 62
T4:0      - FILM CARRIAGE SAFETY TIMER
           TON - File #2 - 15
T4:0/DN   - XIC - File #2 - 16
T4:1      - FIRST REVOLUTION TIME DLY.
           TON - File #2 - 20
T4:1/DN   - XIC - File #2 - 20, 31, 41
T4:2      - TOP OF LOAD CARRIAGE TIME DELAY
           TON - File #2 - 31
T4:2/DN   - TOP OF LOAD CARRIAGE TIME DELAY
           XIC - File #2 - 33
T4:4      - RESET TIMER
           TON - File #2 - 47
T4:4/DN   - RESET OF RESET TIME DELAY
           XIO - File #2 - 47
T4:5      - ENGAGE ADJUSTABLE FILM FORCE DELAY.
           TON - File #2 - 16
T4:5/DN   - XIC - File #2 - 56
T4:6      - END OF WRAPPING CYCLE DELAY
           TON - File #2 - 48
T4:6/DN   - XIC - File #2 - 52, 53, 59, 60
T4:7      - FILM CARRIAGE UP OR DOWN DELAY AFTER PAUSE RESET
           TOF - File #2 - 19
T4:7/DN   - XIO - File #2 - 56, 59, 60
T4:8      - TON - File #2 - 32
T4:8/DN   - XIC - File #2 - 33
T4:9      - TON - File #2 - 39
T4:9/DN   - XIC - File #2 - 40
T4:10     - MACHINE STOP STATE TIME DLY.
           TON - File #2 - 49
T4:10/DN  - XIC - File #2 - 2, 25, 27
           XIO - File #2 - 3, 26, 28

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RSLogix 500 Cross Reference Report - Sorted by Address

```

T4:11      - RANGE VALUES LOADING TIMER.
            RTO - File #2 - 2
            RES - File #2 - 3
T4:11.ACC  - GEQ - File #2 - 4, 5, 6, 7, 8, 9
T4:12      - FULL REVOLUTION PULSE TIMER
            TOF - File #2 - 13
T4:12/DN   - XIC - File #2 - 36, 41, 44, 46, 63
            XIO - File #2 - 20, 45
T4:13      - FILM CARR. UP - REVERSE DIR. TIME DLY
            TON - File #2 - 54
T4:13/DN   - XIC - File #2 - 59
T4:14      - FILM CARR. DOWN - REVERSE DIR. TIME DLY.
            TON - File #2 - 55
T4:14/DN   - XIC - File #2 - 60
T4:18      - TON - File #2 - 33
T4:18/DN   - XIC - File #2 - 35
T4:19      - TOP WRAPS COUNTER PULSE TIMER
            TOF - File #2 - 35
T4:19/DN   - TOP WRAPS COUNTER TIME DELAY
            XIC - File #2 - 36
T4:20      - RTO - File #2 - 25
            RES - File #2 - 26
T4:20/DN   - XIC - File #2 - 29
T4:21      - RTO - File #2 - 27
            RES - File #2 - 28
T4:21/DN   - XIC - File #2 - 30
T4:39      - TON - File #2 - 62
T4:39.PRE  - MOV - File #2 - 61
T4:39.ACC  - CLR - File #2 - 61
            MOV - File #2 - 64
C5:0       - FULL REVOLUTION PULSE COUNTER.
            RES - File #2 - 10
            HSC - File #2 - 12
C5:0/UA    - OTE - File #2 - 11
C5:0/DN    - OTU - File #2 - 14
            XIC - File #2 - 13, 14
C5:0.ACC   - MOV - File #2 - 34
            EQU - File #2 - 35
C5:1       - TOP WRAPS COUNTER
            CTU - File #2 - 36
            RES - File #2 - 37
C5:1.ACC   - GEQ - File #2 - 38
C5:2       - WRAPS COUNTER
            CTU - File #2 - 41
            RES - File #2 - 42
C5:2.ACC   - GEQ - File #2 - 43
C5:3       - STOP/RESET COUNTER
            CTU - File #2 - 50
            RES - File #2 - 51
C5:3/DN    - XIC - File #2 - 47
N7:0       - MOV - File #2 - 61
            DIV - File #2 - 64
N7:1       - CLR - File #2 - 61
            MOV - File #2 - 64
            DIV - File #2 - 64
            GRT - File #2 - 64
N7:2       - CLR - File #2 - 61
            DIV - File #2 - 64
            GRT - File #2 - 64
N7:3       - CLR - File #2 - 61
            DIV - File #2 - 64
N7:5       - CLR - File #2 - 61
            MOV - File #2 - 34
            EQU - File #2 - 35
N7:11      - TOP WRAPS COUNTER: 1-PARAMETER
            MOV - File #2 - 1, 4, 5, 6
            GEQ - File #2 - 38
            LEQ - File #2 - 1
N7:12      - TOP WRAPS COUNTER: 2-PARAMETER

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RSLogix 500 Cross Reference Report - Sorted by Address

```

MOV - File #2 - 1, 4, 5, 6
GEQ - File #2 - 38
LEQ - File #2 - 1
N7:13 - TOP WRAPS COUNTER: 3-PARAMETER
MOV - File #2 - 1, 4, 5, 6
GEQ - File #2 - 38
LEQ - File #2 - 1
N7:18/0 - OSR - File #2 - 63
N7:18/1 - RANGE #1: TOP WRAPS PARAMETERS WRITE IMPULSE
OSR - File #2 - 4
N7:18/2 - RANGE #2: TOP WRAPS PARAMETERS WRITE IMPULSE
OSR - File #2 - 5
N7:18/3 - RANGE #3: TOP WRAPS PARAMETERS WRITE IMPULSE
OSR - File #2 - 6
N7:18/4 - RANGE #1: BOTTOM WRAPS PARAMETERS WRITE IMPULSE
OSR - File #2 - 7
N7:18/5 - RANGE #2: BOTTOM WRAPS PARAMETERS WRITE IMPULSE
OSR - File #2 - 8
N7:18/6 - RANGE #3: BOTTOM WRAPS PARAMETERS WRITE IMPULSE
OSR - File #2 - 9
N7:18/8 - OSR - File #2 - 34
N7:21 - BOTTOM WRAPS COUNTER: 1-PARAMETER
MOV - File #2 - 1, 7, 8, 9
GEQ - File #2 - 43
LEQ - File #2 - 1
N7:22 - BOTTOM WRAPS COUNTER: 2-PARAMETER
MOV - File #2 - 1, 7, 8, 9
GEQ - File #2 - 43
LEQ - File #2 - 1
N7:23 - BOTTOM WRAPS COUNTER: 3-PARAMETER
MOV - File #2 - 1, 7, 8, 9
GEQ - File #2 - 43
LEQ - File #2 - 1
N7:31 - RANGE #1: 1-VALUE=1
MOV - File #2 - 0, 1, 4, 7
N7:32 - RANGE #1: 2-VALUE=2
MOV - File #2 - 0, 1, 4, 7
N7:33 - RANGE #1: 3-VALUE=3
MOV - File #2 - 0, 1, 4, 7
N7:34 - RANGE #2: 1-VALUE=4
MOV - File #2 - 0, 5, 8
N7:35 - RANGE #2: 2-VALUE=5
MOV - File #2 - 0, 5, 8
N7:36 - RANGE #2: 3-VALUE=6
MOV - File #2 - 0, 5, 8
N7:37 - RANGE #3: 1-VALUE=7
MOV - File #2 - 0, 6, 9
N7:38 - RANGE #3: 2-VALUE=8
MOV - File #2 - 0, 6, 9
N7:39 - RANGE #9: 3-VALUE=9
MOV - File #2 - 0, 6, 9

```