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# INSTRUCTION MANUAL

FOR ALL INQUIRIES  
PLEASE CONTACT  
OUR LOCAL DISTRIBUTOR

FOR U.S. (ONLY)  
1-800-333-6556

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

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

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

**NOTICE:**

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

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

- 1) **MODEL**
- 2) **SERIAL NUMBER**
- 3) **SUBASSEMBLY ( see PART LIST )**

**SAFETY:**

ORION'S stretch wrappers should be operated with caution and common sense as any other industrial equipment. To prevent injury and / or electrical shock, 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 performing any inspection, maintenance or repair work.

**ORION PACKAGING INC.**

## MACHINE UNLOADING INSPECTION & INSTALLATION

### UNLOADING

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

1. Carefully insert the forks into the lifting tubes to the maximum possible depth. Depending on the model, a forklift access may be either at the turntable end of the machine frame, the tower end or both. In case of the mongoose machine or the conveyor, enter the forks under the frame.
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.
  - 2a. On the mongoose machines use the brackets welded on the top part of the machine.
3. Sit the machine down assuring uniform contact with the floor which is necessary to ensure correct and smooth operation.
  - 3a. Mongoose type machines (M66, M67) have to be attached on the bracket or on the stand (collapsible or anchored to the floor). The M55 has it's own supporting frame which allows the machine to stand independently.

### 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 rubber covering on the multistretch 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.

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

- motors and transmissions
- junction boxes
- electrical conduits
- proximity and limit switches
- photocells

3. Check under the turntable (H - series models only) 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 carriage to be sure that it is correctly aligned with the tower and 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 may be connected as specified on the diagrams supplied with the machine.

An electrical diagram is provided with each machine in the envelope attached to the panel box.

## **ASSEMBLY PROCEDURE**

The structural frames of the machine have to be installed on a levelled 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).

Conveyor sections (where applicable) have to be positioned, levelled\*\* and bolted to the floor. Any wiring which has been disconnected to facilitate transport is marked with a number located on the junction box to which the wiring must be reconnected. It allows identification of the proper position of the infeed and outfeed conveyor sections. 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.

**CAUTION:** improper placement and alignment of the conveyor section(s) and/or electric photocells may lead to equipment malfunction and damage.

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

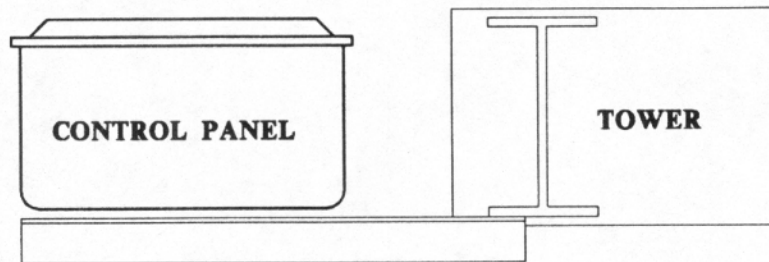
\*\* In the case of the conveyors, the roller deviation from the horizontal must not exceed 1/16 "on the distance 52" (angle: 0 degrees 4').

## CONTROL PANEL

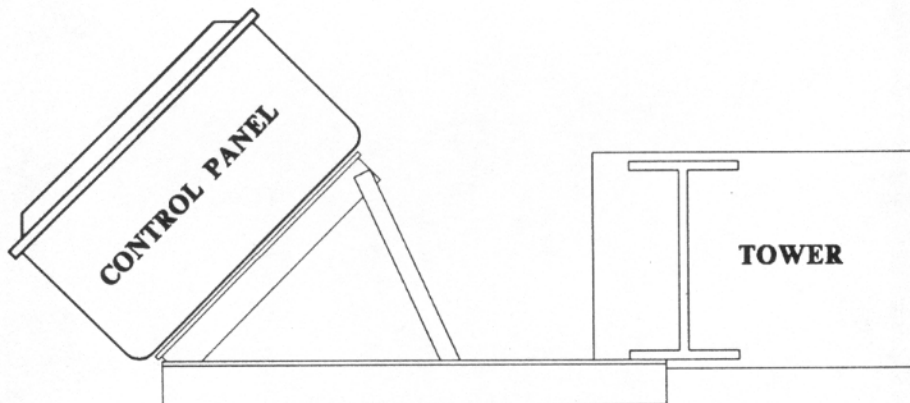
In the case of the free standing panel (console) place it adjacent to the system and anchor firmly to the floor. Connect the liquid tide (rigid conduit) to the main junction box located on the wrapper main frame next to the tower (or tower home position in case of mongoose). The wires must be matched properly on both sides.



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



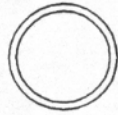
- 1. On the angle brackets aligned to the tower.**



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

## **CONTROL PANEL MOUNT TWO POSITIONS**

**START**

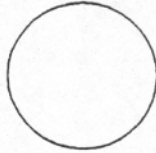


**FILM TENSION**



**orion**<sup>®</sup>

**STOP**



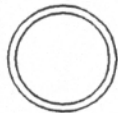
**SPIRAL UP** **UP/DOWN**



**TOP WRAPS**



**TURNTABLE JOG**



**PHOTOCELL OFF** **ON**



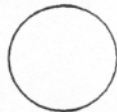
**BOTTOM WRAPS**



**CARRIAGE LOWER** **RAISE**



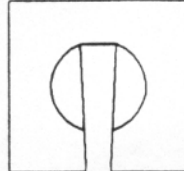
**POWER**



**CARRIAGE SPEED**

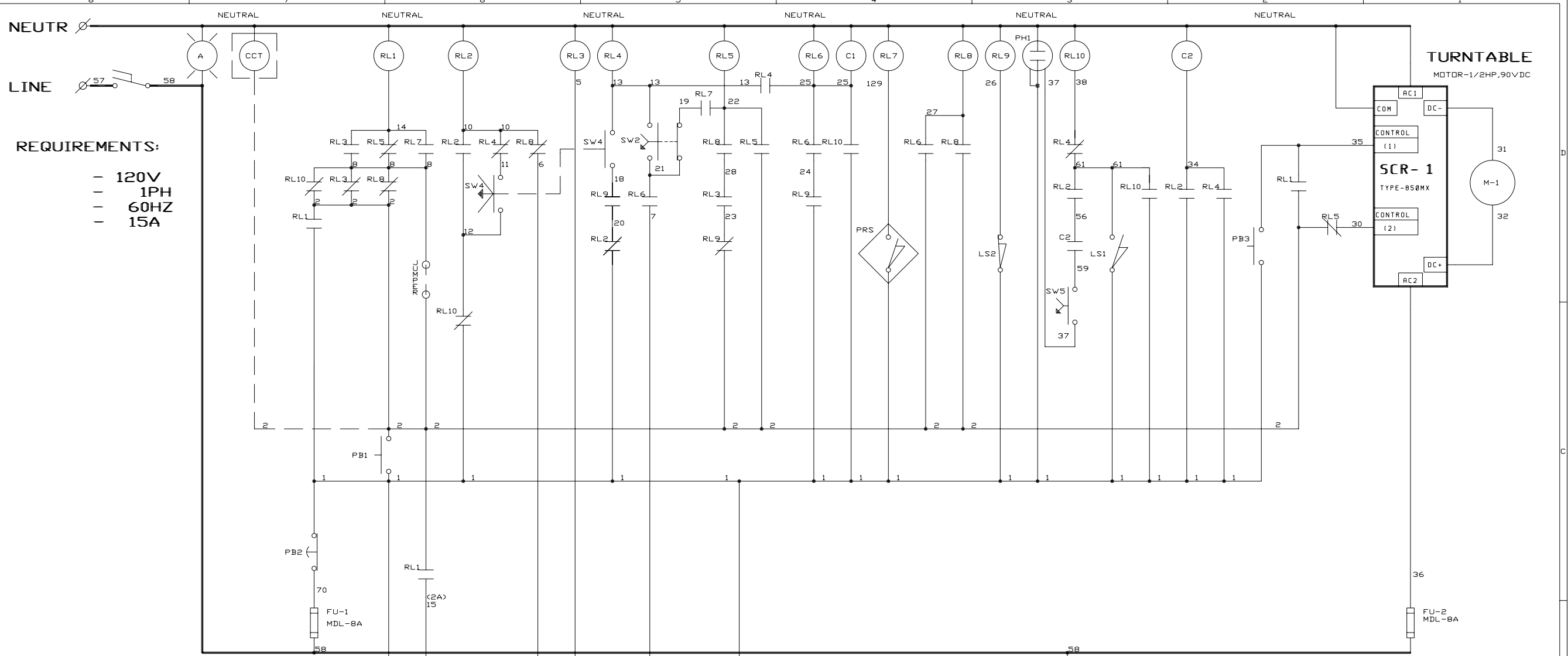


**POWER SWITCH**



**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 PANEL.

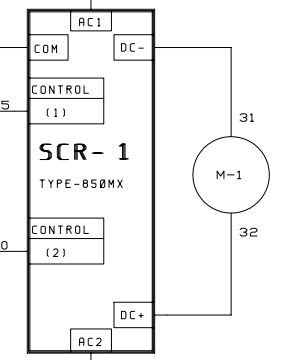
PN-500014



**REQUIREMENTS:**

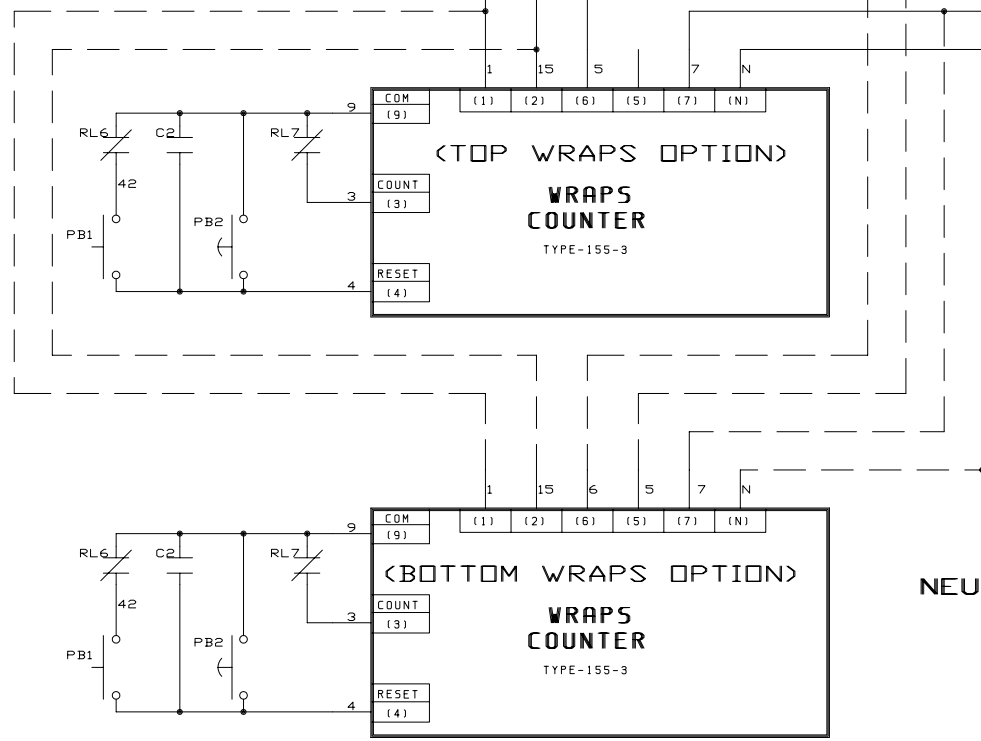
- 120V
- 1PH
- 60HZ
- 15A

**TURNTABLE**  
MOTOR-1/2HP,90VDC

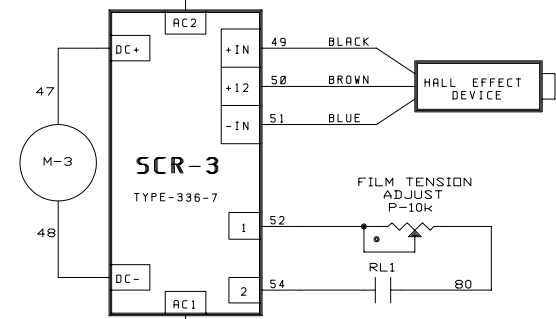


**LEGEND**

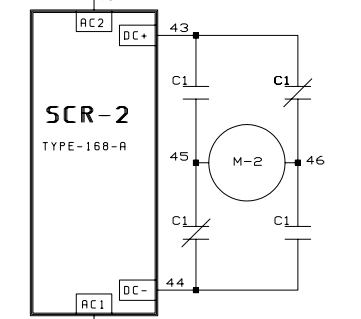
- RL1 AUTOCYCLE START
  - RL2 CARRIAGE UP
  - RL3 FIRST COUNT FROM COUNTER
  - RL4 CARRIAGE DOWN
  - RL5 END OF CYCLE, BEGIN ROTOR DECELERATION
  - RL6 CARRIAGE DOWN
  - RL7 ROTOR PROXIMITY SWITCH
  - RL8 END OF CYCLE RECORDED
  - RL9 BOTTOM OF CARRIAGE TRAVEL LIMIT SWITCH
  - RL10 TOP OF CARRIAGE TRAVEL LIMIT SWITCH OR AUTO-HEIGHT PHOTOCELL
  - PH1 AUTOHEIGHT PHOTOCELL
  - C1 CARRIAGE REVERSE CONTACTOR
  - C2 CARRIAGE DRIVER POWER
  - PB1 START PUSH BUTTON
  - PB2 STOP PUSH-PULL BUTTON
  - PB3 TURNTABLE JOG
  - SW MAIN POWER
  - SW2 WRAP UP OR UP/DOWN
  - SW4 CARRIAGE UP/DOWN
  - SW5 PHOTOCELL OFF/ON
  - LS1 TOP LIMIT SWITCH
  - LS2 BOTTOM LIMIT SWITCH
  - PRS PROXIMITY SWITCH
  - CCT CYCLE COUNTER (OPTIONAL)
- NOTE: 30" MULTISTRETCH CARRIAGE  
FU-1 (MDA-10A) FU-3 (MDL-8A)



**MULTISTRETCH**  
MOTOR-1/2HP,90VDC



**CARRIAGE**  
MOTOR-1/2HP,90VDC



<b>ORION PACKAGING INC.</b>			
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APPR. BY: J.B.S.		DRAWN BY: R.SWIATEK	
TITLE			
<b>H&amp;L66-9</b>		W/TOP WRAPS OPTION & 3 SPEED T.TABLE	
SIZE	DOCUMENT NO.	REV	
C	JOB # STANDARD	<b>300 633</b>	1
DATE:	JAN-03-1994	SHEET	1 OF 1
FILENAME:	HL66-9.SCH	BASE:	

## **CYCLE CONTROLS**

The control panel layout is custom designed for each particular installation, however, common standard controls have been employed.

**CAUTION:** before proceeding be familiar with the EMERGENCY button and all functions, switches and pushbuttons.

## **POWER SWITCH**

The Power Switch has two settings:

ON - connects a power source to the machine (voltage depends on the machine type - see electrical diagram provided with the machine).

OFF - disconnects the power source.

## **START AND STOP SWITCHES (EMERGENCY STOP)**

The START switch is used to start the cycle once the load is on the turntable (or under the rotary arm). The cycle may be stopped at anytime by pressing the STOP button.

**NOTICE:** In case of emergency, use the STOP button which interrupts all the machine electrical circuits (except multistretch drive). If the STOP pushbutton is pressed in the middle of the cycle, the carriage and turntable may be returned to their home position by using the jog buttons before restarting the cycle.

## **SPIRAL WRAP SWITCH**

The SPIRAL WRAP switch has two positions:

UP - in this 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 this position the cycle will be completed after the load is wrapped in both the up and down directions.

NOTE: TOP WRAP FIRST (OPTIONAL)

The carriage raises faster at the beginning of the cycle to wrap the top of the load (see electrical diagram provided with the machine).

### **CARRIAGE CONTROL SWITCH**

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

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 attained.

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 its respective direction.

### **TURNTABLE ( ROTARY TOWER ) JOG**

The turntable (rotary tower) jog switch is a pushbutton which will rotate the turntable (rotary arm) in a clockwise direction (as viewed from the top) when the switch is held depressed. When the switch is released the turntable (rotary tower) will stop. The switch is inoperative during the wrap cycle.

## PHOTOCELL SWITCH

The photocell switch has two settings:

ON - when turned ON, the photocell instructs the carriage to 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 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 usefull range for most of the films used by our customers, 8 to 10 as a very high range which may break some films).

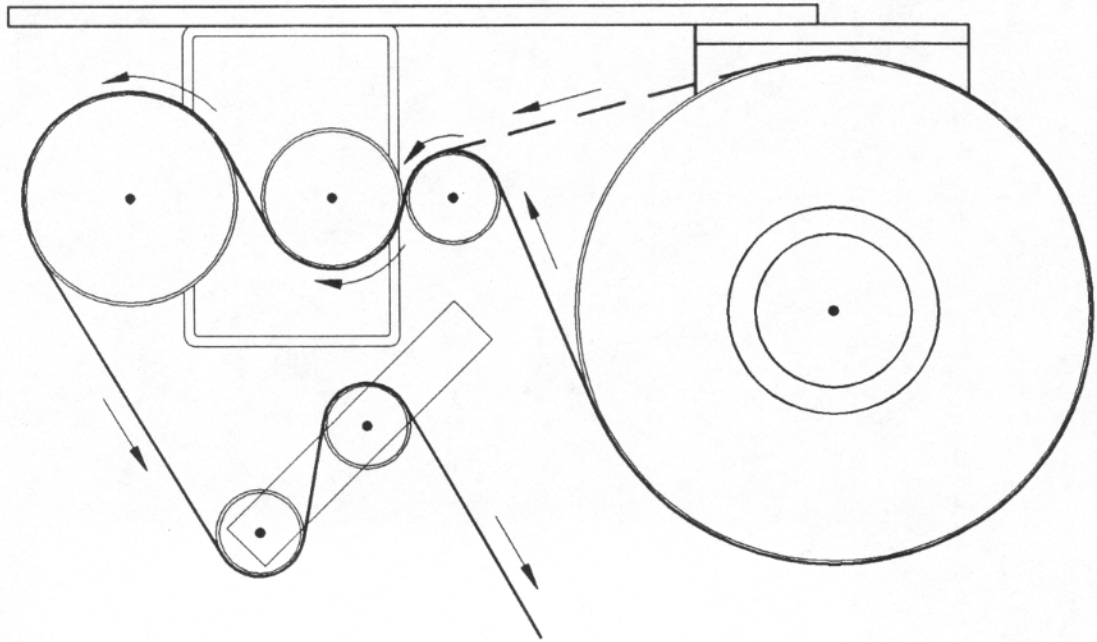
NOTE: Lighter loads may require lower tension settings then heavier loads.

Film tension is controlled through the dancer bar system. Occasionally the feed back proximity sensor may need some adjustment. Adjustment of feed back is shown on drawing # 001

Adjustment instructions:

- remove the carriage cover
- unbolt the two nuts holding the proximity switch -item # 1
- turn the proximity switch - item # 2 until the moment when the motor starts to turn (or hums)
- tighten on the nuts securing the proximity switch.

NOTE: The condition in which the motor hums but does not turn must be maintained even after all elements are tightened. If not, the adjustment procedure must be repeated.



**WARNING:**

**DISCONNECT POWER BEFORE FEEDING FILM**

**FILM FEEDING PATTERN  
FOR STANDARD CARRIAGE**

## TO LOAD THE FILM....

The film roll can be loaded on the mandrel of the carriage 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.

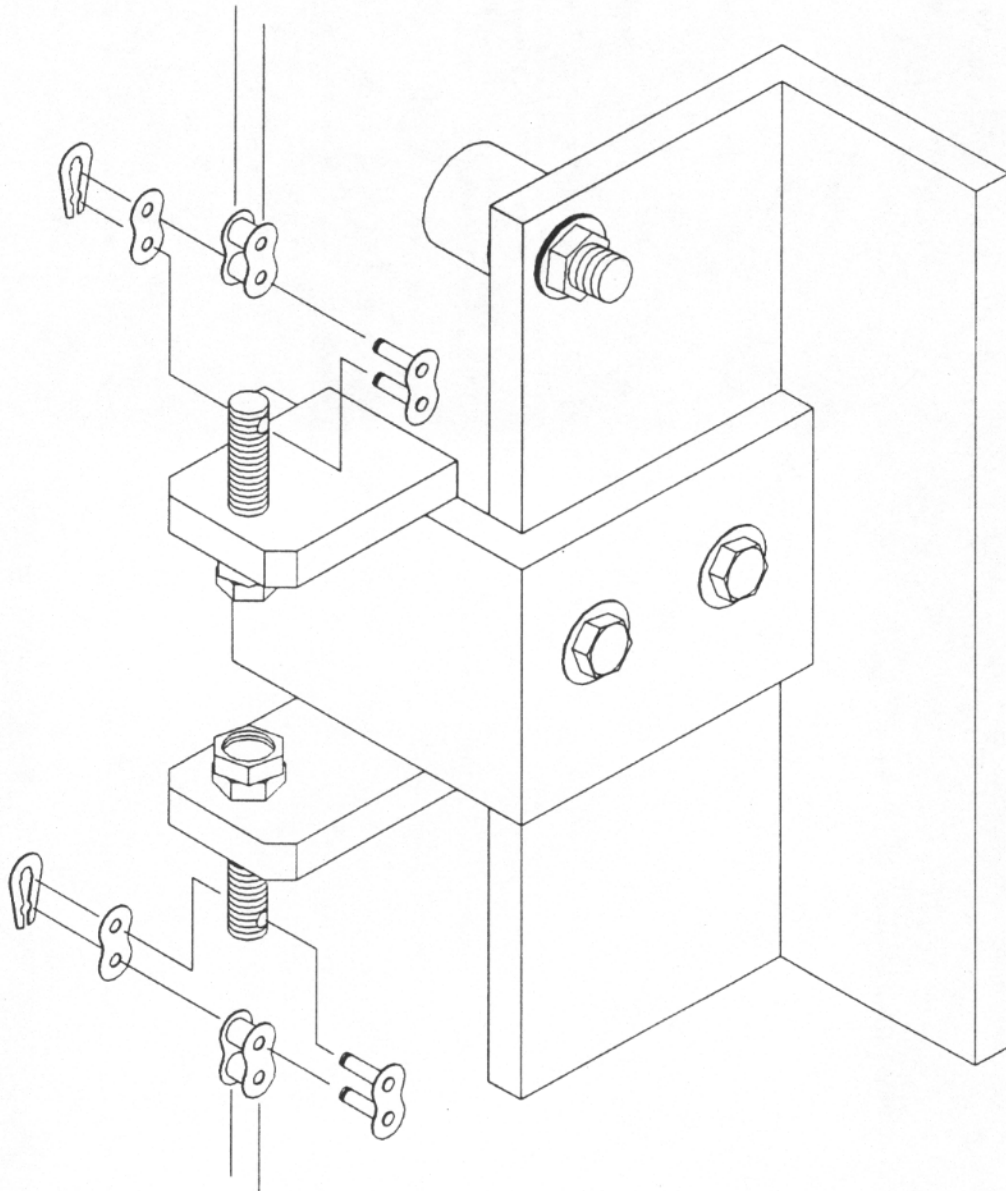
1. Disconnect power (turn off power switch).
2. Put the roll of film on the mandrel and press down to insure penetration of spikes into the card board center of the film roll.
3. In the case of automatic machines, install the film cap on top of the roll to prevent upward movement.
4. Introduce the roping end of the film between the shafts of all rollers (as shown on the dwg.) and pull to pass it around all three rollers (pressure roller and both rubber rollers).
5. Pass the film between the two dancer (aluminium) rollers (in certain applications the film has to be passed around one or two additional position aluminium rollers).
6. When the film feeding is completed - turn the power switch ON
7. 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 or into the clamp mechanism (if machine is fully automatic).

The system is now ready to begin the first wrapping cycle.  
Proceed to page titled SYSTEM START UP.



**ATTENTION:**

**WHEN MOUNTING THE CARRIAGE LIFT CHAIN,  
PLEASE ENSURE, THAT THE CONNECTING  
LINK'S PIN IS INSERTED FROM THE TOWER SIDE**



**CHAIN TENSIONER ASSEMBLY**

## MACHINE MAINTENANCE

### REDUCER OIL CHANGE

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 25000 hours of operation, whichever ever 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:

<b>Manufacturer</b>	<b>Lubricant</b>
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 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

### 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 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.

## **CHAIN MAINTENANCE**

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

With time the chain will tend to stretch. A loose elevator and turntable (rotary arm) chain should be tightened at the chain tensioner, or by moving the reducer on the mounting plate.

## **CAM FOLLOWER MAINTENANCE**

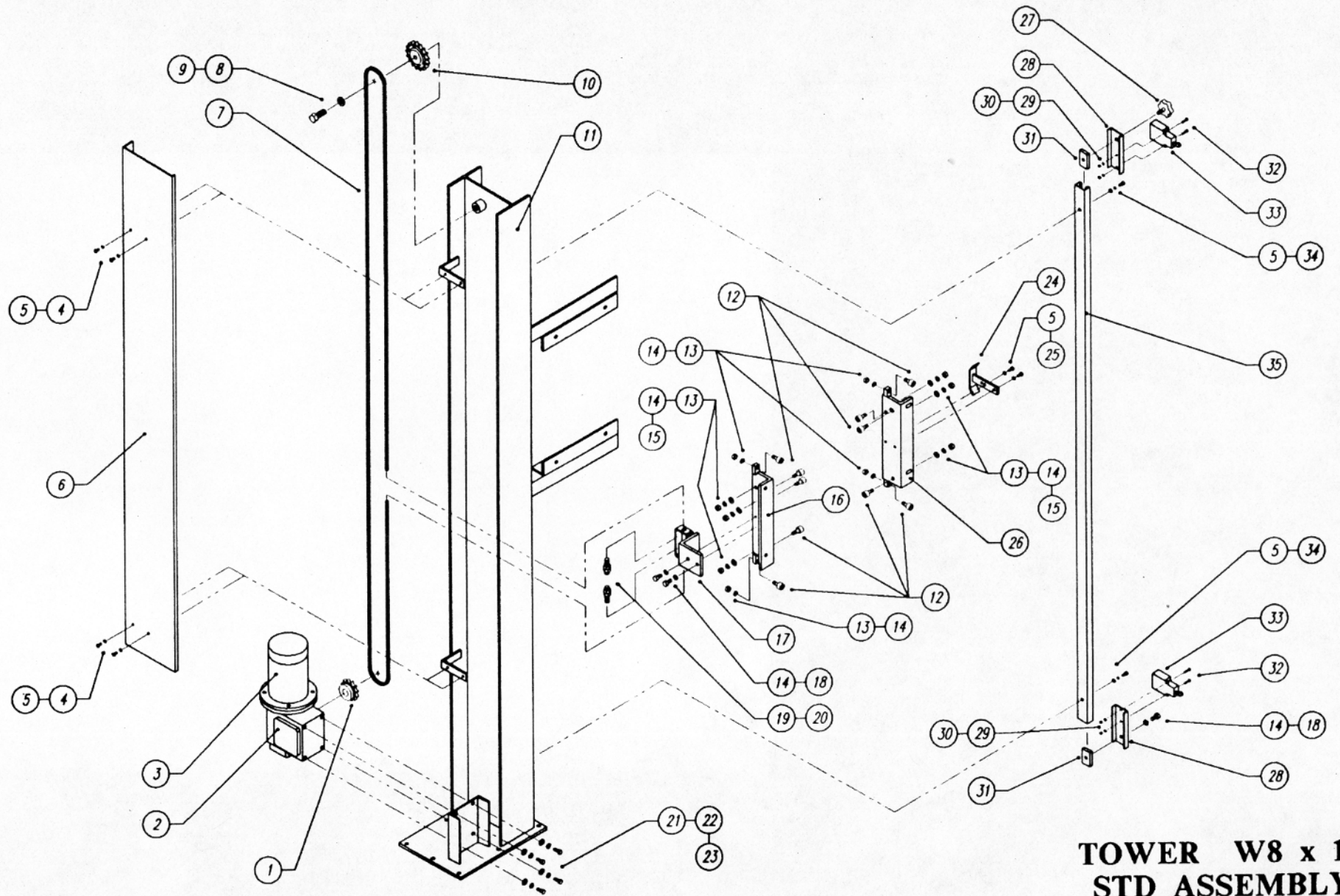
The cam followers behind the carriage have deep grease pockets and do not need frequent relubrication. The portion of the tower on which the cam followers run, should be cleaned and regreased every 300 hours of operation. If the machine operates in a dusty or corrosive environment the tower should be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

**SEMI-AUTOMATIC  
STANDARD ASSEMBLY  
PART LIST**

**Note :**

**\* Quantity listed in order of part number**

**\*\* The names given to the parts are generic**



**TOWER W8 x 18  
STD ASSEMBLY**

UPDATED MARCH-03-94 # 405078

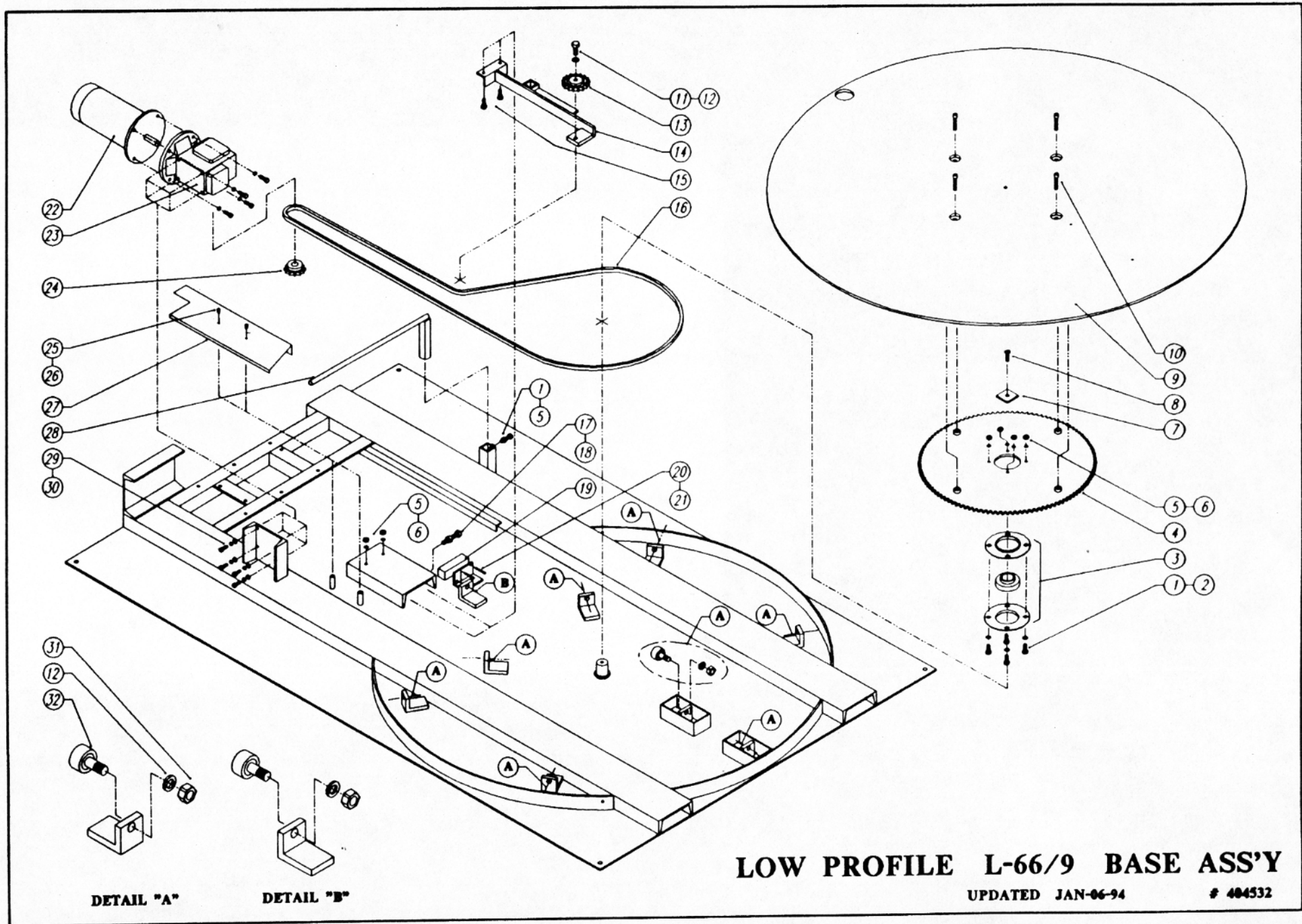
## TOWER W8 x 18 STD ASSEMBLY

## PART LIST

Dwg. # 405078 updated March-03-94

NO.	PART #	DESCRIPTION	QTY
1.	010343	SPROCKET (for 12 RPM)	1
	010235	SPROCKET (for 16 RPM)	
2.	010344	REDUCER	1
3.	010036	ELECTR. MOTOR	1
4.	012049	PAN PHILL SCREW	4
5.	011393	SPRING WASHER	8
6.	260904	TOWER CHAIN GUARD	1
7.	010009	CHAIN	1
8.	010329	HEX HEAD SCREW	1
9.	012721	SPRING WASHER	1
10.	010008	IDLER SPROCKET	1
11.	403885	TOWER W8x18	1
12.	010067	CAM FOLLOWER	10
13.	012582	HEX NUT	10
14.	011390	SPRING WASHER	13
15.	010948	FLAT WASHER	6
16.	200184	LEFT CARRIAGE HOLDER	1
17.	230550	CHAIN TENSIONER	1
18.	012474	HEX HEAD SCREW	3
19.	400892	TIGHTENER SCREW	2
20.	011266	HEX NUT	4
21.	012723	HEX HEAD SCREW	4
22.	012724	SPRING WASHER	4
23.	012725	FLAT WASHER	4
24.	240245	LIMIT SWITCH ACTUATOR	1
25.	012722	HEX HEAD SCREW	2
26.	200183	RIGHT CARRIAGE HOLDER	1
27.	010092	KNOB	1
28.	260816	LIMIT SWITCH HOLDER	2

29.	012726	HEX NUT	4
30.	012743	SPRING WASHER	4
31.	220518	CHANNEL GUIDE	2
32.	012690	PAN PHILL SCREW	4
33.	010123	LIMIT SWITCH	2
34.	010257	SOCKET HEAD CAP SCREW	2
35.	220794	LIMIT SWITCH CHANNEL	1



**LOW PROFILE L-66/9 BASE ASS'Y**

UPDATED JAN-06-94

# 404532

DETAIL "A"

DETAIL "B"



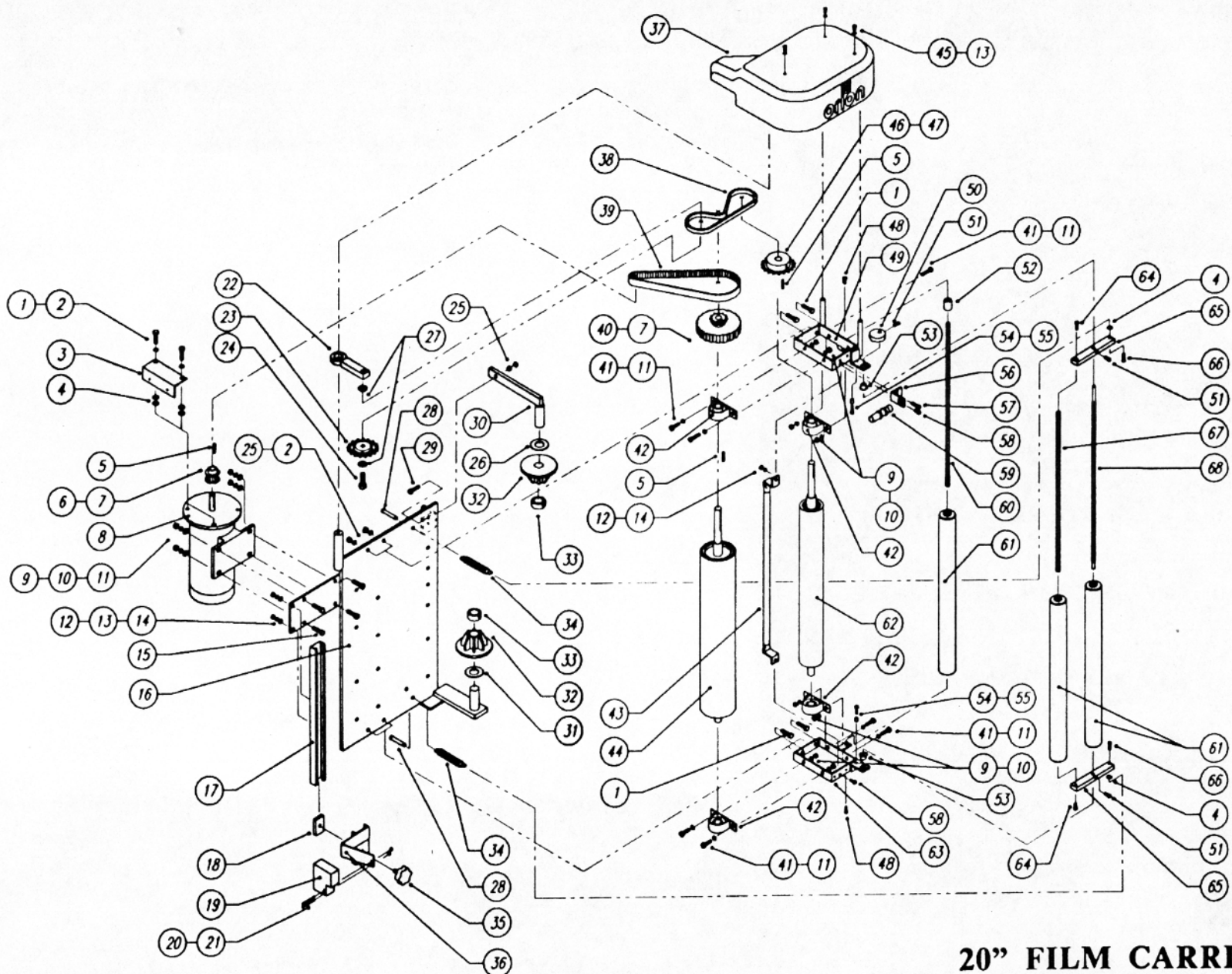
# LOW PROFILE L-66/9 BASE ASS'Y

## PART LIST

# 404532

updated Jan-06-94

NO.	ORION PART NO.	DESCRIPTION	Q-TY
1.	012406	HEX HEAD SCREW	5
2.	010948	FLAT WASHER	4
3.	010007	CENTRAL BEARING UNIT	1
4.	400832	TURNTABLE SPROCKET	1
5.	011128	HEX NUT	6
6.	011390	SPRING WASHER	4
7.	220792	PLATE	1
8.	012692	FLAT SOCKET CAP SCREW	1
9.	401381	TURNTABLE DISK	1
10.	010319	SOCKET HEAD CAP SCREW	4
11.	010329	HEX HEAD SCREW	1
12.	012721	SPRING WASHER	10
13.	010008	IDLER SPROCKET	1
14.	260681	CHAIN TENSIONER	1
15.	010293	HEX HEAD SCREW	2
16.	010009	CHAIN	1
17.	010408	CHAIN TENSION SCREW	1
18.	011266	HEX NUT	1
19.	010739	PROXIMITY SWITCH	1
20.	012858	PAN PHILL SCREW	2
21.	012726	HEX NUT	2
22.	010036	ELECTR. MOTOR	1
23.	010093	REDUCER	1
24.	010435	SPROCKET	1
25.	012049	PAN PHILL SCREW	2
26.	011393	SPRING WASHER	2
27.	401106	CHAIN GUARD	1
28.	403521	ROPING BAR	1
29.	010291	HEX HEAD SCREW	4
30.	012724	SPRING WASHER	2
31.	011322	HEX NUT	9
32.	012598	CAM FOLLOWER	9



**20" FILM CARRIAGE STD  
PART # 405032 - ASS'Y**

UPDATED MAY-09-94 # 404354

**20" FILM CARRIAGE STD  
PART # 405032 ASS'Y - PART LIST**

Updated May-09-94

Dwg. # 404354

NO.	ORION PART #	DESCRIPTION	Q-TY
1.	010293	HEX HEAD SCREW	6
2.	011390	SPRING WASHER	6
3.	250162	JUNCTION BOX BRACKET	1
4.	010948	FLAT WASHER	4
5.	010295	SQ. KEY	3
6.	011283	TIMING BELT PULLEY	1
7.	012800	SET SCREW	2
8.	010036	ELECTR. MOTOR	1
9.	012751	HEX NUT	12
10.	012724	SPRING WASHER	12
11.	012725	FLAT WASHER	12
12.	012689	HEX NUT	3
13.	011393	SPRING WASHER	5
14.	012221	FLAT WASHER	3
15.	012757	HEX HEAD SCREW	4
16.	405501	BACK PLATE F/20" FILM	1
17.	404184	PHOTOCELL CHANNEL F/20" FILM	1
18.	220518	CHANNEL GUIDE	1
19.	011495	PHOTOCELL	1
20.	012754	PAN PHILL SCREW	2
21.	012726	HEX NUT	2
22.	401357	CHAIN TENSIONER	1
23.	011297	IDLER SPROCKET	1
24.	012482	HEX HEAD SCREW	1
25.	011128	HEX NUT	6
26.	012323	FLAT WASHER	1
27.	012584	FLAT WASHER	2
28.	401375	CLEVIS PIN	2
29.	010322	HEX HEAD SCREW	1
30.	403802	TOP MANDREL	1

■ NO.	ORION PART #	DESCRIPTION	Q-TY
31.	013040	THRUST WASHER	1
32.	403801	SPOOL	2
33.	010052	COLLAR	2
34.	010047	TENSION SPRING, 40 COILS	2
or	011424	TENSION SPRING, UPPER, 50 COILS	1
	401320	TENSION SPRING, LOWER, 37 COILS	1
35.	010092	KNOB	1
36.	230721	PHOTOCELL BRACKET	1
37.	404935	CARRIAGE COVER	1
38.	010583	CHAIN	1
39.	012685	TIMING BELT	1
40.	403494	PULLEY/SPROCKET	1
41.	010291	HEX HEAD SCREW	8
42.	010427	PILLOW BLOCK BEARING	4
43.	403449	SAFETY BAR	1
44.	402791	RUBBER ROLLER 4 1/8" DIA.	1
45.	012049	PAN PHILL SCREW	3
46.	011456	DRIVE SPROCKET, PRESTRETCH 230 %	1
47.	012805	SET SCREW	2
48.	012475	HEX HEAD SCREW	2
49.	402787	TOP BRACKET	1
50.	230648	PROXIMITY SENSOR CAM	1
51.	010257	SOCKET HEAD CAP SCREW	3
52.	402822	PLASTIC TUBE SPACER	1
53.	010058	FL.BRONZE BUSHING	2
54.	011423	SHOULDER SCREW	2
55.	010946	PLASTIC HOSE	2
56.	230647	PROXIMITY SENSOR BRACKET	1
57.	010277	HEX HEAD SCREW	1
58.	012722	HEX HEAD SCREW	2
59.	011470	PROXIMITY SENSOR	1
60.	402794	SNUB ROLLER SHAFT	1
61.	402789	ALUMINUM ROLLER	3
62.	402790	RUBBER ROLLER 2 3/4" DIA.	1

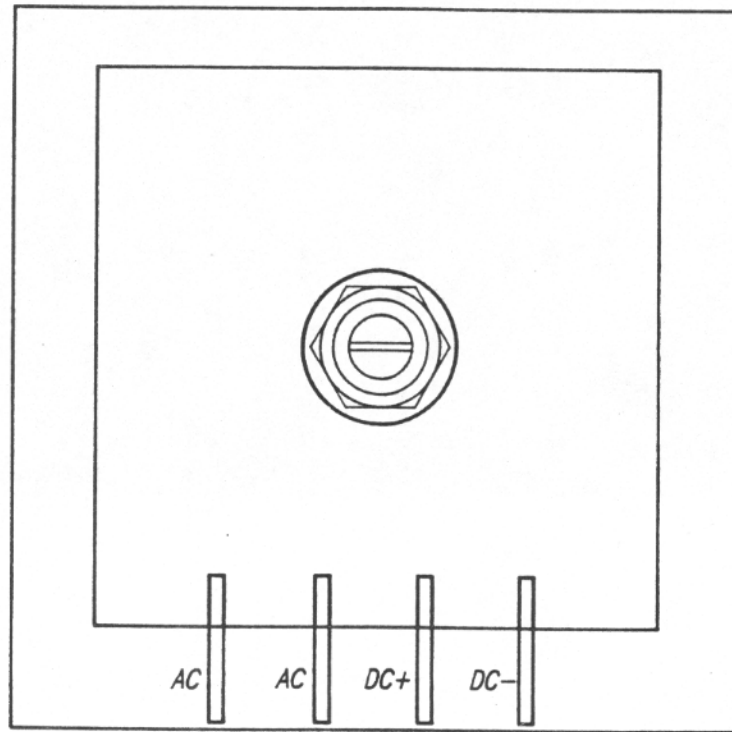
<b>NO.</b>	<b>ORION PART #</b>	<b>DESCRIPTION</b>	<b>Q-TY</b>
63.	402788	BOTTOM BRACKET	1
64.	010259	SOCKET HEAD CAP SCREW	2
65.	401358	DANCER ROLLER LEVER	2
66.	401374	CLEVIS PIN	2
67.	402792	DANCER ROLLER SHAFT	1
68.	402793	DANCER LEVER SHAFT	1

# APPENDIX

## ELECTRICAL BOARDS' CHART FOR ORION STRETCHWRAPPERS

	168-5	168-A	336-7	750 MX	850 M	850 C	155-4	850 DM
L-78, H-78		X					X	X
L-77, H-77		X					X	X
M-66, M-67		X	X		X		X	
L-66, H-66		X	X		X		X	
M-55, L-55, H-55		X	X		X		X	
M-44, L-44, H-44	X		X	X			X	
*M-44,*L-44,*H-44	X		X	X				

\* - PROCESSOR

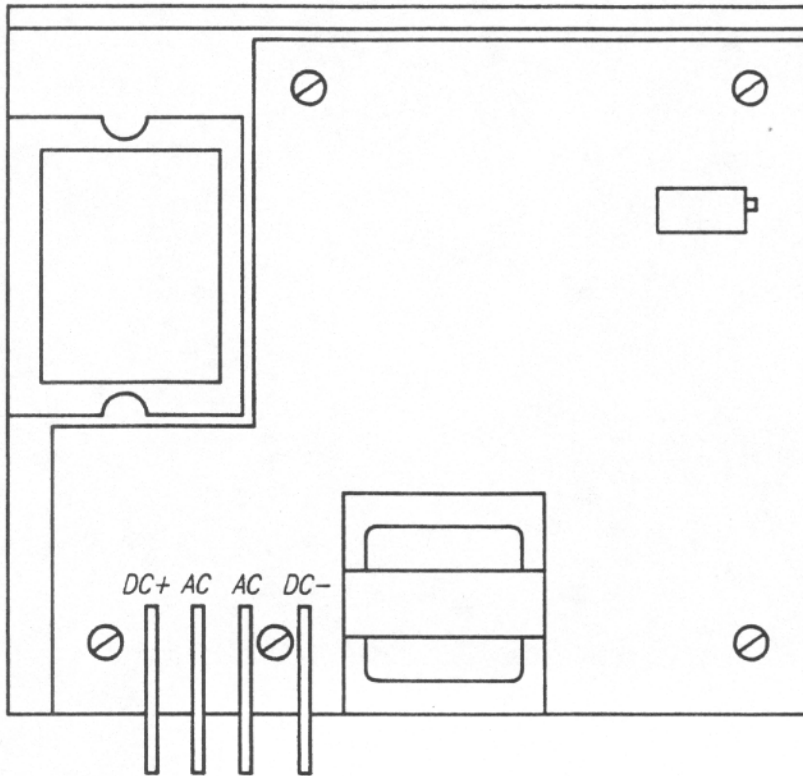


AC: AC INPUT  
AC: AC INPUT  
DC+: ARMATURE CONTROL  
DC-: ARMATURE CONTROL

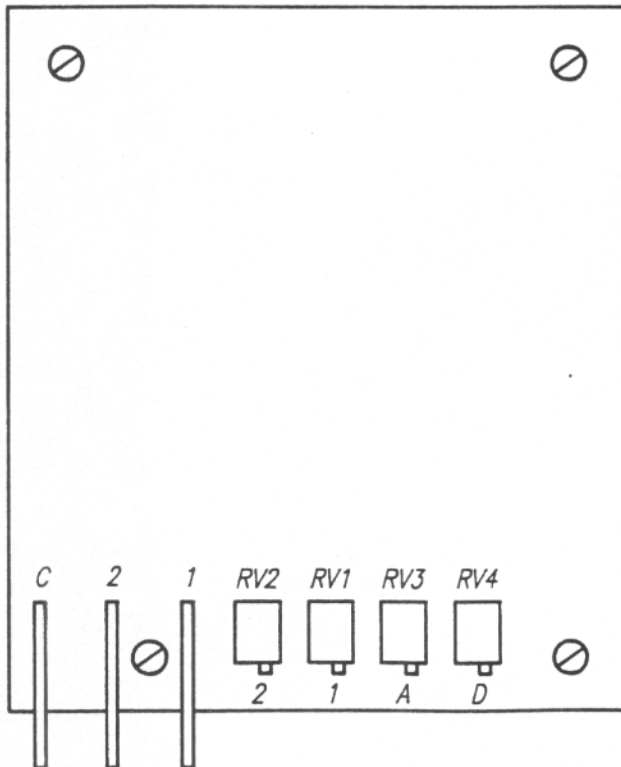
168-A

CARRIAGE SINGLE SPEED BOARD





DC+: ARMATURE CONTROL  
 AC: AC INPUT  
 AC: AC INPUT  
 DC-: ARMATURE CONTROL



C: COMMON  
 2: SPEED CONTROL (HIGH)  
 1: SPEED CONTROL (LOW)

POTENTIOMETERS:

2: HIGH SPEED ADJUSTMENT  
 1: LOW SPEED ADJUSTMENT  
 A: ACCELERATION ADJUSTMENT  
 D: DECELERATION ADJUSTMENT

850M 2 SPEED DC  
 MOTOR CONTROL BOARD

## ADJUSTMENTS

**Acceleration:** (RV3) The pot marked A is the control for the acceleration or electronic soft start feature.

For an initial setting, turn the A pot fully counter clockwise (CCW) (until a faint clicking sound is heard), and then approximately 2 turns or revolutions clockwise (CW). CW adjustment of this potentiometer softens the start and lengthens the time required for the turntable/tower to reach it's preset speed. CCW quickens the start and decreases the time for the turntable/tower, to reach it's preset speed.

**Speed Control:** (RV1) The pot marked 1 controls the turntable/ tower jog speed1.

Simply activate the turntable/tower jog function, adjusting the jog speed (pot 1) as the tower/turntable rotates. This should be set for approximately 2-3 R.P.M... Please note that this setting should be made with a load on the turntable (turntable type models only). A CW turn increases jog speed, while CCW decreases jog speed.

**Speed Control:** (RV2) The pot marked 2 is the control for the high speed2 for the turntable/tower during the wrap cycle once acceleration is complete.

This speed can be as high as 12 R.P.M.; however you should note that if it is set to high, you may see chopping of the current to the turntable/tower drive motor which will cause pulsating half speed operation of the turntable/tower drive itself. If this is seen, please decrease the setting of pot 2, until it is no longer in effect.

For best calibration results, it is recommended that you make this adjustment while the machine is in cycle. After starting a wrap cycle set the film carriage speed control to the "0" (minimum) position. This will prevent the film carriage from rising and completing its cycle. Then simply adjust the high speed (pot 2) as the tower/turntable rotates. A CW turn increases speed, while a CCW turn decreases speed.

---

1 Speed Control 1 = Turntable/Tower Jog Speed  
Selected by a 120 VAC signal applied from terminal (1) to (C)

2 Speed Control 2 = Turntable/Tower High Speed  
Selected by a 120 VAC signal applied from terminal (2) to (C)

**Deceleration:** (RV4) The pot marked D is the deceleration control. Functionally, it is the opposite of acceleration, except that it is a more critical setting in that our machine logic requires that we decelerate from speed 2 to speed 1 during the course of the final revolution of the turntable/tower before shutoff.

For an initial setting, start with the D pot set fully CCW. Then, cycling the machine, observe the transition to jog speed at the end of the cycle, prior to the stop of the turntable/tower at home position. Gradually increase the D pot setting (CW) until the turntable/tower only jogs approximately 1/8 to 1/4 revolution before reaching home position. CW adjustment of this potentiometer quickens the stop and shortens the deceleration time required for the turntable/tower to settle to its preset jog speed. While CCW softens the stop and lengthens the time required for the turntable/tower to settle to its preset jog speed.

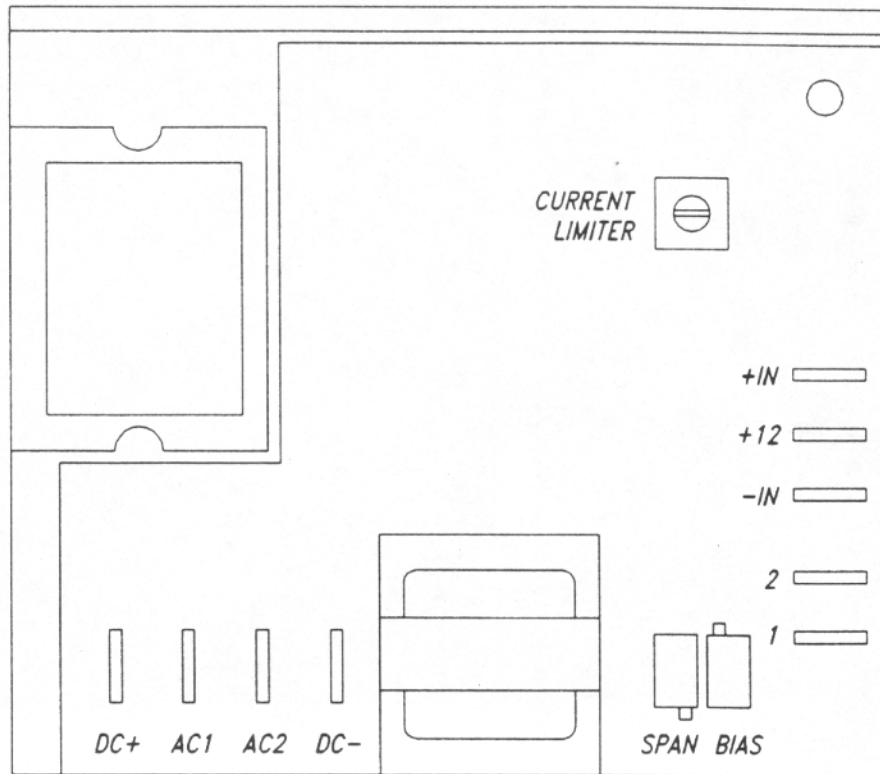
Thus the deceleration control is important in that if the deceleration time is too short, we will prematurely reach jog speed and jog an excessive amount of time to the home position before shutoff.

Conversely if the deceleration time is set too long, the turntable/tower will not settle to the jog speed and thus will be going too fast to align properly and momentum will take the turntable/tower beyond home position. As you can imagine, any time the wrap speed is changed, you will need to make a corresponding change in the setting of the pot marked D for deceleration.

## **TROUBLE SHOOTING & REPAIR**

In most cases repair will require parts replacement. If user intends to, and is equipped to perform repairs, spare parts are available from Orion Parts & Service.

Damage is usually evident visually on the 850M board. Replacing the obviously damaged board frequently restores operation. However if damage is not evidently visible, swapping boards will determine if the board is at fault.



DC+: ARMATURE CONTROL

AC1: AC INPUT

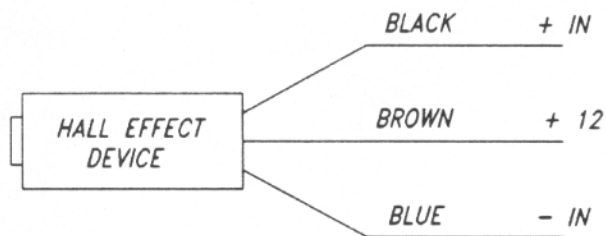
AC2: AC INPUT

DC-: ARMATURE CONTROL

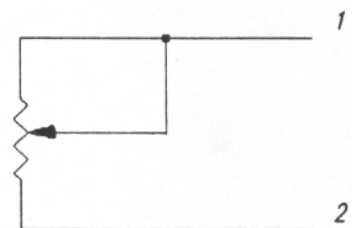
POTENTIOMETER

SPAN: HALL EFFECT SENSITIVITY CONTROL

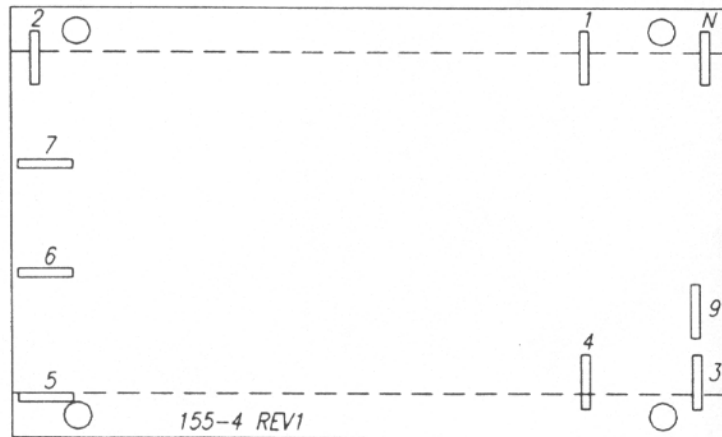
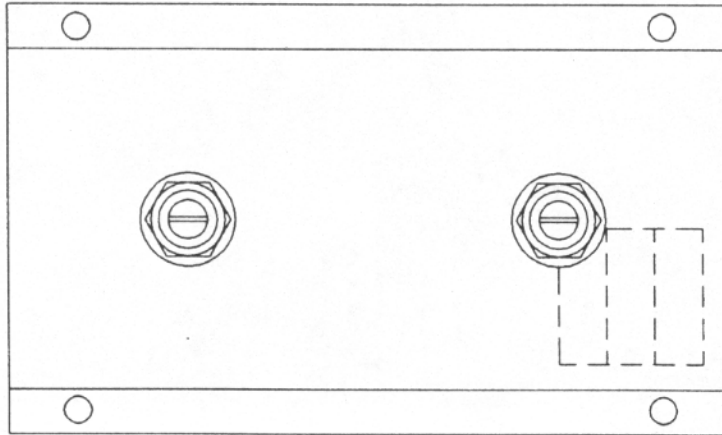
BIAS: SYSTEM BIAS (FACTORY SET)



FILM TENSION ADJUSTMENT  
REMOTE POTENTIOMETER



336-6/7  
MULTISTRETCH BOARD



155-4 REV1

- |               |               |
|---------------|---------------|
| 1: AC INPUT   | 7: OUTPUT B/W |
| 2: AC INPUT   | 8: N/A        |
| 3: COUNT      | 9: COMMON     |
| 4: RESET      | N: NEUTRAL    |
| 5: OUTPUT     |               |
| 6: OUTPUT T/W |               |

155-4  
COUNTER BOARD