



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** 103870
- 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.

103870

ORION MODEL L-88

Foot Pedal Controlled Low Profile Turntable Only

Maximum Load Size:	52"W x 52"L
Weight Capacity:	3,000 lbs. Dynamic, 20,000 lbs. Static
Utilities:	115/1/60 15 Amp Service
Turntable	59" Diameter 3/8" Steel Plate Steel Cam Follower Support System Self Lubricating System with Reservoirs 3" Height Floor to Top of Turntable
Turntable Drive:	10 RPM Fixed Turntable Speed 1/3 HP AC Drive Motor #50 Roller Chain Drive with Tensioner
Control Features:	On/Off Foot Operated Switch
Film Delivery:	N/A
Structural Features:	Forklift Portable Base Design Cam Follower Turntable Support All Structural Steel Construction
Estimated Shipping Weight:	450 lbs.

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 conveyor or mongoose machine, enter the forks under the frame.

2. Lift the machine (or other part of system) only to 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 machine (M66, M67) have to be attached on the bracket or on the stand (collapsible or anchored to the floor). The M55 has its 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 the 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 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:

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 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.

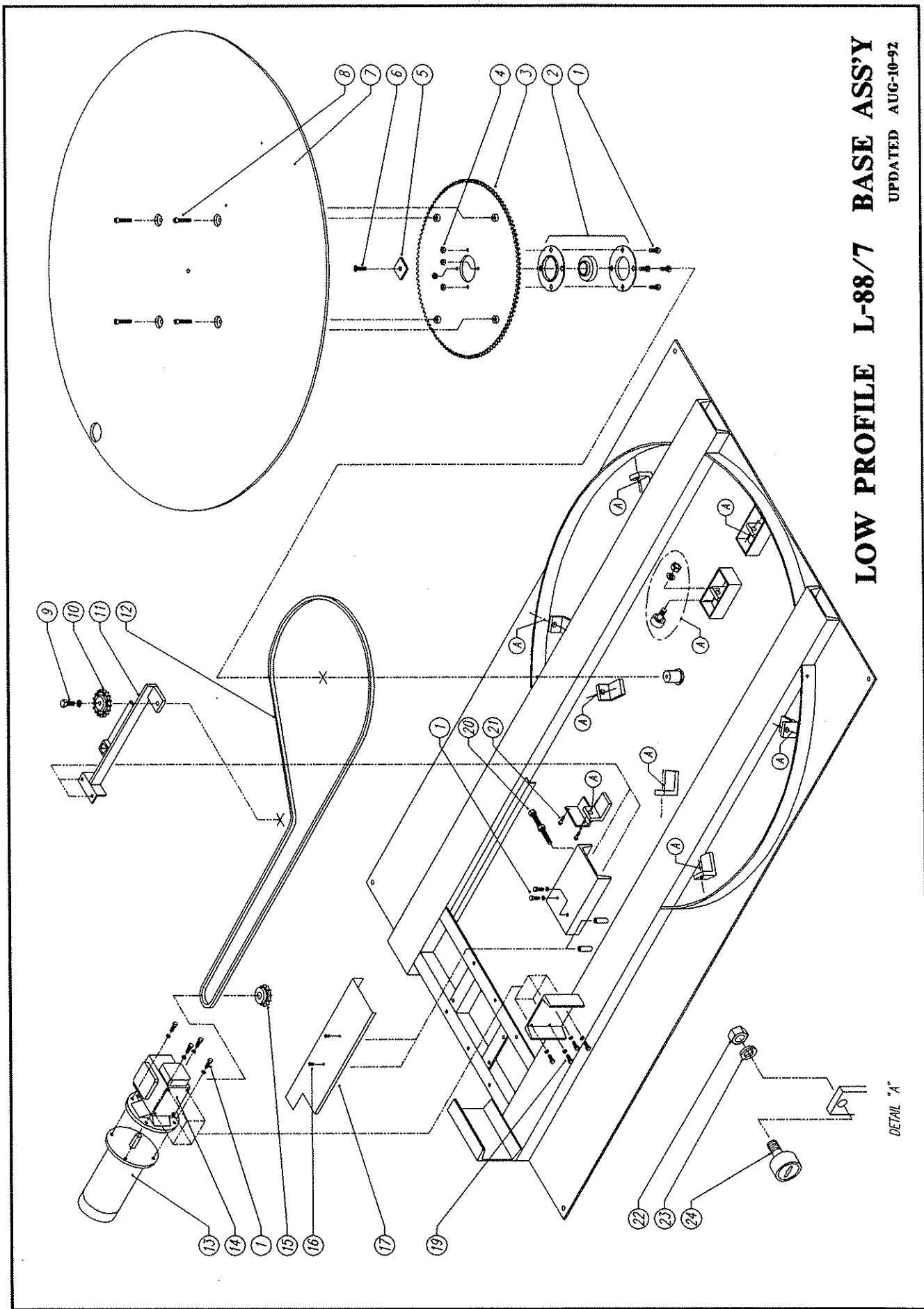
With time the chain will tend to stretch. A loose elevator and turntable (rotary arm) chain should be tightened at the chain tensioner, or by moving the reducer on the mounting plate.

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.

LOW PROFILE L-88/7 BASE ASSY

UPDATED AUG-10-92



DETAIL "A"

LOW PROFILE L-88/7 BASE ASS'Y

PART LIST

updated Aug-10-92

ORION			
NO.	PART NO.	DESCRIPTION	Q-TY
1.	010293	HEX HEAD SCREW	10
2.	010007	CENTRAL BEARING UNIT	1
3.	010006	TURNTABLE SPROCKET	1
4.	012477	HEX NUT	4
5.	010898	PLATE	1
6.	012591	FLAT SOCKET CAP SCREW	1
7.	012596	TURNTABLE DISK	1
8.	010319	SOCKET HEAD CAP SCREW	4
9.	010329	HEX HEAD SCREW	1
10.	010008	IDLER SPROCKET	1
11.	012667	CHAIN TENSIONER	1
12.	010009	CHAIN	1
13.	011057	ELECTR. MOTOR	1
14.	010093	REDUCER	1
15.	010074	SPROCKET	1
16.	012049	PAN PHILL	2
17.	012599	CHAIN GUARD	1
19.	010382	HEX HEAD SCREW	4
20.	010233	CHAIN TENSION SCREW	1
21.	012647	PAN PHILL	2
22.	011322	HEX NUT	9
23.	012601	SPRING WASHER	9
24.	012598	CAM FOLLOWER	9

APPENDIX

REQUIREMENTS:

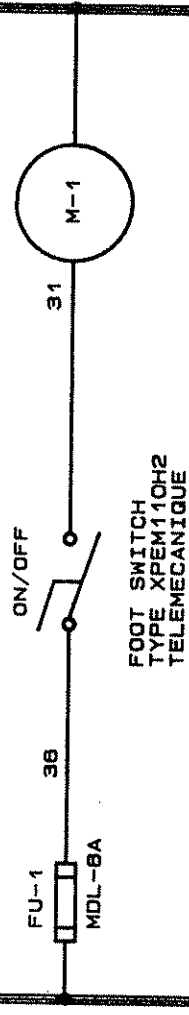
- 120V
- 60HZ
- 1PH
- 10A

LINE

NEUTRAL

TURNTABLE

MOTOR - 1/3HP, 115/230VAC.



FOOT SWITCH
TYPE XPEM110H2
TELEMECANIQUE

ORION PACKAGING INC.



#3103870

2270 INDUSTRIEL 80 LAVAL, QUE., CANADA H7S 1P9
TEL.: (514) -667-9769 FAX: (514) -667-6320
CK'D BY: J.B.S. DRAWN BY: G.RUGGIERI

TITLE **HGL88.STD**

SIZE	DOCUMENT NO.	REV
A	JOB #	0
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DATE:	FEB-14-1991	SHEET 1 OF 1