ANYTHING LESS IS A GAMBLE

MODEL CTS67-17
SERIAL No. 2005-8899999

2270 Industrial, Montreal (Laval), Canada, H7S 1P9
Tel.: (450) 667-9769, Fax: (450) 667-6320

ANYTHING LESS IS A GAMBLE

INSTRUCTION MANUAL

FOR ALL INQUIRIES
PLEASE CONTACT
OUR LOCAL DISTRIBUTOR

FOR NORTH AMERICA 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 advance 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 2005-8899999

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 shocks, careful operation of the machine and awareness of its many automatic functions is required.

NOTE: All electrical power and compressed air must to be disconnected prior to all inspection, maintenance or repair work.

ORION PACKAGING INC.

ORION PACKAGING SYSTEMS INC.
FULLY AUTOMATIC EQUIPMENT SPECIFICATIONS

ORION MODEL CTS67 (2003)

Medium Duty Conveyorized Rotary Turntable Automatic System

Maximum Load Size	48"W x 48"L x 75"H
Minimum Load Size	30"W x 30"L x 26"H*
Weight Capacity	200 lbs*** - 4,000 Ibs. Dynamic / 20,000 Ibs. Static**
Production Capacity	See Attached Throughput Calculation
Utilities	115/1/60 ; 20 Amps Electrical Service 3 CFM Compressed Air @ 80 PSI
Turntable	Powered Conveyor Turntable Surface with 25" Diameter Ring Bearing Support
Turntable Drive	0 - 12 RPM Variable Turntable Speed Electronically Adjustable Acceleration/Deceleration (Soft Start) DC Variable Speed Drive Heavy Duty ANSI Chain & Sprocket Turntable Drive
Control Features	Free Standing, CSA Approved, NEMA 12 Control Panel State-of the-Art Allen Bradley Programmable Logic Control for Maximum Flexibility User Friendly Controls with Non-Proprietary Pushbuttons, and Switches 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 Photocell for Automatic Load Height Detection **** Rewrap Pushbutton for Rewrapping Load After Film Roll Replacement, E-Stop, Etc Turntable Jog Pushbutton Conveyor Jog Pushbuttons Current Overload Protection
Film Delivery	20" Orion Insta-Thread™ Powered Prestretch Film Delivery System Precision Ground, Polyeurethane Pre-Stretch Rollers for Consistent, Maximum Film Yield 245% Standard Pre-Stretch Ratio (Adjustable from 100% to 300%) 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 Insta-Sense™ Film Out/Broken Sensing Logic with Indicator Light
Film Carriage Drive	Heavy Duty ANSI Chain Carriage Lift DC Variable Speed Drive Multi-Point UHMW Precision Carriage Guidance System

ORION PACKAGING SYSTEMS INC.
FULLY AUTOMATIC EQUIPMENT SPECIFICATIONS

ORION MODEL CTS67 CONTINUED

Structural Features	Ergonomic Chassis Layout for Ease of Operator Use Side Facing Carriage for Easy Film Roll Change Personnel Decking Between Chassis Tubes in Film Clamp Area 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 Forklift Easy Access For Loading /Unloading Machine Design Floor Mounted Forklift Wheels Stoppers For Unloading
Conveyor Features	5' Powered lnfeed Conveyor Included 100% Orion Manufactured 100% Structural Steel Construction 4,000 lb. Max Load Weight Capacity 18" Height to Top of Rollers 52" Effective Conveyor Width 2.5" Diameter Rollers on 3.75" Centers All Full Length Rollers Driven Via Heavy Duty ANSI Chain Loop to Loop Full Length Solid Steel Conveyor Roller Axles Individual Bearings with Cast Housings for Each Roller Fully Automatic Sequencing Logic 30 fpm Standard Conveyor Speed DC Variable Speed Drive
Film Tail Treatment	Pneumatic Film Clamp Impulse Wire Film Cutting Pneumatic Load Seeking Brush Down System
Estimated Shipping Weight	4,500 lbs.

* Minimum load height capability is based on 20" film carriage. For 30" carriage, minimum load height capability is 36"

** In applications in which the pallet bottom boards are parallel to conveyor rollers, the minimum bottom board width is 4", and the minimum number of bottom boards is 3.

*** For lighter loads than 200 lbs. consult factory.

**** For black, shiny or transparent loads special type of detector is required.

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.

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 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 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).

Conveyor sections (where applicable) have to be positioned, leveled** and bolted to the floor. 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. 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').

SYSTEM START-UP

Notice: It is advisable to test-run the equipment with several pallet loads before make the attempt to wrap with film. Please position a worker at the EMERGENCY STOP push button.

Start up of the machine (system) may determine the need for the adjustment of:

- Pallet sensor eyes (automatic systems only)
- Load height stop photoswitch (on the carriage)
- Conveyor acceleration/deceleration
- Turntable speed &jog speed
- Turntable speed acceleration/deceleration
- Turntable home position (rotary tower home position)
- Film tail treatment devices (automatic systems).

MACHINE WRAPPING TEST

Before the test procedure adjusts 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). When there is no photocell, verify the top limit switch position.

orion®

CAUTION !

AUTOMATIC MACHINE MAY START WITHOUT WARNING

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

MORE THAN ONE LIVE CIRCUIT. SEE DIAGRAM

LINE-1 LINE-2 LINE-3

MASTER CONTROL

STOP

POWER ON

BYPASS OFF ON

WRAPPER MODE MANUAL AUTO

FILM TENSION

INFEED CONVEYOR JOG

RE-WRAP

CARRIAGE SPEED UP

PROCESS CONVEYOR JOG

CARRIAGE LOWER RAISE

CARRIAGE SPEED DOWN

PROCESS CONVEYORS REV FWD

TOWER/T.TABLE JOG

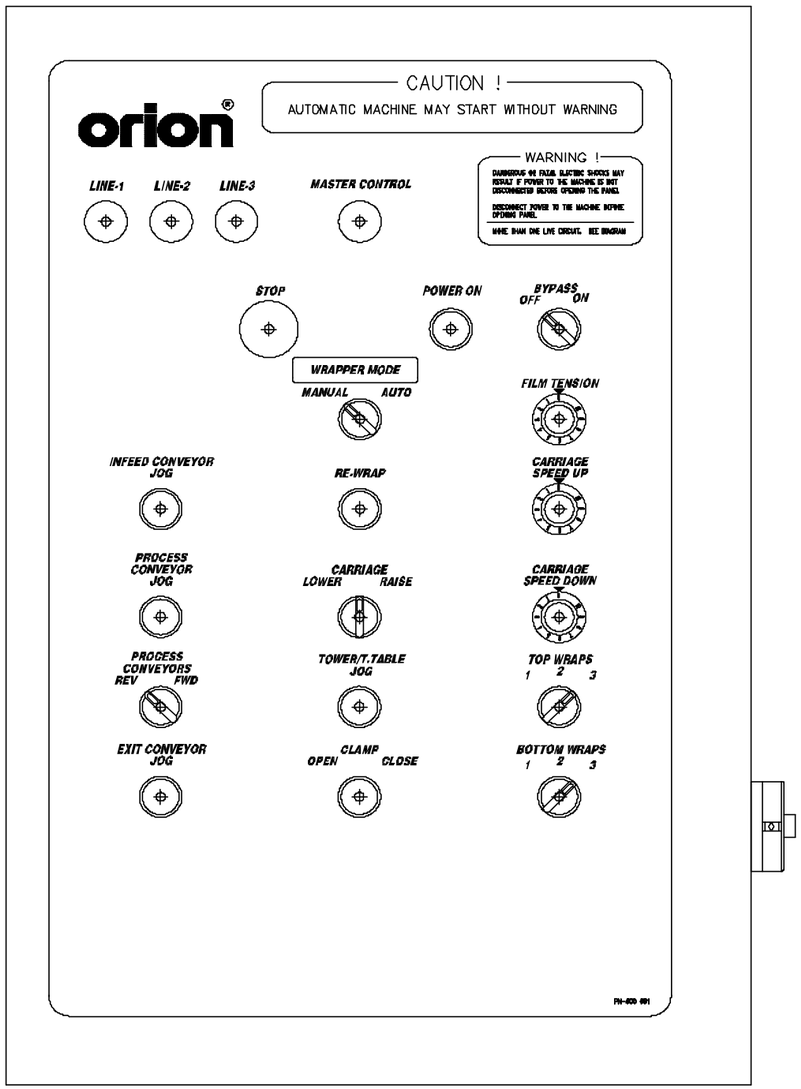
TOP WRAPS 1 2 3

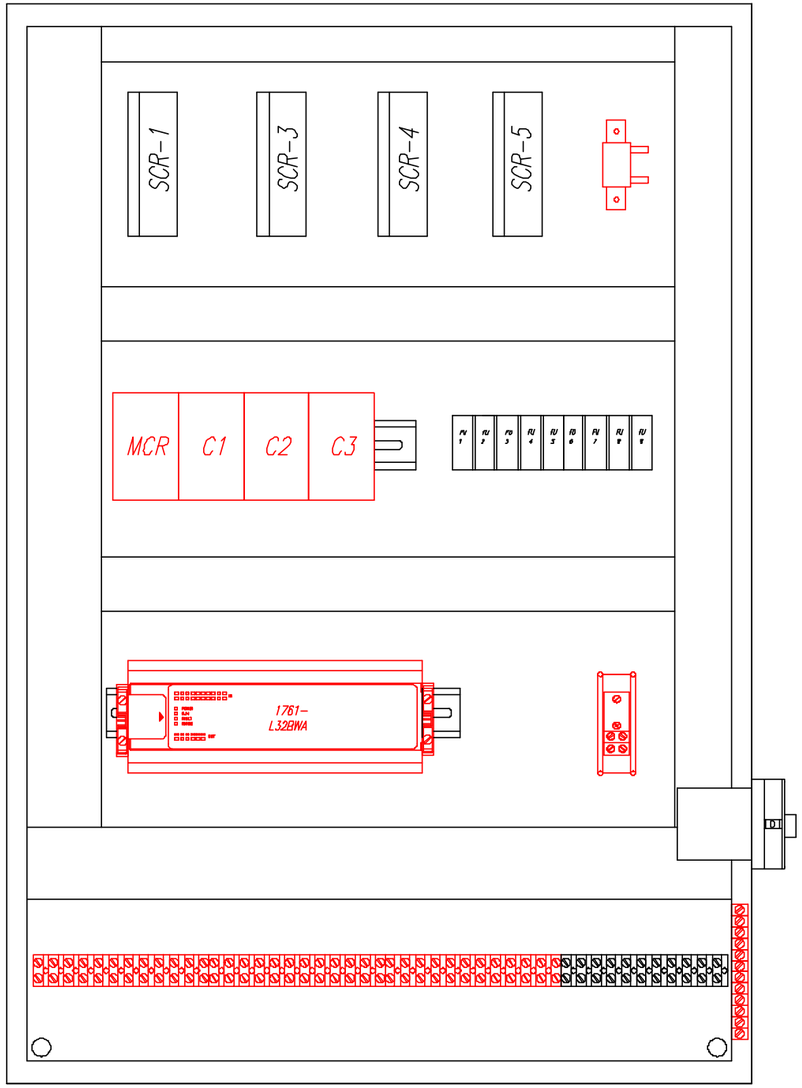
EXIT CONVEYOR JOG

CLAMP OPEN CLOSE

BOTTOM WRAPS 1 2 3

PN-5D0 091





NOTES:

1: SCR-2 (168-A) IS LOCATED ON ENCLOSURE DOOR

CTS67-17 STANDARD PANEL LAYOUT (5412 ES302008)
PANEL SIZE 30x20x08

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

ORION PACKAGING INC.

2270 INDUSTRIEL BLVD LAVAL, QUE., CANADA H7S 1P9
TEL: (514) 667-9769 FAX: (514) 667-9320
APPR. BY: J.B.S. DRAWN BY: J. ALEXANDER

SCALE: 1:2

TITLE: CTS67-17 "STANDARD"

SIZE: D | DOCUMENT NO: JOB # STD 302 753/L | REV: 1

DATE: DEC-19-2003 | SHEET: 1 OF 1

FILENAME: CTS67-17STD.DWG | BASE:

NEUTRAL

LINE

PANEL POWER SWITCH

92

NEUT

LINE

CONTROL PANEL REQUIREMENTS:

- 115V
- 60Hz
- 1PH
- 20Amp

TURNTABLE
MOTOR-1/8HP,90VDC

M-1 | 25 | 26

92 FU-1 MDA-8A | 21 | MCR | 22

SCR-1
TYPE - 858-N
+DC | -DC | ACL | ACZ | CONTROL 121 11 | COM

#12 | #14

1000/02 | 1000/03

CARRIAGE
MOTOR-1/8HP,90VDC

M-2 | 33 | 34

C1 | 35 | 36 | C2

RJ-5.6

C1 | C2 | C1 | C2 | 37 | 38

92 FU-2 MDL-8A | 31 | MCR | 32

SCR-2
TYPE - 158-R
+DC | -DC | ACL | ACZ

MULTISTRETCH
MOTOR-1/2HP,90VDC

M-3 | 47 | 48 | N/C

SCR-3
NC | COM | NO | DC+ | DC- | ACL | ACZ | +IN | +17 | -IN | 3 | 2

92 FU-3 NDL-8A | 45 | MCR | 46

49 | 50 | 51 | 53 | 54

BLACK | BROWN | BLUE

HALL EFFECT SENSOR

1000/00 TO PAGE #2

63 VAC/DC-D TO PLC OUTPUT

#104 1000/13 TO PAGE #2 TO PLC INPUT

#64 LINE #64

INFEED CONVEYOR
MOTOR-1/8HP,90VDC

M-4 | 73 | 74

92 FU-4 MDL-8A | 71 | MCR | 72

SCR-4
TYPE - 858-D
+DC | -DC | ACL | ACZ | CONTR. 151 | CCW | W | CW | CCW

#111 N/C

1000/05

TURNTABLE CONVEYOR
MOTOR-1/8HP,90VDC

M-5 | 83 | 84

92 FU-5 MDL-8A | 81 | MCR | 82

SCR-5
TYPE - 858-D
+DC | -DC | ACL | ACZ | CONTR. 151 | CCW | W | CW | CCW

#111 N/C

1000/05

92 FU-6 GGC-8A | 164

JP1 OPTIONAL EMERGENCY STOP - PB. (TJBLOCKS PROVIPED)

E-STOP | 77 | 69 | START

MCR

MACHINE ENABLE INDICATOR G

MCR | 62 | TYPE - LC1-D09G7

TRANSFORMER
PRI - 120VAC
SEC - 12VAC
- 1PH
- 60HZ
- 250VA

92 FU-7 MDL-8A | 55 | C3 | 56

115VAC H1 H2

37 X1 X3 X2 X4

12VAC

HOT WIRE - CUTTER
- HOT WIRE-CUTTER SHOULD BE GAUGE 16.

92 FU-8 GGC-8A | 163 | LINE #163 TO PAGE #2

FU-9 GGC-8A | 76 | MCR | 66 | LINE #66 TO PAGE #2

ROTORSEAL 2- AIR FLOW	
SLIP-RING	
SECTION #	WIRE #
1	83
2	84

orion PACKAGING INC.
2270 INDUSTRIEL BOUL., LAVAL
QUEBEC, CANADA, H7S 1P9
TEL: (450) 687-9769

ORION PACKAGING INC.

2270 INDUSTRIEL BLVD LAVAL QUE., CANADA H7S 1P9
TEL: (450) 667-9769 FAX: (450) 667-6320

APPR. BY: J.B.S. DRAWN BY:

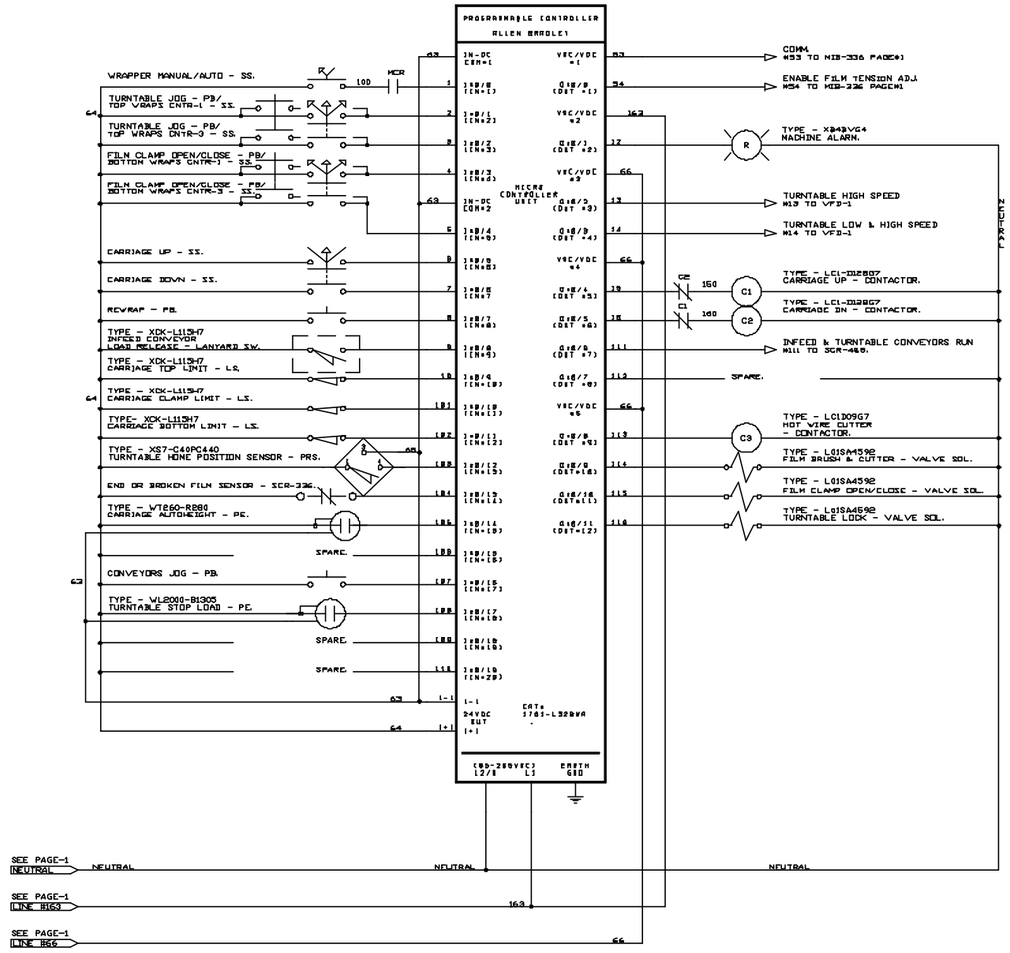
SCALED: NTS

TITLE: CTS67-17

SIZE: D | DOCUMENT NO. XXX # STANDARD: 302 753/1 | REV: 2

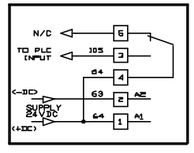
DATE: DEC-19-2003 | SHEET: 1 OF 2

FILENAME: CS67-17C.DWG | BASE:



NOTE:

- PHOTOCELL 'SICK' WT260-R880



ORION PACKAGING INC.

2270 INDUSTRIEL BLVD LAVAL, QUE., CANADA H7S 1P8
TEL: (450) 667-9760 FAX: (450) 667-6320

APP'D BY: J.B.S.	DRAWN BY:
SCALE: NTS	
TITLE: CTS67-17	
SIZE: D	DOCUMENT NO. JOB # STANDARD 302 753/2
REV: 2	
DATE: DEC-19-2005	SHEET: 2 OF 2
FILENAME: CS67-17P.DWG	BASE:

orion PACKAGING INC.
2270 INDUSTRIEL BOUL., LAVAL
QUÉBEC, CANADA, H7S 1P8
TEL: (450) 667-9760

CONTROL PANEL

The control panel layout is custom designed for each particular installation. Please before proceeding be familiar with location of the EMERGENCY button and all functions, switches and pushbuttons.

POWER SWITCHES

Main Disconnect Switch

ON - connects the power source to the machine.
OFF - disconnects the power source.

Power Switch

When the power switch is not actuated, all the inputs of the machine are operative but the outputs will remain disabled. This is a useful aspect for troubleshooting since the signal may be traced at the PLC without having the machine operate. When the power switch is activated, the outputs are enabled and the machine will resume normal operation.

Operation Mode Selector Switch

The two settings on the operation mode selector switch are:

MANUAL: Manual operation for use during the machine testing, set-up, or troubleshooting.

AUTO: Automatic operation when using the programmed commands of the automatic cycle.

When the switch is set to **MANUAL** the manual control switches are enabled. In order to begin machine testing or operational set-up, the operation mode MUST be set to **MANUAL**. This will permit the operator to use the manual switches described in this section.

When the mode selector switch is set to **AUTO**, the programmed commands stored in the PLC are operate and the **START** button may be pressed to permit normal automatic operation. The STOP button may be pressed to stop the cycle during operation. The mode selector switch may be switched from **AUTO** to **MANUAL** during the cycle for a transfer to manual operation.

MACHINE OPERATION

The operator unload the liftruck on the infeed conveyor and the load move to the turntable, without getting off the liftruck he activate the lanyard switch, which begin the wrapping cycle. During this time the operator is free to get an other load and do not need to wait at the wrapping operations going. The next load is unloaded on the infeed conveyor and the wrapped load is unloaded. When it’s done the operator activate the lanyard switch and the wrapping cycle goes again.

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 (rotary arm) may be returned to their home position by using the buttons in the **MANUAL** mode.

REWRAP SELECTOR

The REWRAP selector is a pushbutton switch that restarts the wrapping cycle during the automatic operation. The REWRAP will work only when the operation switch is set to **AUTO,** and a load is in the proper position for wrapping on the turntable (process conveyor).

CLAMP JOG

The Clamp Jog is a bistable pushbutton (except “MA” type machines*) that opens the clamp when pressed once and closes when pressed again. The mono-stable action is achieved through the use of a four-way pneumatic valve mounted on turntable (or process conveyor frame) next to the clamp. The **CLAMP JOG** will work only when the Operation Selector Switch is set to **MANUAL.**

*“MA” MODELS HAVE 3 POSITIONS RETURN SPRING SWITCH

CONVEYOR CONTROL SWITCHES

Conveyor Jog Switches

The Conveyor Control Switches are the pushbuttons type switches activating the conveyor when depressed. Each conveyor section has its own switch. Standard configuration is: Infeed, Process and Exit Conveyor. In case of extra conveyors (optional), the pushbutton switches will bear the number corresponding with particular conveyor (ex: Infeed # 2, # 3, etc. and Exit # 2, # 3 etc.).

Conveyor Reverse /Forward Switch

The conveyors reverse switch is a monostable two positions switch that reverses the flow direction of all/or chosen conveyor when activated. This Control Switch may be used & when the Operation Selector Switch is set to **MANUAL.**

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.

TOP WRAP FIRST (OPTIONAL)

The carriage rises 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 type switch with the
Following settings:

RAISE - raises the carriage until the top limit switch on the tower is attained.
LOWER - lowers the carriage until the bottom limit switch on the tower is attained.
This switch is normally positioned in the middle where the carriage remains stationary. Turning 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 is held depressed. When the switch is released the turntable (rotary tower) will stop. The switch is inoperative during the wrap cycle.

FILM TENSION

Film tension may be adjusted using the Film Tension Control Knob. It has a range of tension from 0 to 10: low range from 0 to 4, 4 to 8 is the most useful1 range for most of the films used by our customers and 8 to 10 considered 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 feedback is shown on drawing # 001.

Adjustment instructions:

- Remove the carriage cover
- Unbolt the two nuts holding the proximity switch (item # 1)
- Turn the Proximity sensor (item # 2) until the moment when the motor starts to turn (or hums)
- Tighten on the nuts securing the Proximity Sensor.

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.

CARRIAGE SPEED

There are two carriage speed controls on the panel:

CARRIAGE SPEED UP & CARRIAGE SPEED DOWN

The carriage speed controls can be used to control the amount of overlap the film will have on itself during a wrap. It is recommended to start with a RAPID upward wrap in order to stabilize the load early in the cycle.
The control potentiometers have settings from 0 to 10, the higher settings being the fastest. High settings will mean less film overlap because of faster carriage speed, and low settings will mean more film overlap because of lower carriage speed.

TOP AND BOTTOM WRAPS

There are two bistable, three position type switches controlling the number of wraps that may be put at the top and bottom of the load.

TOP WRAPS: 1,2,3
BOTTOM WRAPS: 1,2,3

These switches may be set before the automatic cycle begins, and in their different positions will wrap respectively 1,2 or 3 turns of the film on the top or on the bottom of the load.

PHOTOSWITCHES

Photoswitches are placed on the machine to monitor the motion and location of the loads on the conveyors. For each optional, additional conveyor on the machine an additional photoswitch will be added. The photoswitches are located as follows (shown on the machine layout) :

Load Height Sensing Photoswitch: located on the carriage and stops it from moving higher than the highest point on the load. The photoswitch position on the track can be adjusted in order to make the carriage pass the top of the load and make the film overlap the top.

Turntable Load Location Photoswitch: is the middle one of the three photoswitches that are pointed at the turntable from behind the tower. Its purpose is to stop the load on the turntable/process conveyor in a suitable position for wrapping. The turntable conveyor or process conveyor is programmed to stop approximately 1.5 seconds after this photoswitch is activated.

Turntable or Process Conveyor Safety Photoswitches: these are the three photoswitches pointed at the turntable or process conveyor from behind the tower. Their purpose is to prevent the cycle from starting if the load is not properly positioned on the turntable or process conveyor.

Infeed and Outfeed Photoswitches: these are located approximately one foot from the side of each conveyor in the middle of the section. Their purpose is to monitor the position of the loads as load transfers are occurring. When the photoswitch is activated there is a delay of approximately 1.5 seconds before the conveyor stops.

NOTE: When testing the conveyor without the load the photoswitch must be kept activated for at least 1.5 seconds in order to have the conveyor stop. For a downstream conveyor, when the load is moved out the photoswitches range there will be delay of about 5 seconds before an upstream conveyor is activated to move load.

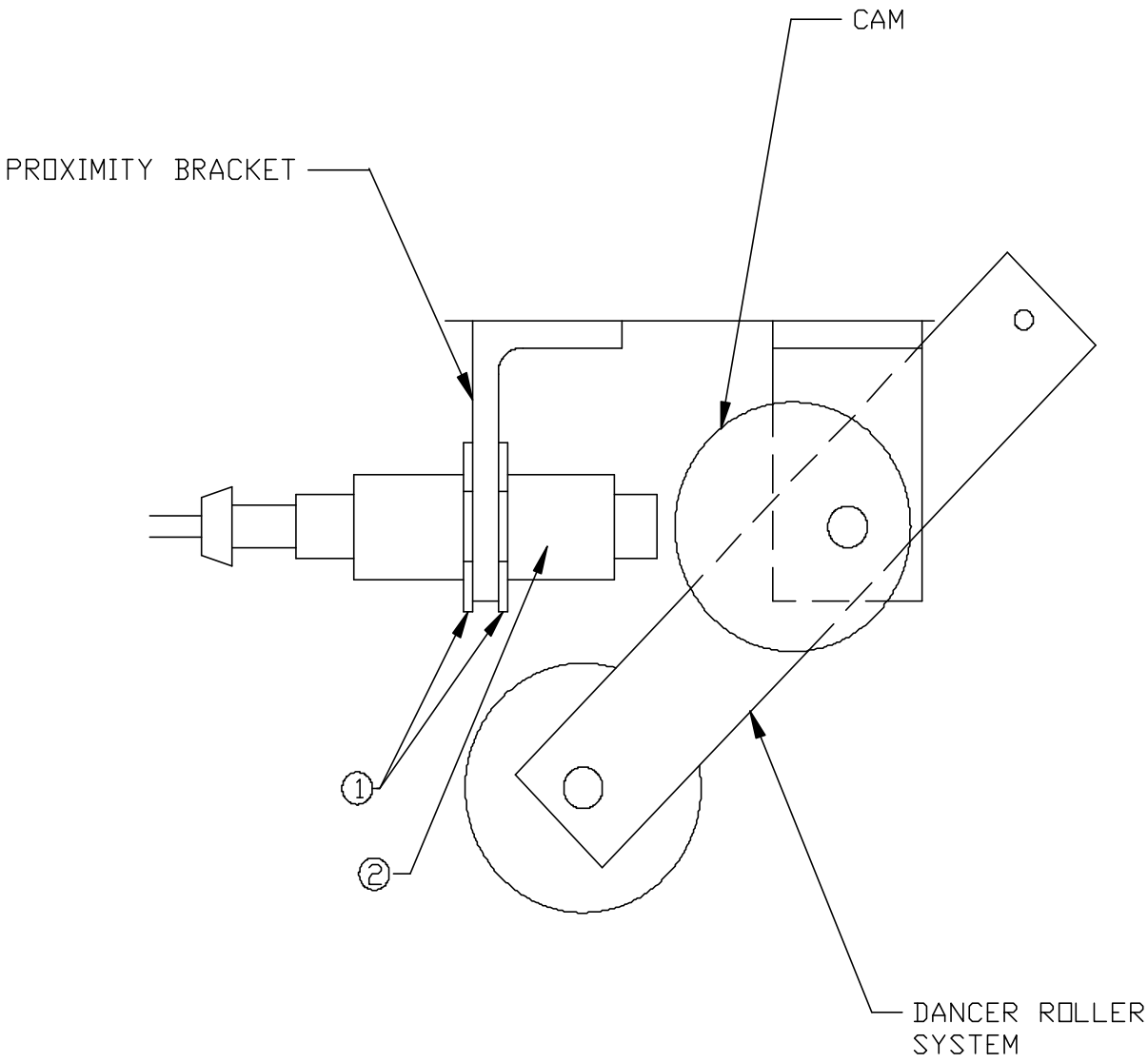
LIMIT SWITCHES.

There are three limit switches located on the tower. The top-most and bottom-most switches limits the motion of carriage determinate by location of the elevator's drive and idler sprocket. The middle limit switch purpose is to activate the clamp to open, once the carriage reaches its level.
CAUTION: These limit switches are factory adjusted. When setting the machine, please double check their proper position.

PROXIMITY SWITCH

Proximity Switch is located under the turntable next to the lock, or on the perch ("MA" type machine). Its purpose is to monitor the turntable or rotary arm position, and to signal the controller every time the turntable or rotary arm passes the home position. The proximity switches proper adjustment ensures that turntable or rotary tower will stop in the correct position for the lock to be activated (only turntable machine).

CAUTION: The Proximity Switch is factory adjusted and should not need any further adjustment unless it has been disturbed.



PROXIMITY SENSOR
FEED BACK ADJUSTMENT

DWG. # 001

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 (multistrech 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.

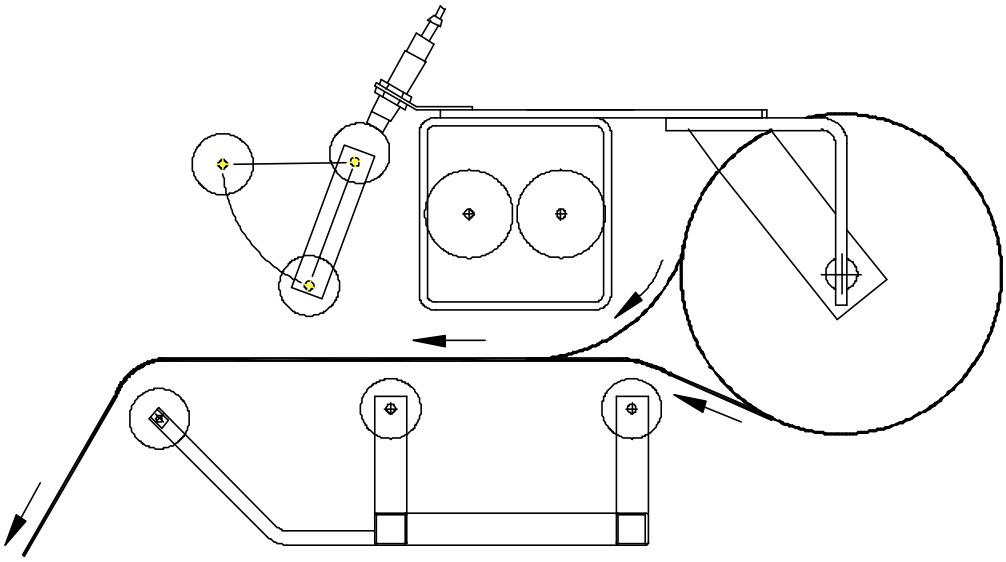


Fig. 1 OPEN CRADLE

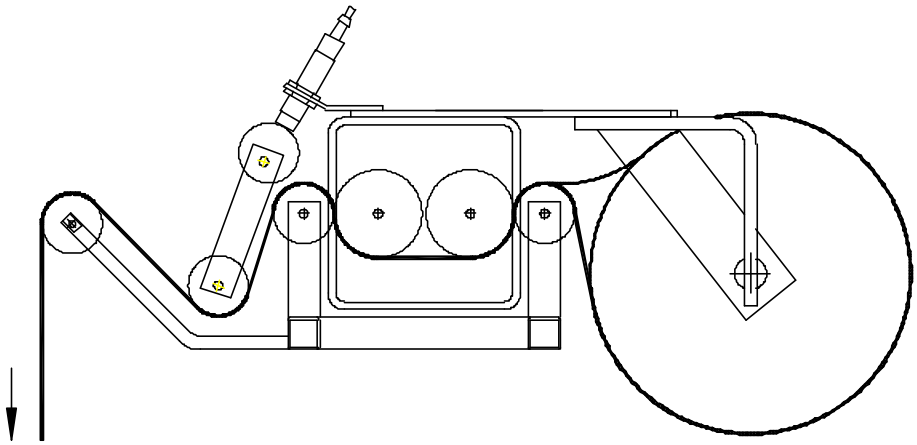


Fig. 2 CLOSED CRADLE

FILM QUICK THREADING

DWG # 418180

MACHINE MAINTENANCE

All general information about machine maintenance is based on normal machine working conditions: indoor, 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 l/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 Suer-r 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.

CAM FOLLOWER MAINTENANCE (when applicable)

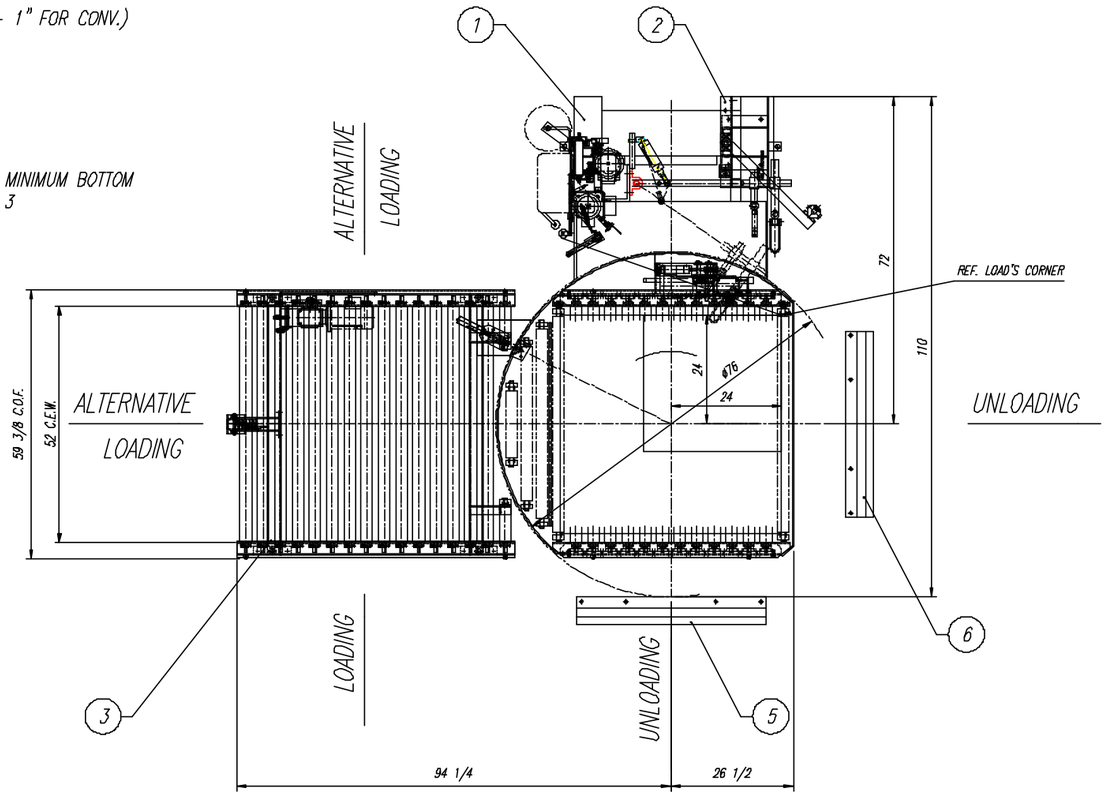
The cam followers have deep grease pockets and do not need frequent relubrication. The portion of the tower on which the cam followers run, should be cleaned and regreased every 300 hours of operation. If the machine operates in a dusty or corrosive environment the tower should be relubricated more often.

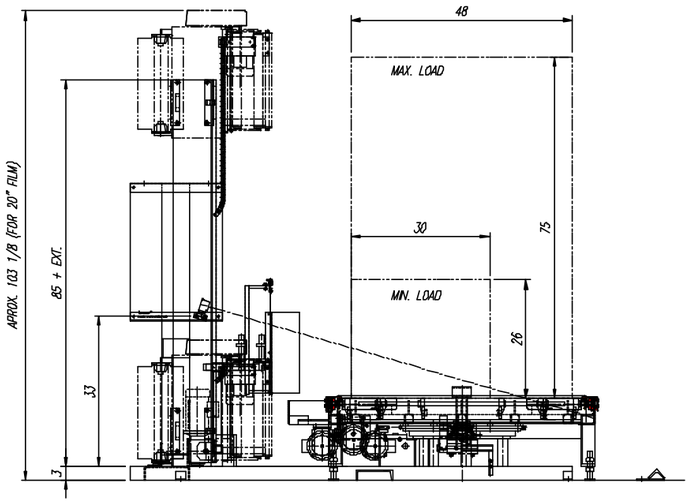
FULLY AUTOMATIC STANDARD ASSEMBLY PART LIST

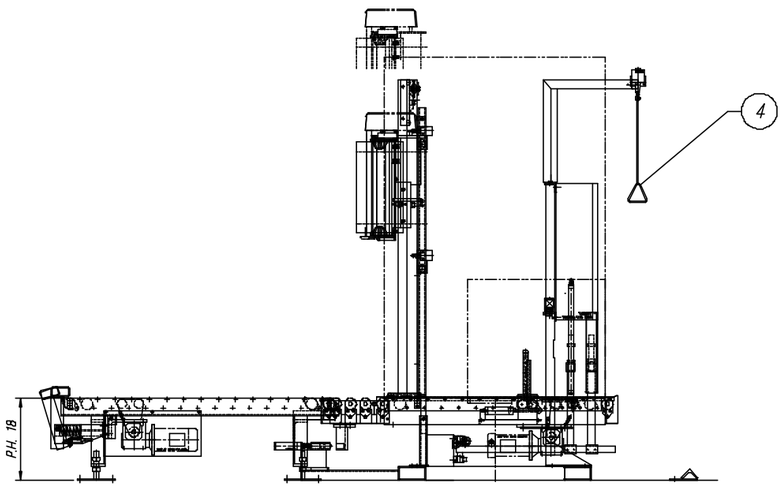
Note :
*** Quantity listed in order of part number**
** The names given to the parts are generic

NOTE :

1. CONVEYOR ROLLERS : 2 1/2" DIA. x 3 3/4" CENTERS , 52" EFECTIVE WIDTH
2. CONVEYOR PASS HEIGHT : 18" (FIXED FOR CENTRAL MODUL, ADJUSTABLE +/- 1" FOR CONV.)
3. CONVEYOR SPEED : 30 FPM
4. TURNTABLE SPEED : 12 RPM
5. MAX. LOAD SIZE : 48" L x 48" W x 75" H
6. MIN. LOAD SIZE : 30" L x 30" W x 26" H (*)
   (*) – FOR 20" FILM CARRIAGE. (FOR 30" FILM CARRIAGE IT IS 36" H)
7. LOAD WEIGHT : MIN. 200 Lbs , MAX. 4000 (**)
   (**) – IF PALLET BOTTOM BOARDS ARE PARALLEL TO CONVEYOR ROLLERS, THE MINIMUM BOTTOM BOARD WIDTH IS 4" , AND THE MINIMUM NUMBER OF BOTTOM BOARD IS 3
8. POWER REQUIREMENT : 115 VAC, 1 Ph, 60 Hz, 20 Amp
9. AIR SUPPLY : 3 CFM @ 80 PSI
10. MACHINE COLOR : "ORION STD. GREY"
11. REVERSING CONVEYOR







6	FORKLIFT WHEEL STOP			1	
5	FORKLIFT WHEEL STOP			1	
4	LANYARD SWITCH HANDLE ASS'Y			1	
3	5 FT CONTOUR ROLLER CONVEYOR			1	
2	ELECTRICAL PANEL STAND			1	
1	BASE & TOWER ASS'Y 76" DIA. TURNTABLE ASS'Y 20" INSTA-THREAD FILM CARRIAGE ASS'Y 20" FILM TAIL TREATMENT ASS'Y			1	
No.	DESCRIPTION	DWG SIZE	PART No.	Q'ty	WEIGHT

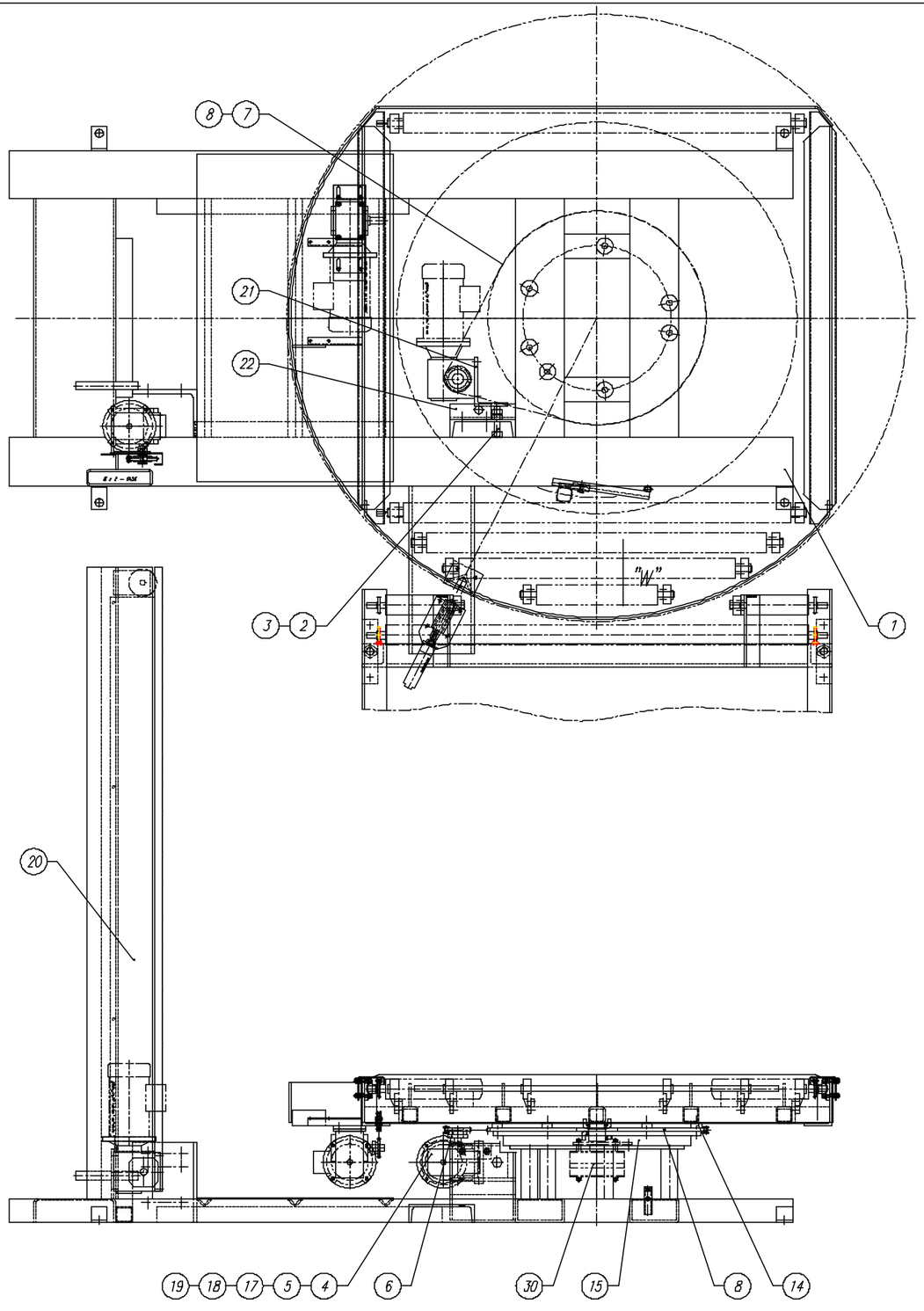
REMARKS:

REMARKS:

CTS 67 LAYOUT

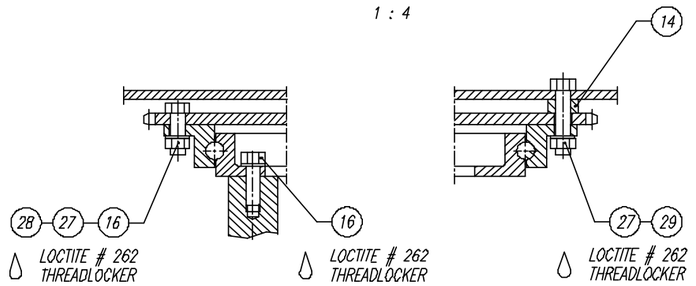
orion PACKAGING INC.
2270 INDUSTRIEL, LAVAL
QUEBEC, CANADA, H7S 1P9
TEL.: (514) 857-3769

ASSEMBLY DWG: –	JOB No.: STD 2003/2	DRAWING No.: 438880M
	DRAWN BY: S. KUBICKA	MACHINE TYPE: CTS67
	CHECKED BY: K. GLOWACKI	DRAWING SIZE: D
	DATE: AUG-29-2003	SCALE: 1 : 8

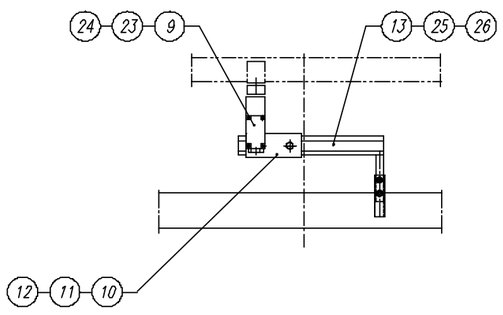


TURNTABLE BEARING MOUNTING

1 : 4



VIEW "W"



No.	DESCRIPTION	DWG SIZE	PART No.	Q'ty	WEIGHT
30	ROTORSEAL–SLIPRING ASS'Y (4 WIRES)		427861	1	
29	HEX HEAD SCREW		013405	6	
28	CENTERING BUSHING		402388	4	
27	HEX. NUT		012846	10	
26	HEX. NUT		013407	2	
25	HEX HEAD SCREW		013470	2	
24	HEX. NUT		012726	2	
23	RD. HEAD PHILLIPS SCREW		012858	2	
22	TOP BRACKET		403103	1	
21	REDUCER BASE		436762	1	
20	TUBULAR TOWER (L – R) ASS'Y		438882	1	
19	SPRING WASHER		012724	4	
18	FLAT WASHER		012725	4	
17	HEX HEAD SCREW		010455	4	
16	HEX HEAD SCREW		012847	11	
15	TURNTABLE BEARING		014671	1	
14	TT. SPACER		270060	6	
13	PROXIMITY SWITCH CHANNEL		260972	1	
12	HEX HEAD SCREW		012474	1	
11	CHANNEL GUIDE		220518	1	
10	PROXIMITY SWITCH HOLDER		260817	1	
9	PROXIMITY SWITCH		010739	1	
8	SPROCKET		415961	1	
7	CHAIN		011484	1	
6	SPROCKET		011226	1	
5	REDUCER		015699	1	
4	EL. MOTOR		017851	1	
3	HEX. NUT		012992	1	
2	ADJUSTING SCREW		403264	2	
1	SA66 BASE WELDING (L – R)		436211	1	

REMARKS:

REMARKS:

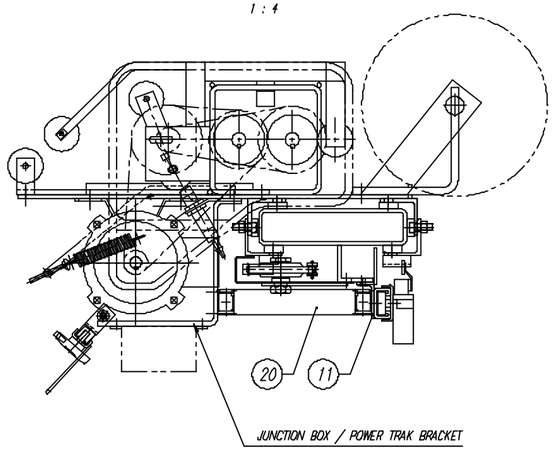
CTS67 BASE & TOWER ASS'Y (L – R)

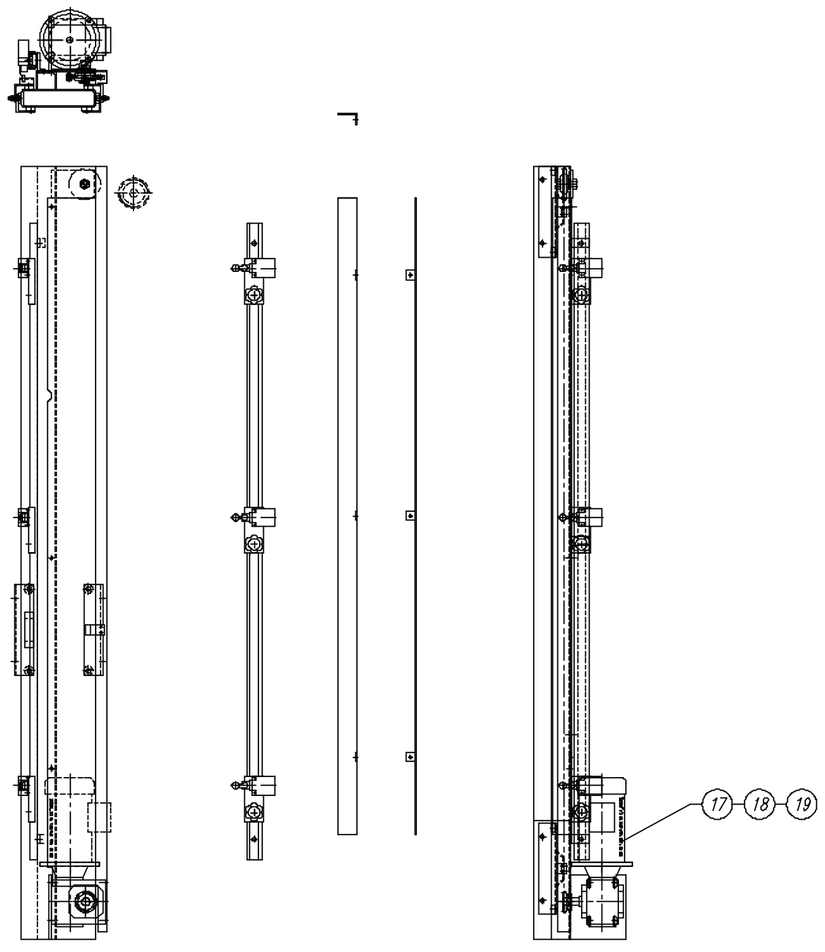
orion
PACKAGING INC.
2270 INDUSTRIEL, LAVAL
QUEBEC, CANADA, H7S 1P9
TEL.: (514) 667-9769

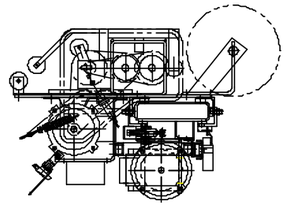
DATE: AUG-29-2003		SCALE: 1 : 8
DRAWN BY: S. KUBICKA		MACHINE TYPE: CTS67
CHECKED BY: K. GLOWACKI		DRAWING SIZE: D
ASSEMBLY DWG: 438880 D	JOB No.: STD 2003/2	DRAWING No.: 438881M

POWER TRAK MOUNTING

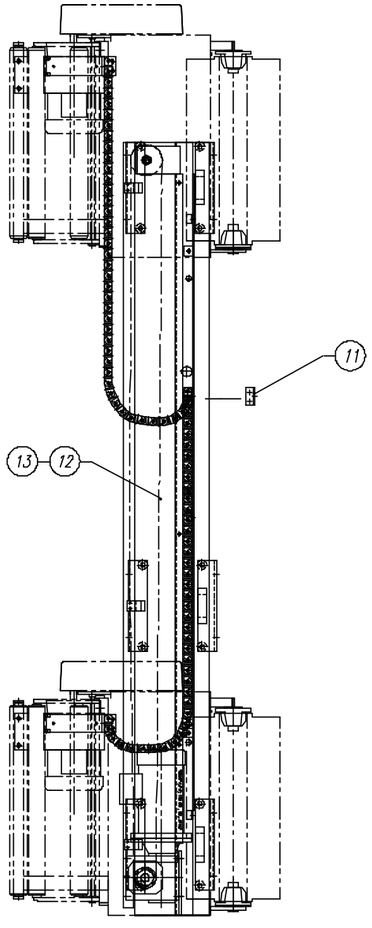
1 : 4





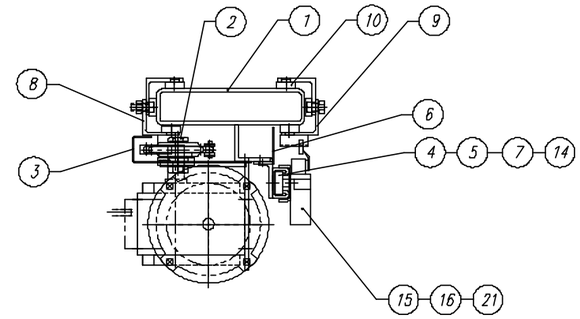


"W"



VIEW "W"

1 : 4



No.	DESCRIPTION	DWG SIZE	PART No.	Q'ty	WEIGHT
21	LIMIT SWITCH		010123	3	
20	NYLATRAC		015897	1	
19	SPROCKET		010074	1	
18	REDUCER		015700	1	
17	EL. MOTOR		017851	1	
16	HEX. NUT		012726	6	
15	PAN PHILL SCREW		012481	6	
14	HEX. HEAD SCREW		012474	3	
13	CHAIN LINK		010009	2	
12	ROLLER CHAIN		010009	1	
11	TOWER POWER TRAK BRACKET		435272	1	
10	SLIDE BUTTON		427058	12	
9	CARRIAGE ATTACHMENT ANGLE W/ACTUATOR		424814	1	
8	CARRIAGE CHAIN ATTACHMENT ANGLE		420000	1	
7	CHANNEL GUIDE		220518	3	
6	LIMIT SWITCH CABLE COVER		436276	1	
5	LIMIT SWITCH HOLDER		260816	3	
4	LIMIT SWITCH CHANNEL		409047	1	
3	CHAIN GUARD (L-R)		436281	1	
2	IDLER SPROCKET ASS'Y		420809	1	
1	TUBULAR TOWER 8 x 2 WELDING (L-R)		436274	1	

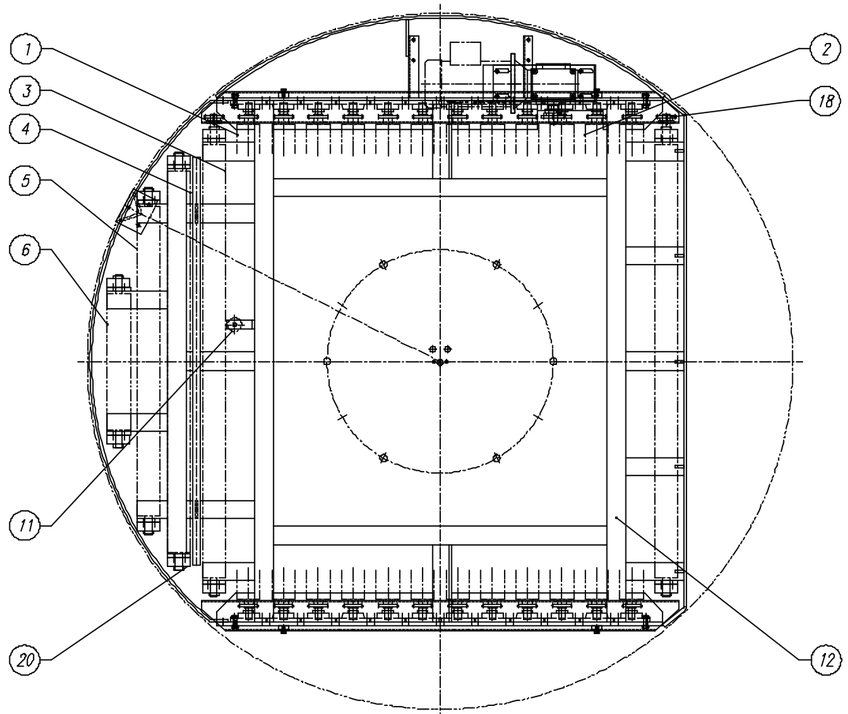
REMARKS:

REMARKS:

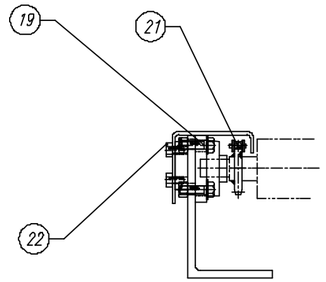
CTS67 TUBULAR TOWER 8 x 2 ASS'Y (L-R)

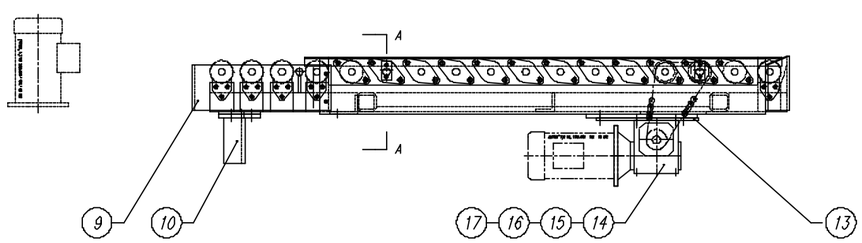
orion
PACKAGING INC.
2270 INDUSTRIEL, LAVAL
QUEBEC, CANADA, H7S 1P9
TEL.: (514) 667-9769

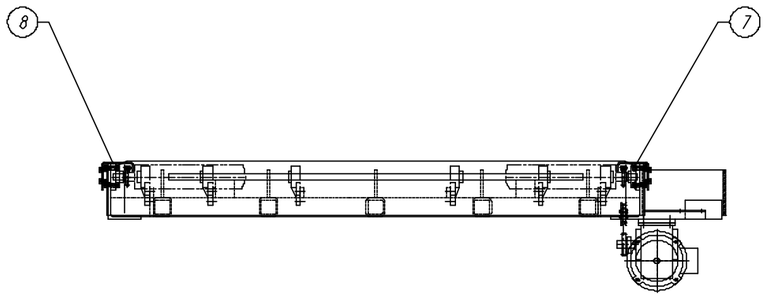
ASSEMBLY DWG: 438880 D	JOB No.: STD 2003/2	DRAWING No.: 438882M
	DRAWN BY: S. KUBICKA	MACHINE TYPE: CTS67
	CHECKED BY: K.GLOWACKI	DRAWING SIZE: D
	DATE: AUG-29-2003	SCALE: 1 : 8



A – A
1 : 4







No.	DESCRIPTION	DWG. SIZE	PART No.	Q'ty	WEIGHT
22	HEX. HEAD CAP SCREW		013471	8	
21	ROLLER CHAIN		010583	12	
20	BEARING		012341	10	
19	CONVEYOR CHAIN GUARD & BEARING. ASS'Y		436896	24	
18	SPROCKET		010748	2	
17	ROLLER CHAIN		010009	1	
16	SPROCKET		010411	1	
15	EL MOTOR		017851	1	
14	REDUCER		015189	1	
13	REDUCER BASE		200626	1	
12	CTS67 TURNTABLE WELDING		437969	1	
11	PROXIMITY SWITCH TARGET		402711	1	
10	TURNTABLE LOCK CATCH		436221	1	
9	INFEED SIDE GUARD		436218	1	
8	CHAIN GUARD		437976	1	
7	DRIVE SIDE CHAIN GUARD		437977	1	
6	ROLLER		410045	1	
5	ROLLER		410046	1	
4	ROLLER		409971	1	
3	ROLLER		414494	2	
2	MEDIUM DUTY DRIVE ROLLER		434967	2	
1	MEDIUM DUTY BASIC ROLLER		434966	10	

REMARKS:

REMARKS:

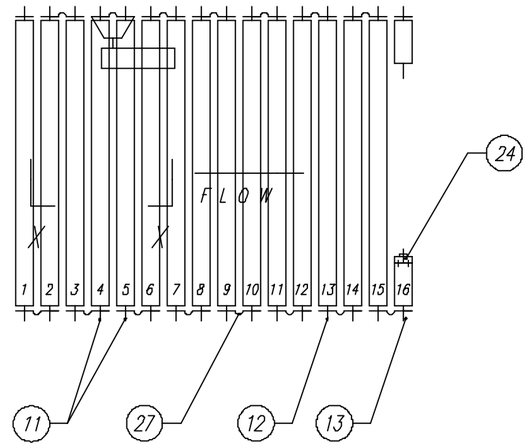
CTS67 76" DIA. TURNTABLE W/ROLLER CONVEYOR L-R

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

DATE: AUG-29-2003		SCALE: 1 : 8
DRAWN BY: S. KUBICKA		MACHINE TYPE: CTS67
CHECKED BY: K. GLOWACKI		DRAWING SIZE: D
ASSEMBLY DWG.: 438880 D	JOB No.: STD 2003/2	DRAWING No.: 438883M

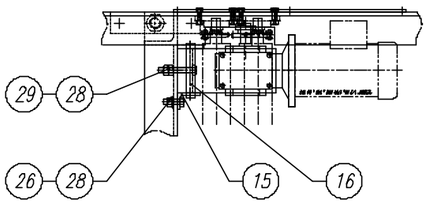
DIAGRAM

N T S



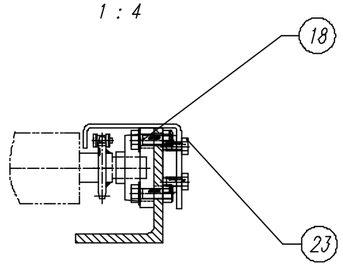
X – X

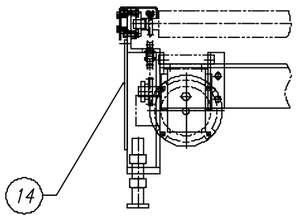
CONV. DRIVE ASS'Y

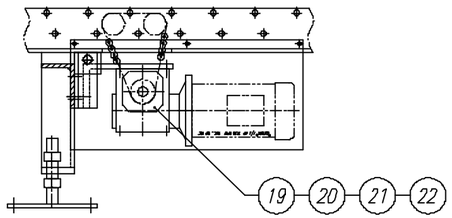


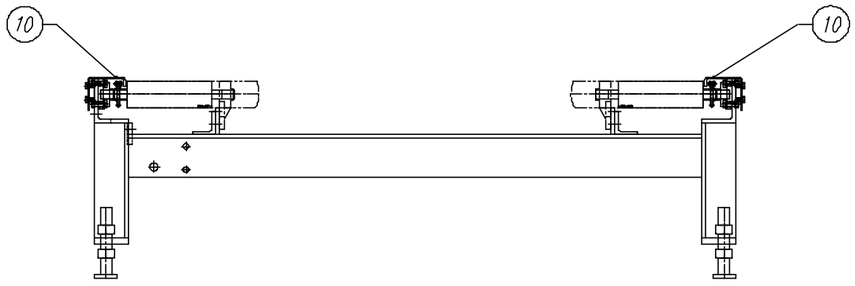
B – B

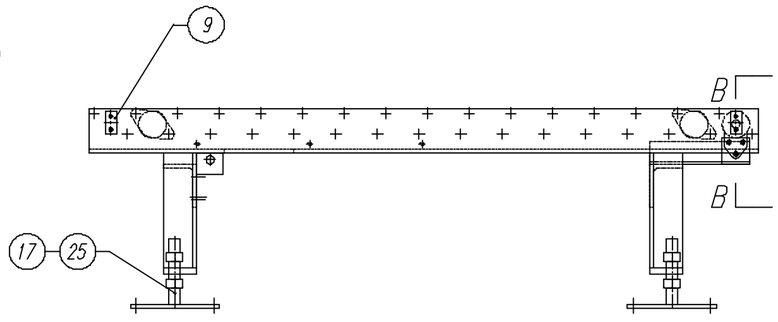
1 : 4











No.	DESCRIPTION	DWG. SIZE	PART No.	Q'ty	WEIGHT
29	HEX. HEAD CAP SCREW		010408	1	
28	REGULAR HEX. NUT		011266	4	
27	ROLLER CHAIN		010583	14	
26	HEX. HEAD CAP SCREW		010287	2	
25	HEX. NUT		012688	8	
24	BEARING		012341	2	
23	HEX. HEAD CAP SCREW		013471	8	
22	ROLLER CHAIN		010009	1	
21	SPROCKET		010411	1	
20	REDUCER		015189	1	
19	EL. MOTOR		017851	1	
18	CONVEYOR CHAIN GUARD & BEARING ASS'Y		436896	32	
17	LEG		240868	4	
16	REDUCER BASE		403685	1	
15	BRACKET R.H.		408196	1	
14	CONVEYOR DRIVE GUARD		436184	1	
13	MEDIUM DUTY CONTOUR ROLLER		434968	2	
12	MEDIUM DUTY BASIC ROLLER		434966	13	
11	MEDIUM DUTY DRIVE ROLLER		434967	2	
10	5 FT CHAIN GUARD		436968	2	
9	CONVEYOR CHAIN GUARD SPACER		436894	4	

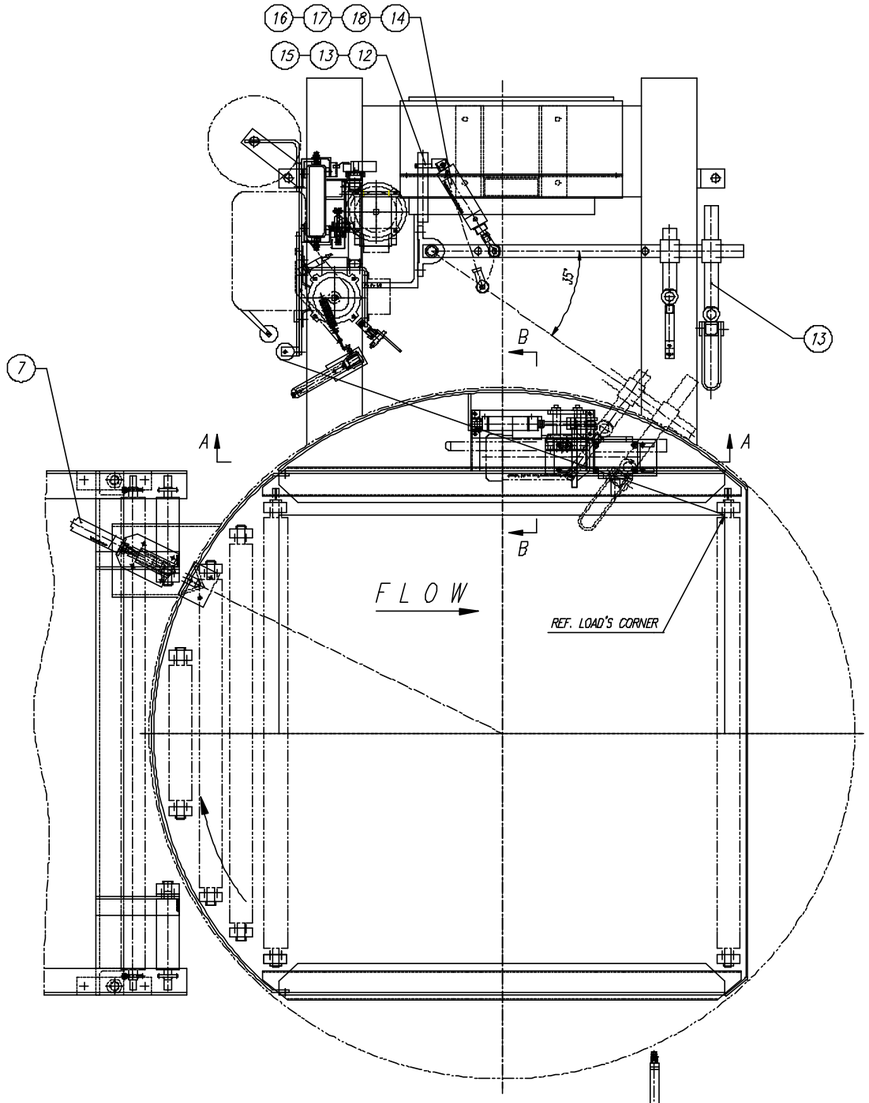
REMARKS:

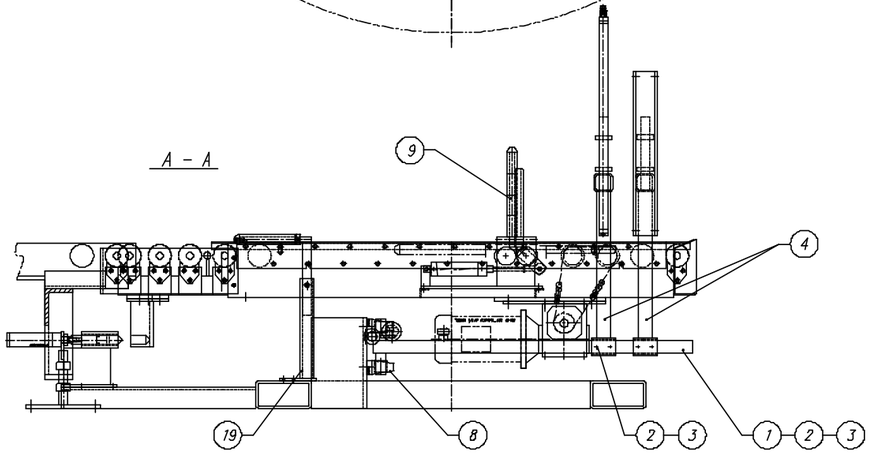
REMARKS:

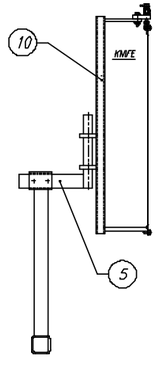
CTS67– 5 FT LG CONTOUR ROLLER CONVEYOR L–R

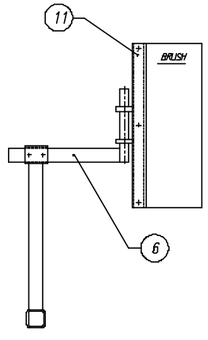
orion
PACKAGING INC.
2270 INDUSTRIEL, LAVAL
QUEBEC, CANADA, H7S 1P9
TEL.: (514) 667-9769

DATE: AUG-29-2003		SCALE: 1 : 8
DRAWN BY: S. KUBICKA		MACHINE TYPE: CTS67
CHECKED BY: K. GLOWACKI		DRAWING SIZE: D
ASSEMBLY DWG.: 438880 D	JOB No.: STD 2003/2	DRAWING No.: 438884M









19	ROPING ROLLER ASS'Y		431001	1	
18	FLAT WASHER		017494	1	
17	SOCKET HD CAP SCREW		010191	1	
16	AIR CYLINDER		014167	1	
15	CYLINDER HOLDER		424885	1	
14	ROD END		013813	1	
13	HEX. NUT		011128	1	
12	HEX. HEAD CAP SCREW		013479	1	
11	20" BRUSH ASS'Y		417539	1	
10	20" HOT WIRE CUTTER ASS'Y		417750	1	
9	FILM CLAMP ASS'Y R.H.		414433	1	
8	BEARING		011191	2	
7	TURNTABLE POSITIONING LOCK ASS'Y		436080	1	
6	ARM SEGMENT		404925	1	
5	KNIFE ARM SEGMENT		417244	1	
4	BRUSH HOLDER		412236	2	
3	HEX NUT		012751	8	
2	HEX BOLT		012757	8	
1	CUTTER-BRUSH ARM		427730	1	
No.	DESCRIPTION	DWG SIZE	PART No.	Q'ty	WEIGHT

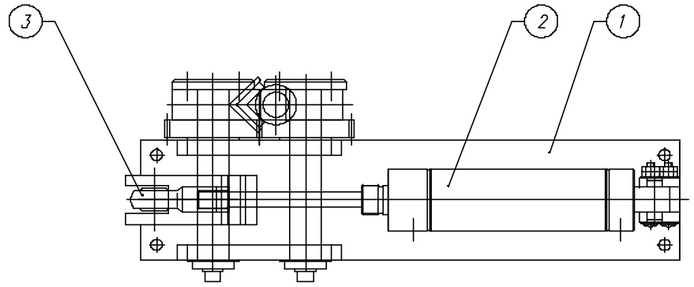
REMARKS:

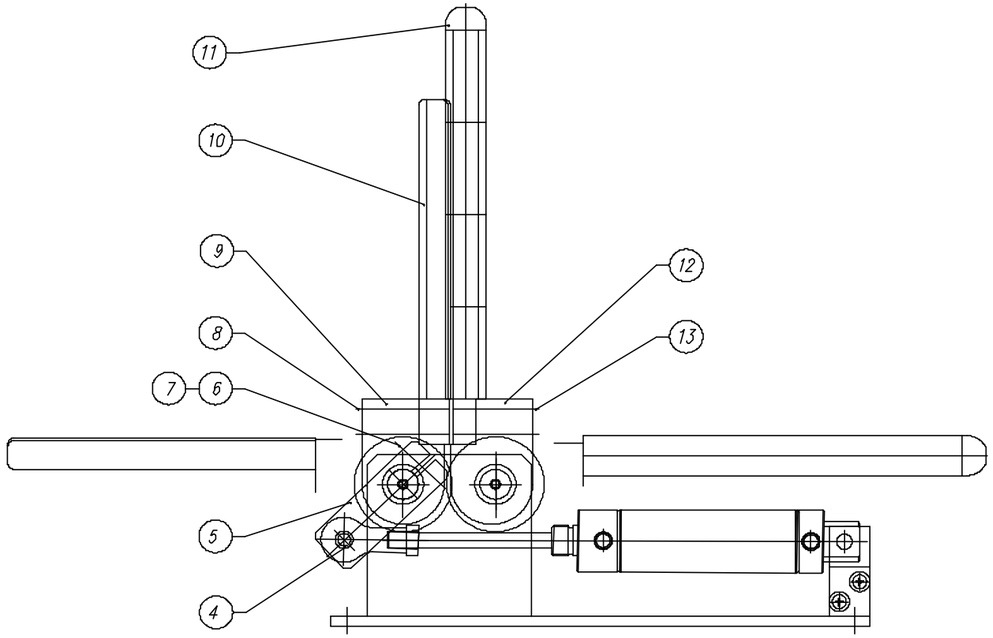
REMARKS:

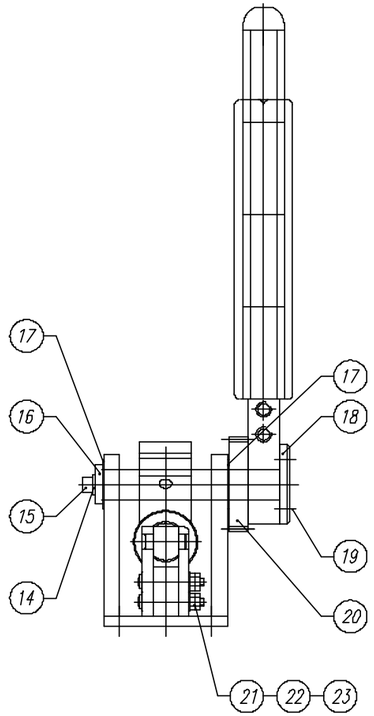
CTS67 FILM TAIL TREATMENT

orion
PACKAGING INC.
2270 INDUSTRIEL, LAVAL
QUEBEC, CANADA, H7S 1P9
TEL.: (450) 667-9769

ASSEMBLY DWG: 438880 D	JOB No.: STD 2003/2	DRAWING No.: 438916M
DRAWN BY: S. KUBICKA	CHECKED BY: K. GLOWACKI	DATE: SEP-04-03
SCALE: 1 : 8	MACHINE TYPE: CTS67	DRAWING SIZE: D







23	FLAT WASHER		013335	4	
22	HEX NUT		012726	4	
21	PAN PHIL		012858	2	
20	SPUR GEAR		011384	2	
19	FLAT CAP SCREW		012671	6	
18	CLAMP JAW PIVOT SHAFT		260558	2	
17	THRUST WASHER		010193	4	
16	FLAT WASHER		011381	2	
15	HEX SOCKET SCREW		010286	2	
14	SPRING WASHER		011393	2	
13	HEX SOCKET SCREW		012834	2	
12	SMOOTH JAW HOLDER		401184	1	
11	SMOOTH JAW		400810	1	
10	JAW WITH RUBBER		400811	1	
9	JAW WITH RUBBER HOLDER		401185	1	
8	HEX SOCKET SCREW		012686	2	
7	SPRING WASHER		011390	1	
6	HEX HEAD SCREW		012406	1	
5	CLAMP YOKE		421689	1	
4	SPRING PIN		010264	1	
3	ROD END		011201	1	
2	AIR CYLINDER		014150	1	
1	CLAMP BASE		414465	1	
No.	DESCRIPTION	DWG. SIZE	PART No.	Q'ty	WEIGHT

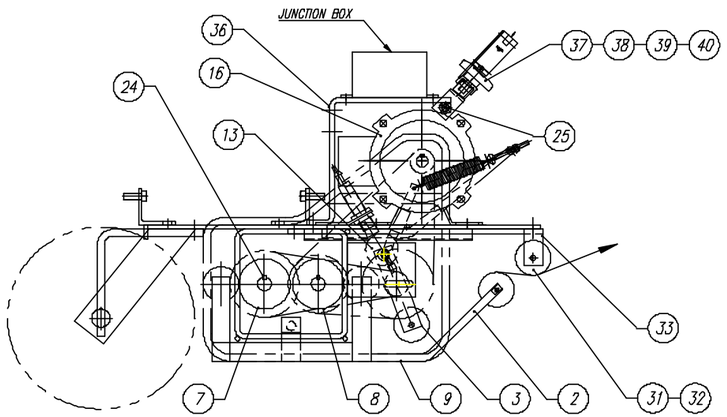
REMARKS:

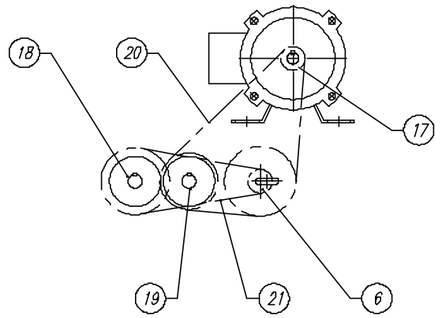
REMARKS:

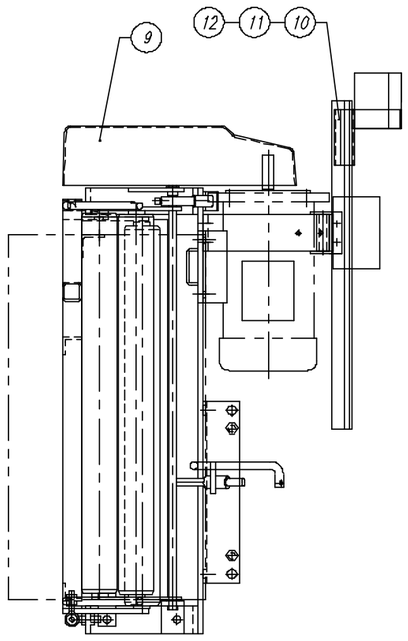
FILM CLAMP ASSEMBLY – R.H.

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

DATE: DEC-09-1996		SCALE: 1 : 2
DRAWN BY: G. SEWERYN		MACHINE TYPE: FA , MA
CHECKED BY:		DRAWING SIZE: D
ASSEMBLY DWG.:	JOB No.: STD	DRAWING No.: 414433M







No.	DESCRIPTION	DWG. SIZE	PART No.	Q'ty	WEIGHT
40	BLACK KNOB		010092	1	
39	PAN PHILL SCREW		012481	2	
38	HEX. NUT		012726	2	
37	CHANNEL GUIDE		427690	1	
36	JUNCTION BOX/POWER TRAK BRACKET		435553	1	
35	BOTTOM SPOOL WASHER		432322	1	
34	BOTTOM SPOOL		432323	2	
33	20" (30") ROLLER BRACKET (FLR)		427276	1	
32	IDLE ROLLER SHAFT-20"		413249	1	
31	ALUMINUM ROLLER 1.9 - 20"		402789	1	
30	HEX. NUT		012689	1	
29	FLAT WASHER		012221	1	
28	SOCK. HD. CAP SCREW		010259	1	
27	PILLOW BLOCK		011192	4	
26	FLAT WASHER		012323	1	
25	HEX. HEAD SCREW		012474	2	
24	SQ. KEY		010227	3	
23	FL. BRONZE BUSHING		014247	2	
22	SELF SEATING RETAINING RING		013860	2	
21	CHAIN		013397	1	
20	TIMMING BELT		011151	1	
19	PULLEY		431672	1	
18	SPROCKET (245 %)		428647	1	
17	PULLEY		431477	1	
16	EL. MOTOR		015240	1	
15	CRADLE ROLLER OPENING LOCK		409469	2	
14	TENSION SCREW ASS'Y		433628	1	
13	PROXIMITY SENSOR CAM		413744	1	
12	PHOTOCELL BRACKET		435397	1	
11	PHOTOCELL HOLDER (FLR, FRL)		432739	1	
10	PHOTOCELL CHANNEL		434651	1	
9	FIBERGLASS COVER - FLR		414854	1	
8	RUBBER ROLLER - 2 (20" FILM)		420917	1	
7	RUBBER ROLLER - 1 (20" FILM)		420916	1	
6	SPROCKET / PULLEY ASS'Y		431475	1	
5	TOP MANDREL FLR		414853	1	
4	DANCER ROLLER BRACKET FLR		414852	1	
3	DANCER ROLLER ASSEMBLY - 20" IT, FLR		414843	1	
2	CRADLE ROLLER ASSEMBLY - 20" IT, FLR		426137	1	
1	BACK PLATE - 20" INSTA-THREAD, FLR		438964	1	

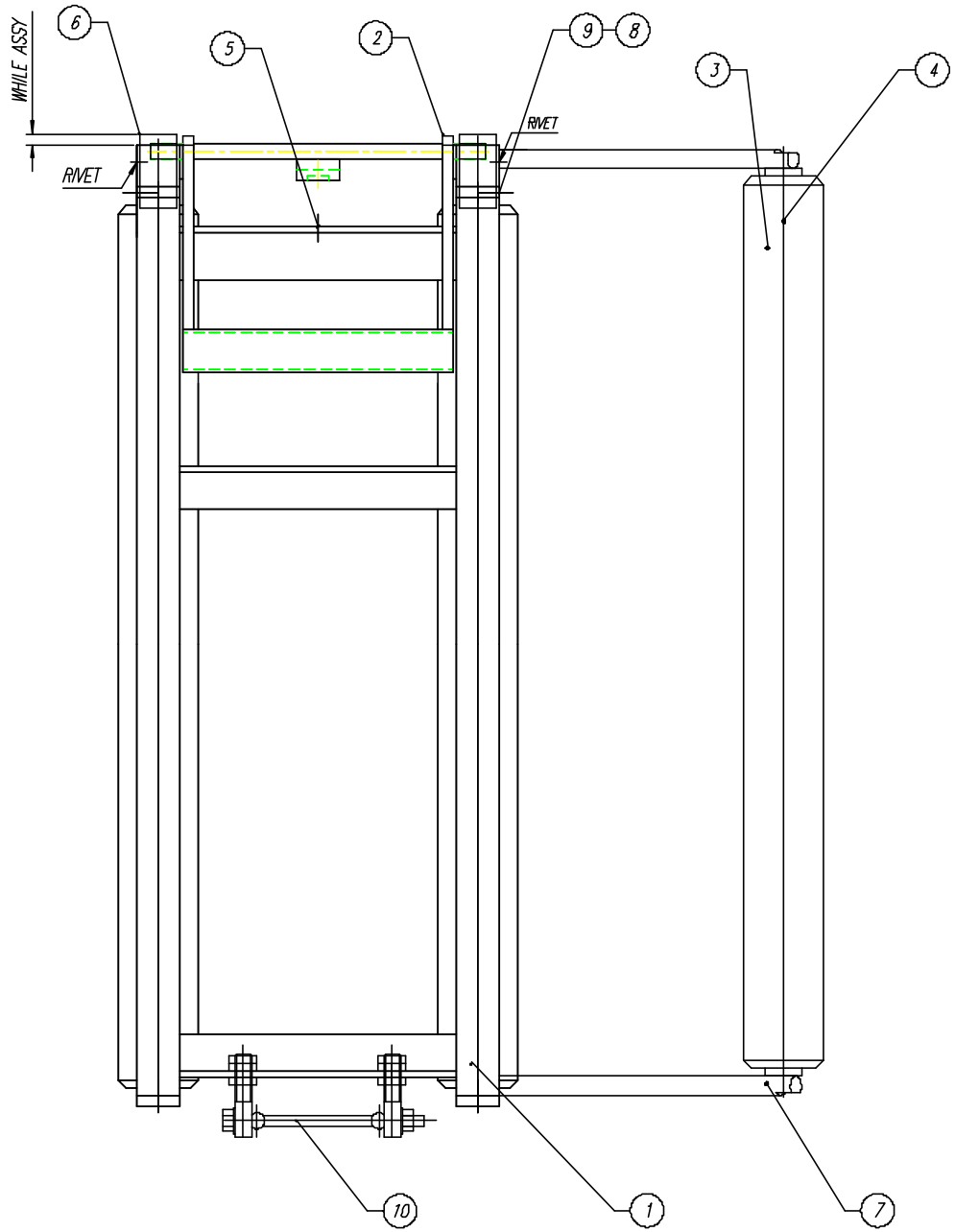
REMARKS:

REMARKS:

20" INSTA-THREAD FILM CARRIAGE ASS'Y (FLR)

orion
PACKAGING INC.
2270 INDUSTRIEL, LAVAL
QUEBEC, CANADA, H7S 1P9
TEL.: (450) 667-9789

ASSEMBLY DWG.: –	JOB No.: STD 2003/2	DRAWN BY: S. KUBICKA	DATE: SEP-02-2003
		CHECKED BY: –	SCALE: 1 : 4
			MACHINE TYPE: CTS67
			DRAWING SIZE: D
			DRAWING No.: 438885M



No.	DESCRIPTION	DWG. SIZE	PART No.	Q'ty	WEIGHT
10	CRADLE HINGE ASS'Y		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		413249	3	
3	ALUMINIUM ROLLER 1.9 DIA - 20 LG		402789	3	
2	LOCK		412542	1	
1	CRADLE ROLLER FRAME - 20" (FLR)		426138	1	

REMARKS:

REMARKS:

CRADLE ROLLER ASSEMBLY - 20 (FLR)

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

DATE: DEC-13-99

SCALE: 1 : 2

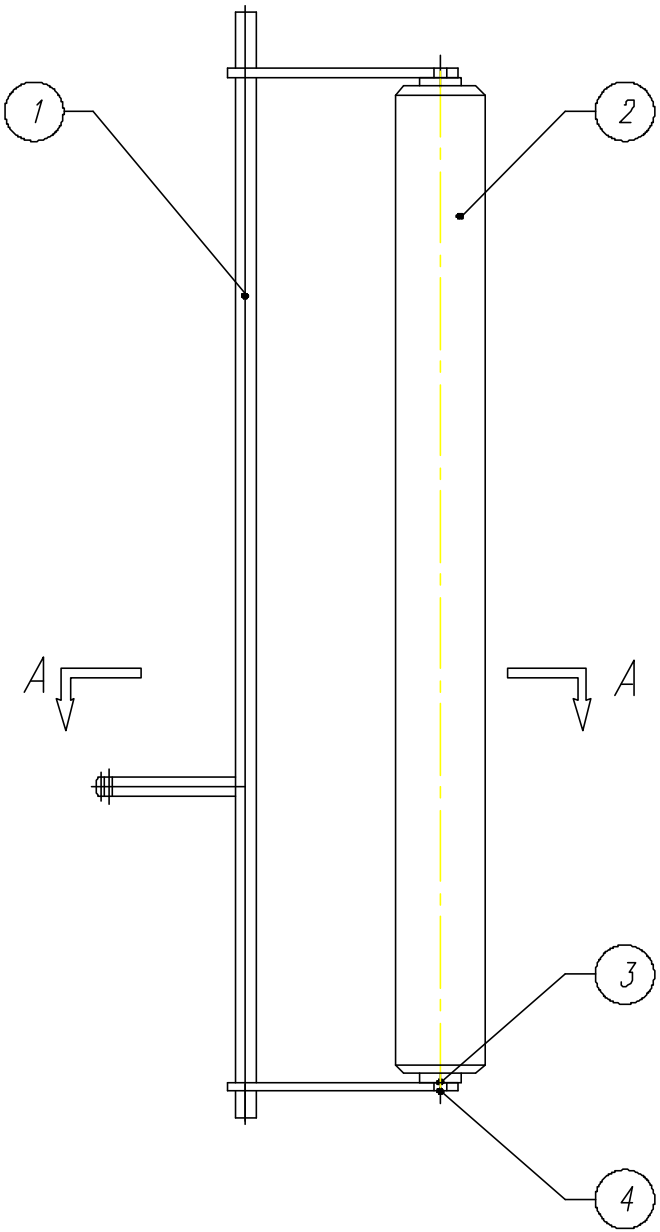
MACHINE TYPE: H,L/14

DRAWING SIZE: C

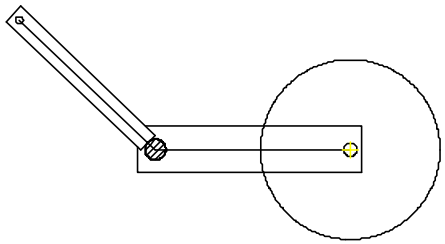
ASSEMBLY DWG.: -

JOB No.: STD

DRAWING No.: 426137M



A – A



No.	DESCRIPTION	DWG. SIZE	PART No.	Q'ty	WEIGHT
4	HEX HEAD SCREW		012475	2	
3	FLANGE NUT		014164	2	
2	ALUMINIUM ROLLER 1.9 DIA – 20		402789	1	
1	DANCER ROLLER CRADLE – 20 (FLR)		414851	1	

REMARKS:

REMARKS:

DANCER ROLLER ASSEMBLY – 20 (FLR)

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

DATE: JAN-23-1997

SCALE: 1 : 4

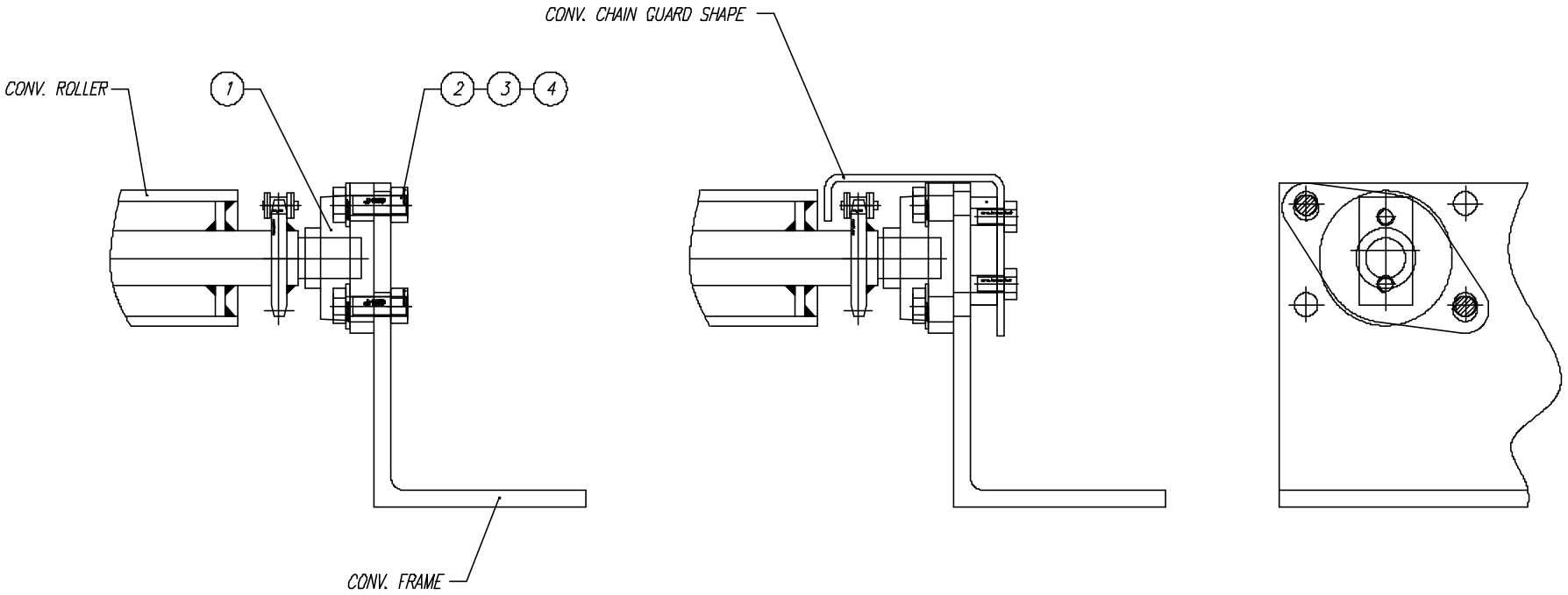
MACHINE TYPE: ALL/12

DRAWING SIZE: A

ASSEMBLY DWG.: 438636M

JOB No.: STD – 12.1

DRAWING No.: 414843M



No.	DESCRIPTION	DWG. SIZE	PART No.	Q'ty	WEIGHT
4	FL. WASHER		017298	2	
3	HEX. REGULAR NUT		014238	2	
2	HEX. HEAD CAP BOLT		014510	2	
1	BEARING		010042	1	

REMARKS:

REMARKS:

CONVEYOR CHAIN GUARD & 3/4" BRG ASS'Y

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

DATE: NOV. 26. 2002

SCALE: 1 : 2

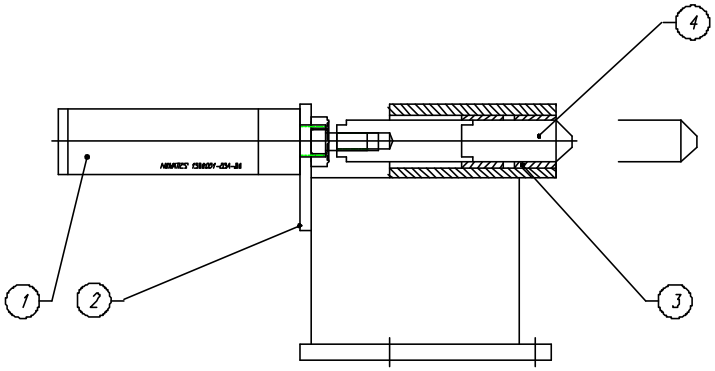
MACHINE TYPE: 33, 44, 55, 66

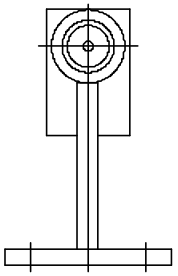
DRAWING SIZE: B

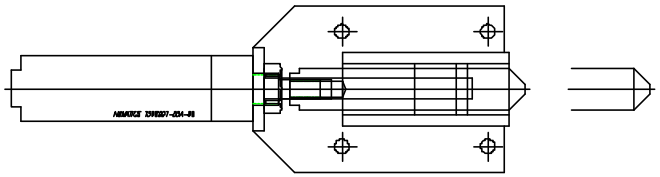
ASSEMBLY DWG.: —

JOB No.: STD

DRAWING No.: 436896M







No.	DESCRIPTION	DWG. SIZE	PART No.	Q'ty	WEIGHT
4	LOCK SHAFT		436215	1	
3	BRONZE BEARING		012925	2	
2	TURNTABLE LOCK BRACKET		436081	1	
1	AIR CYLINDER		014166	1	

REMARKS:

REMARKS:

TURNTABLE POSITIONING LOCK

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

DATE: SEP. 30. 2002

SCALE: 1 : 2

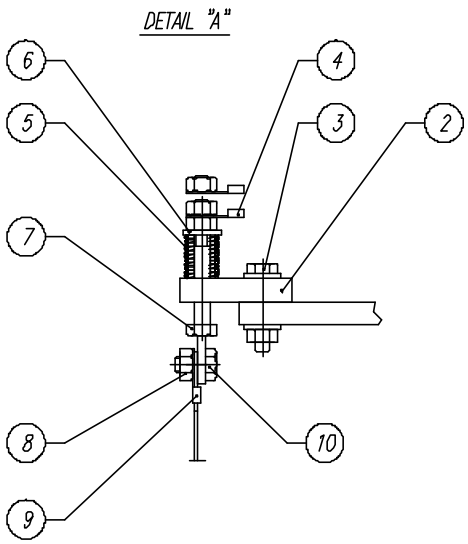
MACHINE TYPE: FA55

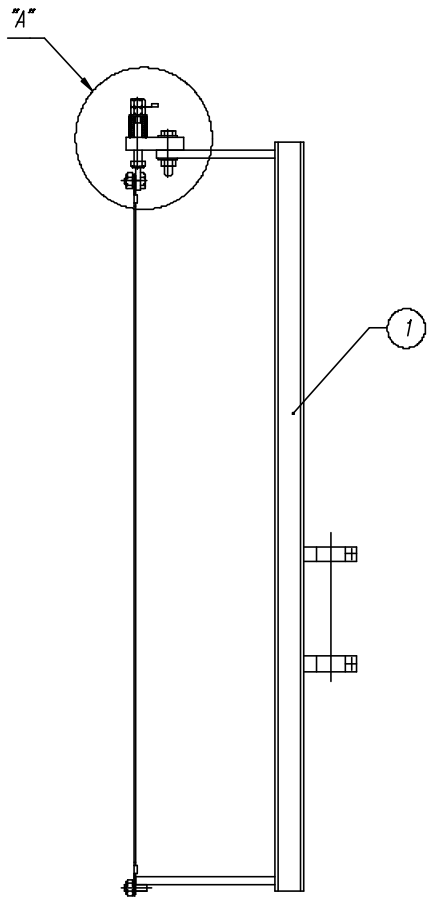
DRAWING SIZE: C

ASSEMBLY DWG.: 436049 D

JOB No.:

DRAWING No.: 436080M





No.	DESCRIPTION	DWG SIZE	PART No.	Q'ty	WEIGHT
10	HEX. HEAD CAP SCREW		012722	1	
9	CUTTING WIRE		402745	1	
8	HEX. NUT		012689	5	
7	WIRE ATTACHMENT		409351	1	
6	FLAT WASHER		012221	1	
5	COMPR. SPRING		013995	1	
4	TERMINAL RING		010693	1	
3	HEX. HEAD CAP SCREW		012793	1	
2	HOT WIRE BRACKET		409350	1	
1	20" CUTTING WIRE BRACKET		417752	1	

REMARKS:

REMARKS:

20" HOT WIRE CUTTER ASS'Y

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

DATE: OCT-30-1997

SCALE: 1 : 4

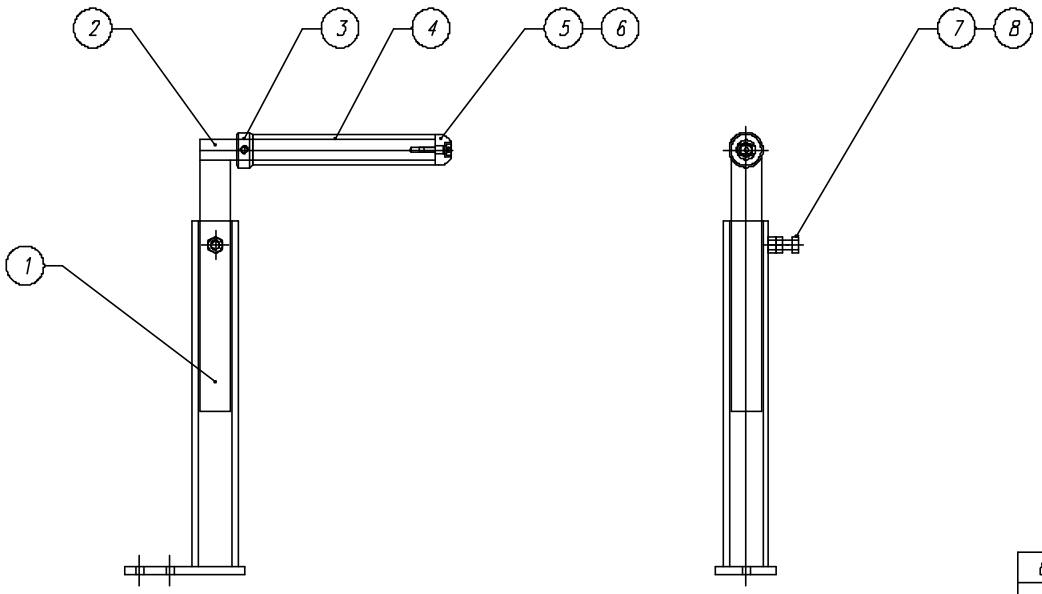
MACHINE TYPE: ALL-66

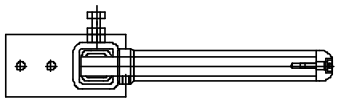
DRAWING SIZE: B

ASSEMBLY DWG: -

JOB No.: 13405

DRAWING No.: 417750M





TOP VIEW

No.	DESCRIPTION	DWG. SIZE	PART No.	Q'ty	WEIGHT
8	HEX. HEAD SCREW		013470	1	
7	HEX. NUT		013407	1	
6	SHOULDER SCREW		015502	1	
5	ROLLER STOPPER		431005	1	
4	ROLLER		431002	1	
3	STEEL COLLAR		014596	1	
2	ROLLER BRACKET		431003	1	
1	STAND		431004	1	

REMARKS:

REMARKS:

ROPING ROLLER ASS'Y

orion
PACKAGING INC.
2270 INDUSTRIEL, LAVAL
QUEBEC, CANADA, H7S 1P9
TEL.: (450) 667-9769

DATE: MAR. 15/2001		SCALE: 1 : 4
DRAWN BY: GREGORY STACHURA		MACHINE TYPE: FA44
CHECKED BY:		DRAWING SIZE: B
ASSEMBLY DWG.: -	JOB No.:	DRAWING No.: 431001M

APPENDIX

Multistretch Interface Board Calibration Instructions For MIB-336 Interface Board.

Adjustments:

Gain; The Pot controls the system Gain.

This control injects an offset voltage, which adds or subtracts from the voltage reference defined by the External Tension Adjustment (Film Tension Potentiometer); this will allow extremes of adjustment to be set to levels consistent with proper operation. Typically, the Gain will be used to center the operating range in linear portion of its characteristics.

Note: This adjustment is normally made at the factory and should not require fields adjustment.

Zero: The Pot controls the system loop gain.

This system loop gain may be adjusted if the motor continues to be energized when the dancer arm is unloaded and at rest. With the machine stopped, the potentiometer should be adjusted to ensure that the motor is de-energized in this condition, and so that a light pull on the free end of the film causes the film to feed freely. Counter clockwise (CCW) adjustment of this potentiometer will increase the response time i.e. (soften the motor tension response). Clockwise (CW) adjustment decreases the response time i.e. (sharpen the motor response) plus increases the maximum possible motor speed attainable.

Trip:

The output relay located on MIB-336 Board (Outputs: Com (14); NO(13); NC(15)) energized when the voltage between (11) & (12) overshoots the level selected on the potentiometer marked “Trip”. It de-energizes when the voltage falls below the normal current by approximately 5% or when power to board breaks.