orion

PACKAGING SYSTEMS, INC.

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

OPERATION MANUAL

For All Inquiries
Please Contact
Our Local Distributor

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

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

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

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

Notice:

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

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

1) Model
2) Serial Number
3) Subassembly (see PART LIST)

SAFETY

ORION'S stretch wrappers should be operated with caution and common sense as any other industrial equipment. To prevent a potential injury and/or electrical shocks, careful operation of the machine and awareness of its many automatic functions is required.

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

ORION MODEL H-88

Foot Pedal Controlled High Profile Turntable Only

Maximum Load Size	52"W x 52"L
Weight Capacity	3,000 lbs. Dynamic, 6,000 lbs. Static
Utilities	115/1/60 15 Amp Service
Turntable	48"x48" Formed & Welded Octagonal Turntable w/ Skirt Structural Steel Plate 3 Point Floating Caster Support Design
Turntable Drive	12 RPM Fixed Turntable Speed Heavy Duty Friction Drive
Control Features	On/Off Foot Operated Switch
Film Delivery	N/A
Structural Features	Forklift Portable Base Design All Structural Steel Construction
Estimated Shipping Weight	350 lbs.

UNLOADING

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

1. Carefully insert the forks into the lifting tubes to the maximum possible depth. Depending on the model, a forklift access may be either at the turntable end of the machine frame, the tower end or both. In case of the mongoose machine enter the forks under the frame or insert the forks in the tube brackets welded to the top of machine.

2. Lift the machine (or other part of system) only to the necessary height to move it with no bouncing or friction on the floor.

3. Sit the machine down assuring uniform contact with the floor, which is necessary to ensure correct and smooth operation.

INSPECTION

1. Remove all packing and supporting additions - these may include the blocks under the carriage and the restraining bar over the table.

NOTE: when removing the stretchwrap film covering the machine, care must be taken not to cut any of the electrical wires and/or polyurethane covering on the film carriage rollers.

2. Perform a visual inspection of the electrical and mechanical parts for loosened joints and/or broken connections. Any suspected shipping damage must be reported immediately to the freight carrier. Any transport damage cannot be claimed to Orion Packaging Inc.

Items that are vulnerable to damage and must be inspected:

- motors and transmissions (transmissions may require purge plugs which could have been be unplugged for the transport purpose).
- junction boxes
- electrical conduits
- proximity and limit switches
- photocells

3. Check the turntable assembly to ensure that there is no crippling of the movable parts i.e. casters, center axle or drive assembly.

4. Verify the following:

- turntable or rotary arm drive system to confirm that the reducer to drive the chain is snug and properly aligned
- verify the wires tight conduits for crushed sections or loose fittings
- verify the film carriage to be sure that it is correctly aligned with the tower
- verify the tension on the lift chain
- verify all the dials and knobs on the control panel for smooth action

MACHINE MAINTENANCE

All general information about machine maintenance is based on normal machine working conditions: indoors, moderate dust and low moisture environment, and maximum rotation of 32 RPM of turntable/rotary arm.

They should be regarded as guidelines, reviewed and corrected according to requirements of actual use and conditions.

MOTOR MAINTENANCE

An occasional inspection of the brushes should be made in order to establish a wear rate. Replacement brushes should be installed before old brushes wear to 9/16" long, measured on the long side. After replacing brushes run the motor near rated speed for at least 1/2 hour with no load to seat the new brushes.

Failure to properly seat the new brushes may cause commutator damage and rapid wear of the new brushes. If the commutator becomes rough, scored or out of shape, a competent motor shop should disassemble it and resurface the commutator.

With every third brush change, have a competent motor shop resurface the commutator and blow the carbon dust out of the motor.

REDUCER OIL CHANGE

All external cap screws and plugs on the reducing transmission should be checked for tightness after the first week. It is recommended to change the oil every six months or at least 1800 hours of operation, whichever comes first. When adding or changing oil, the transmission should never be filled above the oil level mark indicated, because leakage and overheating may occur.

Below is the list of the type of lubricant that should be used.

List of recommended reducer oils

Manufacturer	Lubricant
American Oil Co..	American Cyl Oil no:196-L
Cities Service Oil Co.	Citgo Cyl Oil 100-5
Gulf Oil Corp.	Gulf Senate 155
Mobil Oil Corp.	Mobil 600 W Suerr Cyl. Oil
Philips Oil Corp.	Andes S 180
Texaco Inc.	624 + 650T Cyl.Oil
Shell Oil Co.	Velvata Oil J82
Union Oil of Cal.	Red Line Worm Gear Lube 140

RING BEARING MAINTENANCE (when applicable)

The ring bearing (located under the turntable) should be re-lubricated internally and externally.

Internally: by injecting grease into all the lubrication nipples in succession until a collar of fresh grease appears around the perimeter of the ring. The re-lubrication interval suggested for these bearings, used in Stretch Wrapping Machinery is 750 hours, with a maximum period of 6 months. The lubricant should be fresh and applied in sufficient quantities to make sure all surfaces are lubricated.

Externally: by lubricating and wiping the chain drive with oily cloth.
The frequency of lubrication depends on entirely upon the usage of the machine and environment in which the machine is placed (dust, moisture etc.).
Machines working under extremely dirty conditions should be lubricated every 400 operating hours but at minimum, every 2 months. Longer lubrication intervals may occur only when machine is working under very clean and dry conditions but should be not be longer than 6 months.

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.

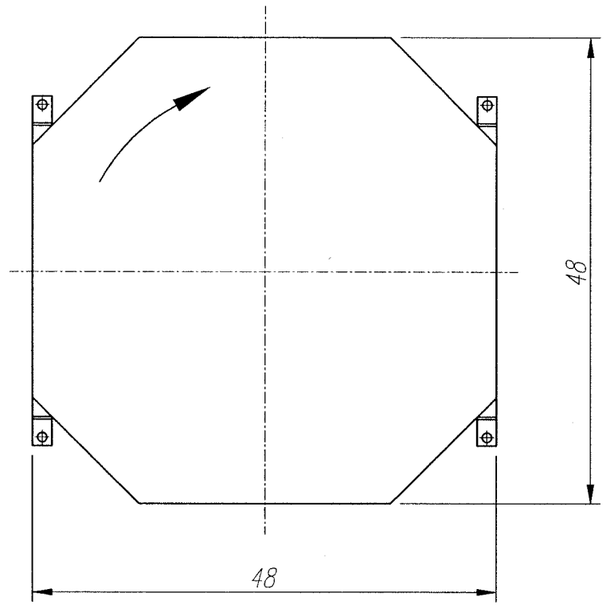
List of recommended lubricants for the ring bearing lubrication

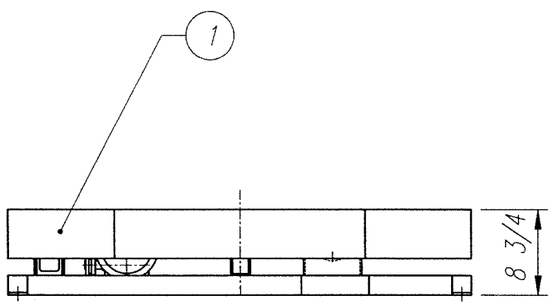
Manufacturer	Lubricant
BP	Energrease LS2
Castrol	Speeroll AP2
Esso	Beacon 2
Gulf	Crown Grease 2
Mobil	Mobilus 2
Shell	Avania Grease R2
Texaco	Glissando FT 2
Valvoline	LB - 2

SEMI-AUTOMATIC STANDARD ASSEMBLY PART LIST

NOTE:

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





REPLACES 423833 B

No.	DESCRIPTION	DWG. SIZE	PART No.	Q'ty	WEIGHT
1	H88/13 BASE ASS'Y	C	427906	1	–

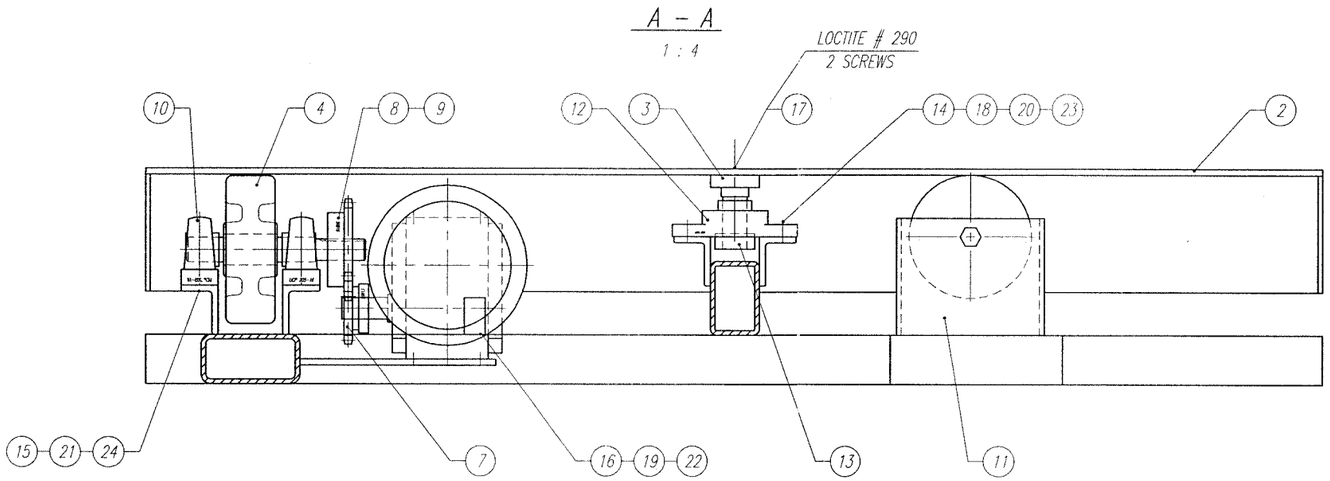
REMARKS: –

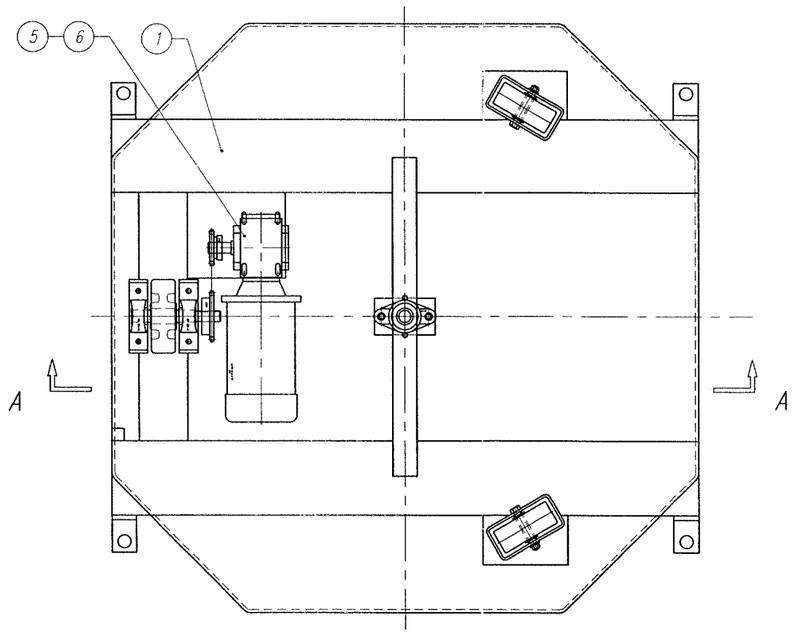
REMARKS: –

H-88/14 WRAPPER

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

DATE: MAY-05-2000		SCALE: 1 : 16
DRAWN BY: S. KUBICKA		MACHINE TYPE: H88/14
CHECKED BY:		DRAWING SIZE: B
ASSEMBLY DWG.: LAYOUT	JOB No.: STD	DRAWING No.: M-427907





No.	DESCRIPTION	DWG SIZE	PART No.	Q'ty	WEIGHT
24	HEX. NUT		011128	4	
23	HEX. NUT		011266	2	
22	SPRING WASHER		012724	4	
21	SPRING WASHER		011390	.4	
20	SPRING WASHER		012583	2	
19	FLAT WASHER		012672	4	
18	FLAT WASHER		012584	2	
17	FLAT SOCKET SCREW		010278	2	
16	HEX. HEAD SCREW		012723	4	
15	HEX. HEAD SCREW		010293	4	
14	HEX. HEAD SCREW		010287	2	
13	COLLAR		010052	1	
12	2-BOLT FLANGED BEARING		010244	1	
11	SINGLE CASTER ASS'Y	B	425390	2	
10	PILLOW BLOCK		012101	2	
9	CHAIN		010009	1	
8	SPROCKET		010235	1	
7	SPROCKET		010094	1	
6	EL. MOTOR		013606	1	
5	REDUCER		015699	1	
4	DRIVE SHAFT WITH PHENOLIC WHEEL	B	402542	1	
3	TURNTABLE SHAFT	A	404267	1	
2	TURNTABLE – 48" OCTAGONAL	A	427944	1	
1	H-88/13 BASE WELDING	C	423835	1	

REMARKS: 12 RPM, REDUCER ASS'Y-2

REMARKS:

H88/14 BASE ASSEMBLY

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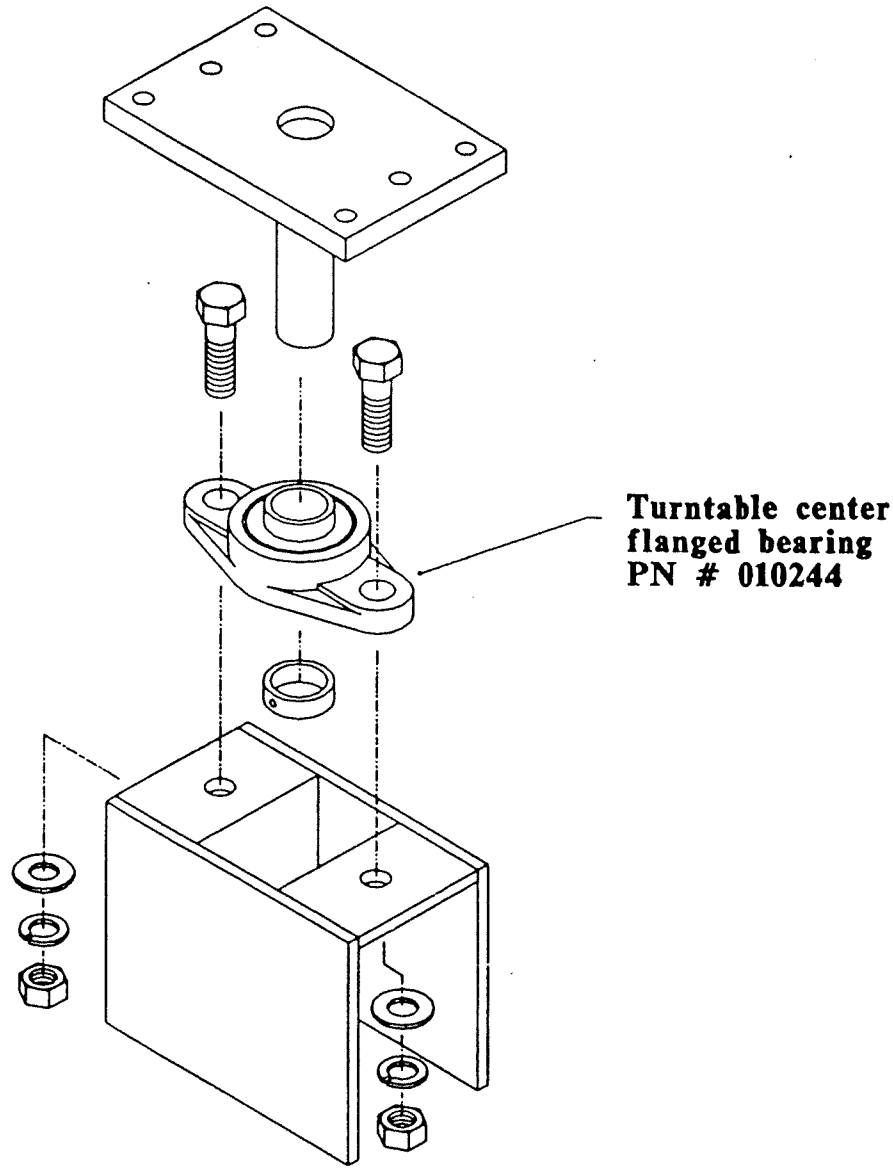
TEL.: (514) 667-9769

ASSEMBLY DWG: 427907 B	JOB No.: STD	DRAWN BY: S. KUBICKA	DATE: MAY-11-2000
CHECKED BY:		DRAWING SIZE: C	SCALE: 1 : 8
DRAWING No.: M-427906		MACHINE TYPE: H88/14	



WARNING !

When replacing turntable center flanged bearing (# 010244), please make sure that both bolts are placed head-up as shown on the drawing above.

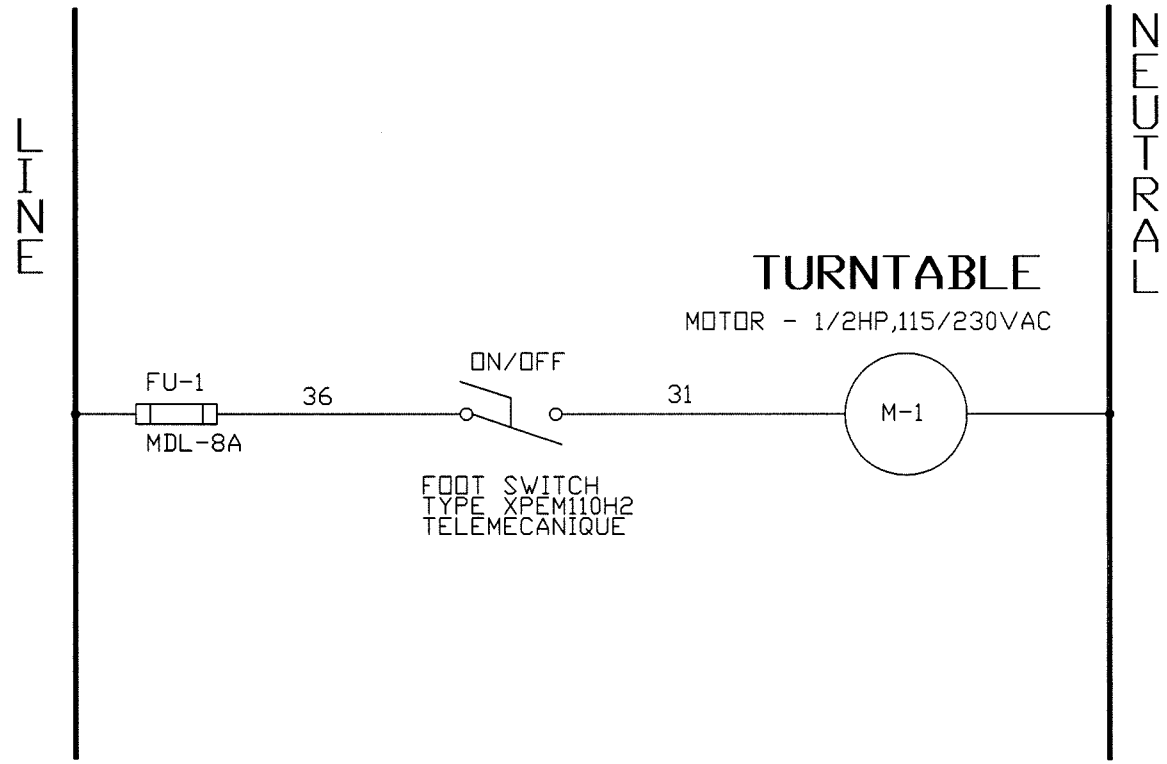
Incorrect installation may affect clear rotation and cause damage to the machine.

FOR HIGH PROFILE H-66, H-77 & H-88
BASE ASSEMBLY

APPENDIX

REQUIREMENTS:

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



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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:

SCALE: NTS

TITLE: H88-17AC

SIZE:	DOCUMENT NO:	REV:
A	JOB # STANDARD 302 450	2

DATE: FEB-20-2002 SHEET: 1 OF 1

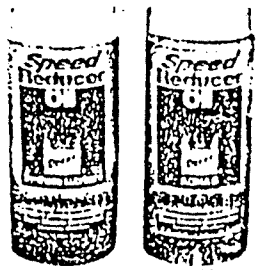
FILENAME:: H88-17AC.DWG BASE:

Lubrication

REDUCERS MAY BE FILLED TO THE PROPER LEVEL AT THE FACTORY WITH AGMA No. 8 compounded oil. AFTER INSTALLATION OF THE BREATHER PLUG, UNIT IS READY FOR USE. Before installing breather plug, refer to instruction tag and determine proper position according to reducer mounting.

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

KEEP YOUR OIL CLEAN



Doerr Electric replacement oil

To order oil, request:

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

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

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

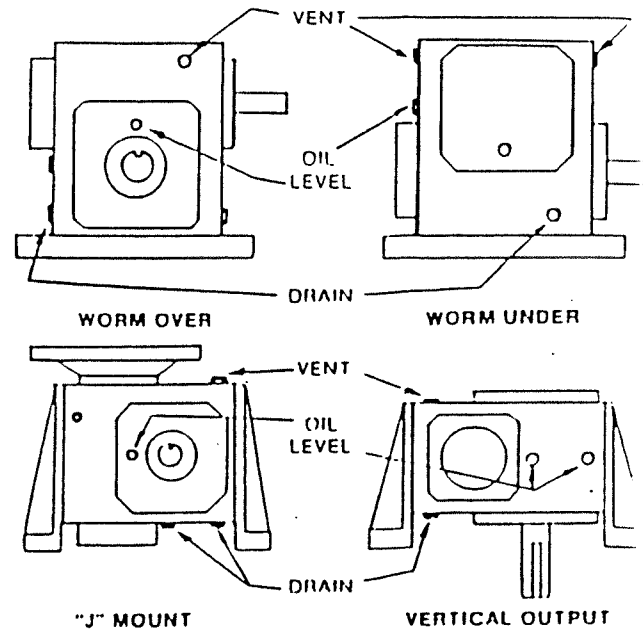
Contact DEC Service Dept. for order information.

OIL CAPACITIES*

UNIT TYPE	UNIT SERIES 133	173	206	262
Worm Over	14	20	27	49
Worm Under	17	22	28	49
Vertical Output	10	15	20	37
"J" Mount	13	18	23	38

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

OIL LEVELS*



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