



Revision Date - March 26, 2021  
RTA, RTD, HPA, HPD, LPA, LPD  
Revision 3.2

# FLEX STRETCHWRAPPER MANUAL

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# 1. Introduction and Safety

## Introduction

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.

**Note:** This manual covers standard features of the machine. Certain options may not be fully covered due to their unique application. Every effort has been made to ensure document accuracy however, Orion Packaging retains the right to change specifications without notice.

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 Flex Stretchwrapper with S Carriage
2. Serial Number (See sticker on electrical cabinet)
3. Built in Alexandria Minnesota, USA

## About this Manual

Orion is committed to helping you maximize the productivity of your system. This manual is specifically designed for your packaging system, to assist you in the operation and maintenance of your new equipment. Please take the time to familiarize yourself with the contents of this manual.

- Section 1 is the Introduction and Safety section. This section discusses safety, lock out/ tag out, hazard messages, and installation information.
- Section 2 is the System Description section. This section discusses machine specifications. A Machine Layout Drawing is found at the end of this section.
- Section 3 is the System Operation section. This section describes the operator control panels, the Human Machine Interface, and operational procedures.
- Section 4 is the Troubleshooting section. A Troubleshooting chart is found in this section.
- Section 5 is the Maintenance section. In this section you will also find a suggested maintenance schedule including a maintenance log. Assembly drawings conclude this section.

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# Flex Series Warranty

- Flex Low-Profile and High-Profile turntable style of machines include the LPD, LPA, HPD and HPA
- Flex Rotary tower style of machines include the RTD and RTA.

## **WARRANTY**

5-years on all Structural Components without limitation on cycles.

## **EFFECTIVE JANUARY 1, 2020**

The Flex series by Orion is covered by a 5-year warranty from the delivery date of its products to be free from defects in materials and workmanship as described below. This warranty assumes that normal maintenance as outlined in your machine operation manual, will be performed by the user.

## **STRUCTURAL COMPONENTS**

All Structural Components on the Flex series by Orion are warranted to be free from defects in material and workmanship for a period of 5-years. During the warranty period Orion will, at its option, either repair or replace any failed component. Structural components are defined as the Base weldment, Tower weldment and Carriage backplate. Components bolted to these items fall under the Mechanical and Electrical components listed below.

## **MECHANICAL & ELECTRICAL COMPONENTS**

All Mechanical and Electrical Components on the Flex series by Orion are warranted to be free from defects in material and workmanship for a period of 1-year or Manufacturer's Warranty whichever is greater. During the warranty period Orion will, at its option, either repair or replace any failed component. This warranty does not include any labor, travel, or equipment downtime cost for part replacement.

## **POLYURETHANE PRE-STRETCH ROLLERS**

The polyurethane pre-stretch rollers on the Flex series by Orion models carry a Limited Lifetime warranty and are guaranteed to be free from defects in material and workmanship. Rollers are not warranted against physical damage, corrosion, abuse, or negligence.

Wear parts including, but not limited to belts, fuses, light bulbs, circuit breakers, brakes, motor brushes, slip ring, brushes, casters, chains, sprockets, etc. are excluded from this warranty.

## **DAMAGE IN TRANSPORT**

Damage in transport is the responsibility of the carrier and is not covered under our warranty.

## **FREIGHT CHARGES**

There will be no freight charges for warranty parts that are ordered for shipment via FedEx regular ground service from Orion. Any other method of shipment, (FedEx next day /second day, etc., UPS, common carrier, etc.) will be at the expense of the customer/distributor.

## **PARTS RETURN POLICY**

Most components valued at under \$300 list price, Orion does not require that the defective component be returned. All defective components valued at \$300 or more list price must be returned to Orion in Alexandria, MN. It is at Orion's sole discretion as to whether any given component must be returned, regardless of its value, for the purpose of determination of warranty status and the nature of the defect. Furthermore, confirmation that the part does not need to be returned must be provided by Orion at the time of order placement. Please contact Orion Parts to learn more about the RMA (Returned Materials Authorization) procedure.

## **IMPORTANT EXCLUSIONS**

Except as stated herein, Orion makes no other warranty, expressed or implied and in no event shall be liable for incidental or consequential damages. Orion makes no warranty as to fitness of equipment for particular purpose. Orion neither assumes nor authorizes anyone else to assume for it, any other obligation or liability relating to its equipment. This warranty does not apply to damage to equipment which, in the judgment of Orion, has been subject to incorrect voltage supply, normal wear and tear, to misuse, neglect, or has been repaired or altered by unauthorized personnel. Defective parts must be returned to Orion, freight prepaid, within 30 days of shipment of the replacement part, except for components valued at under \$300 list price under the conditions stated above. Defective parts must be returned in their original state along with the RMA documentation. Defective parts that have been disassembled, damaged during removal, or otherwise tampered with, will not be covered under warranty, unless otherwise stated in writing. Orion's sole obligation under this warranty will be to provide repairs to components or replacement parts, F.O.B. Orion's point of shipment except as stated above. All aspects of the above stated warranty and procedures related to ordering parts under warranty will be upheld with no exceptions.

Orion recommends that the purchase of an Orion Essential Spare Parts Kit be considered to maximize system uptime. See your Orion parts representative for details.

This document supersedes all **Flex** warranty documents created prior to January 1, 2020.

# 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 be disconnected prior to all inspection, maintenance or repair work.

At Orion, we are committed to building quality packaging and material handling equipment. To achieve this, our machines must be efficient, easy to maintain, and safe to operate.

Before attempting to operate the equipment, become familiar with the safety recommendations and operational components of your Flex Stretchwrapper with S Carriage. You should also become familiar with the technical information pertaining to components used within the system, including their operating and safety features. This information is located in the Vendor Data Manual and in other literature supplied with the equipment. To maximize machine safety and efficiency you must operate the machine correctly and comply with the safety features described.

**Stay alert and remember:** Safety is the responsibility of everyone who operates or services your BEC system.

## System Safety Recommendations

Safeguarding personnel that operate and/or maintain automated equipment is the primary consideration. Because it is very dangerous to enter the operating space (work envelope) of a machine during operation, adequate safeguards must be in place and safety precautions must be observed.

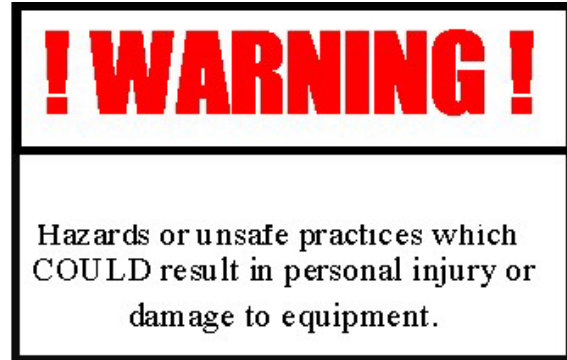
The following general precautions are recommended for all personnel who perform system operation or maintenance.

- Do lockout-tagout procedures whenever you do maintenance and repair work.
- All personnel who repair, maintain, or operate the equipment need to know the location of all EMERGENCY STOP buttons.
- Do not operate the equipment with any of the safety guards removed.
- Do not wear neckties, loose clothing, or long loose-hanging hair around any equipment.
- Observe and follow the DANGER, WARNING, and CAUTION messages throughout this manual, in vendor manuals, and displayed on the equipment.
- DO NOT use steps or stands that allow anyone to reach over guards.
- Personnel should attend all available safety and operational training courses.
- Personnel should know and follow the recommended safety procedures whenever they must enter the packaging systems motion area.
- Personnel should not enter the packaging system while control power is "ON".
- Personnel should not power up the system if someone is in the working path of the machine
- The system should be powered down when not in use.
- Personnel should pay special attention to all the posted warnings and cautions located on any devices. Observe all safety and/or precautionary steps and procedures when working with the system.
- Personnel should keep the system clean to make it easier to spot hazards.



## Hazard Messages

Notations appear on pages of this manual to alert the reader to important messages regarding a significant hazard for personnel or equipment. These messages convey three levels of risk as defined below. Failure to observe these instructions can result in death, serious injury, damaged equipment, or loss of product or production.



- |                |  |
|----------------|--|
| <b>DANGER</b>  | Denotes the possibility of serious injury or death to personnel.               |
| <b>WARNING</b> | Denotes the possibility of potential injury or damage to equipment.            |
| <b>CAUTION</b> | Denotes the possibility of damage to product or an interruption of production. |

## Operation Safety

The following safety precautions are recommended for all personnel who will operate this Flex Stretchwrapper with S Carriage.

- Operators should immediately report unsafe working conditions to a supervisor.
- The operator should understand the function of the entire system including all external devices and equipment that interact with the system.
- Before starting operation, the operator should understand the complete task that the system is designed to accomplish.
- The operator should know the location and functional status of all devices (switches, sensors, control signals) that can cause the system to move.
- The operator should know where each EMERGENCY STOP button is located for both main and external control devices. Do not hesitate to use them in an emergency.
- The operator should make sure all safety devices are functioning and periodically checked for proper operation.
- The operator should ensure that all personnel are outside the system before starting operation.
- The operator should never enter, or allow others to enter the system during automatic operation.

## Maintenance Safety

The following safety precautions are recommended for all personnel who are responsible for the maintenance or service this Flex Stretchwrapper with S Carriage.

- Personnel should ensure that all safety devices are functioning and periodically checked for proper operation before performing maintenance.
- Before performing any maintenance, service, or inspection inside the main control panel, the power source should be turned off and locked out.
- Maintenance should be performed on the system with the power OFF. Lockout and tag out procedures should be followed to protect personnel from injury and to indicate the equipment is being serviced.
- Place a lock on the main electrical disconnect, as shown below, while performing maintenance.
- Personnel should pay careful attention to all devices that may be powered or capable of motion, such as conveyors and pneumatic devices.
- Release or block all stored energy devices (hydraulic or pneumatic) that may present a danger when working with the system. Before working with pneumatic devices, shut off the air supply and purge the air lines.
- Be aware when removing a servomotor or brake that the associated mechanical part will fall unless supported in some manner.
- Use only specified replacement parts. Never use non-specific fuses that have not been specified. Potential fire and/or damage may result.
- Before restarting the system, ensure personnel are not in the system and that the system and external devices are operating properly.

# Lockout and Tagout Recommendations

## Electrical System

(See OSHA 1910.147 & OSHA 1910.333 (b)(2) for exception to procedures)

To avoid hazards of electrical shock or other personal injuries, the main power disconnect for the system and any other separate sources of power for the system shall be locked out & tagged as a safety precaution during entry and maintenance to the system.

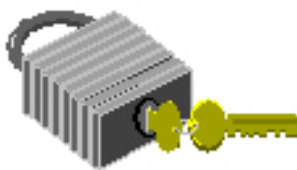
To accomplish this, set the Main Power Disconnect operating handle to the "OFF" position and install a personal locking device through the padlock hole on the operating handle. Attach a Danger tag to the handle containing a statement prohibiting unauthorized operation of the disconnect and removal of the tag signed by the individual responsible for locking out the system. If several personnel are performing maintenance, each individual shall install a lockout device and tag.

A qualified person shall verify that the equipment is de-energized by:

1. Operating controls to verify equipment cannot be restarted.
2. Using test equipment to test circuits and electrical parts that will be exposed to personnel.

Stored electric energy that might endanger personnel shall be released by discharging the circuits. Check appropriate equipment manuals on exact procedures.

To re-energize equipment, a qualified person shall conduct tests and visual inspections, as necessary, to verify that all tools, electrical jumpers, shorts, grounds, and other such devices have been removed, so that equipment can be safely energized. Personnel exposed to the hazards associated with re-energizing equipment shall be warned to stay clear of equipment. Each lock and tag shall be removed by the person who applied it or under their direct supervision. A visual determination that all personnel are clear of the equipment shall be accomplished before the operating handle on each Main Power Disconnect is placed to the "ON" position.



### **Danger!**

**When performing maintenance, inspection, repair or changeover, execute the Lockout & Tag Out procedure to prevent personal injury – before entering the machine. When you see this symbol, DQ LOCK OUT/TAG OUT.**

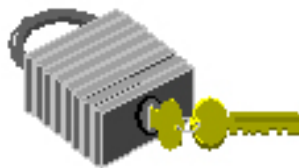
## Pneumatic and Vacuum Systems

To avoid hazards of moving mechanisms, pinch points and other personal injuries, the main compressed air supply valve for the system shall be locked out & tagged as a safety precaution during entry and maintenance to the system.

1. To accomplish this, turn the Main Air Supply valve to the "OFF" position and install a personal locking device through the padlock hole on the valve handle.
2. Also attach a Danger tag to the handle containing a statement prohibiting unauthorized operation of the disconnect and removal of the tag signed by the individual responsible for locking out the system.

If several personnel are performing maintenance, each individual shall install a lockout device and tag. Qualified personnel shall vent any stored or accumulated air in pneumatic/vacuum devices before working on them. Check appropriate equipment manuals on exact procedures.

To re-supply compressed air to the equipment, a qualified person shall conduct visual inspections, as necessary, to verify that mechanisms are properly connected, as well as all tools and other objects have been removed so that equipment can safely operate. Personnel exposed to pneumatic/vacuum hazard areas shall be warned to stay clear of equipment. Each lock and tag shall be removed by the person who applied it, or, under their direct supervision. A visual determination that all personnel are clear of the equipment shall be accomplished before the main air supply valve is turned to the "ON" position.



### **Danger!**

**When performing maintenance, inspection, repair or changeover, execute the Lockout & Tag Out procedure to prevent personal injury – before entering the machine. When you see this symbol, DO LOCK OUT/TAG OUT.**

# Installation and First Time Power Up

## 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 tower end of the machine frame, the tower end or both. Look for the forklift tube access stickers shown below.

**Figure 1 - 1**  
**Fork Tube Access**  
**Sticker**



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 packing materials 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 are as follows:

- Motors and transmissions
  - Junction boxes
  - Electrical conduits
  - Proximity and limit switches
  - Photocells
3. Check around the tower to ensure that there is no crippling of the movable parts i.e. casters, center axle or drive assembly.
  4. Verify the following:
    - Check wires and 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 belt.
    - 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 (Optional) shall 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.
- Make sure the machine is on a level surface.
- Orion Packaging insist on a dedicated circuit be used for this wrapper. Extension cords are not allowed and can void your warranty.

## Assembly Procedure

**Note:** The structural frames of the machine have to be installed on a leveled floor. The base deviation from vertical must not exceed 1/4" on the distance of 10 feet (angle: 0 degrees 6').

Move the wrapper into its final position. If the wrapper is to be secured to the floor, we recommend that the wrapper base section be bolted to the floor by the 1/2" concrete floor anchors (leg & shield or expandable type-Red Heads).



# How to Erect an RTA or RTD Flex Orion

**WARNING** Observe safety precautions in the user manual. Always follow OSHA and plant regulations when placing machinery.

1. Attach a strap around the center crossmember. Secure to properly rated lifting device.

**Figure 1 - 2**  
**Attaching Strap**



2. Raise the tower while moving forward. Use a spotter to ensure the raising and lifting balance is correct.

**Figure 1 - 3**  
**Raising Tower**



3. Your spotter can position the machine precisely while the lift is holding the tower vertically.

**Figure 1 - 4**  
**Positioning Wrapper**



4. Remove the shipping feet while the machine is still held by the lift.

**Figure 1 - 5**  
**Remove Shipping Feet**



5. Using a hammer drill, drill the mounting holes in the floor with the correct drill bit to match the mounting hardware.

**Figure 1 - 6**  
**Drill Mounting Holes**



6. Pound in the 10 Red Head Anchors. Use 5/8" hardware. The length of the anchors depends on the thickness of the concrete.

**Figure 1 - 7**  
**Installing Anchors**



7. Once the machine is properly bolted down, loosen the tension to the crossmember.

**Figure 1 - 8**  
**Loosen Tension Once**  
**Bolted Down**



8. Climb the ladder and remove the strap.

**Figure 1 - 9**  
**Remove Attachment**





9. Bolt the safety hoop to the bottom of the rotary arm.

**Figure 1 - 10**  
**Attach Safety Hoop**



10. Verify the machine is properly secured and test the machine operation.



---

**System Description Contents**

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## 2. System Description

### Machine Specifications

#### Utilities

- 115 / 1ph / 60hz 20 Amp Service

#### Standard Speed

- 16 Rpm Variable Tower Speed Vfd Controlled Motor\*\*

#### Drive

- Heavy Duty Chain Drive
- Electronically Adjustable Acceleration/ Deceleration And Running Speeds (At VFD)
- Positive Alignment Feature (True Home Position)

#### Control Features

- Nema 12 Control Panel
- User Friendly Interface with Graphical Maintenance Reminders
- IP Address is Modifiable for Networking
- Easy to Use Icon Based Interface
- Web-based Production Data Dashboard
- Optional Wireless Connection to the PLC/ HMI
- Downloadable VFD Parameters
- Variable Speed Film Carriage Up/ Down Control
- Film Carriage Manual Jog Functionality
- Photocell For Automatic Load Height Detection
- Main Drive Jogging
- Variable Speed Main Drive
- Semi-automatic Reinforce Wrap Feature
- On-Screen Interactive Troubleshooting Guide

#### Film Delivery

- Instathread Full Corner Compensating Powered Film Drive.
- 260 % Stretch From The Factory. 20" Film Tension Delivery System. \*\*optional 30"
- Full Authority, Corner Compensating, Vfd Powered Prestretch
- Electronic Film Tension Control Adjustment On The Panel < Or = 90 Ga Film Capacity. Higher Gauge Film Requires A Heavy Film Upgrade.
- Film Carriage Elevator Drive
- High Strength Belt Lift Optional Chain Lift

- Variable Frequency Drive Motor
- Multi-point Uhmw Precision Carriage Guidance System

### **Structural Features**

- Structural Steel Construction Throughout
- Easy Access To All Components
- Limited Proprietary Parts For Ease Of Maintenance

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## 3. System Operation

### Operating Procedures

#### How to Start and Shut Down Your Wrapping System

**Note:** Do not use extension cords. Plug your Flex Stretch-wrapper directly into an outlet.

##### POWER SWITCH

Located on the panel door, the lockable power switch has two settings:

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

##### START AND EMERGENCY STOP SWITCHES

- Press the **START** button to gain Control Power prior to starting.
- The **START** switch is used to start the cycle once the load is available.
- The cycle may be stopped at anytime by pressing the **E-STOP** button.

The FLEX series machines are engineered to give the operator different levels of operation, the front panel or USER settings, and MENU DRIVEN parameters. The menu driven parameters offer even more flexibility and security.

## Carriage Obstacle Detect Error Recovery

**Note:** This procedure only applies to turntable models HPA, HPD, LPA, & LPD.

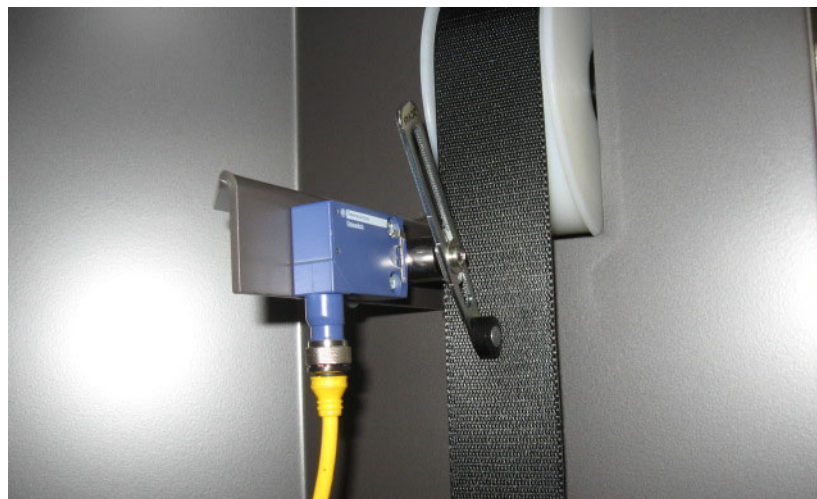
1. When the obstacle detect error occurs, the brake must be released.
2. To release the brake, pull outward on the carriage strap on the front side of the tower until the brake releases.

**Figure 3 - 1**  
**Pulling Strap to**  
**Release Brake**



3. Align the limit switch on the inside of the tower with the center of the strap.

**Figure 3 - 2**  
**Limit Switch**  
**Alignment**



4. Reset and restart, when ready.

## 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 tacky surface of the film is inward on the load.

1. Press in the E-stop.
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. Turn the two knobs to unlatch the carriage door, then pull out on the carriage door to open it. The film carriage is equipped with a magnetic switch that detects when the carriage threading door is open. When opened, it will set off an alarm on the HMI and prevent the carriage from moving.
6. Pass the roped tail of the film through the opening.
7. Push the carriage door closed. Turn the two knobs to latch the carriage door.
8. When the film feeding is completed, release the E-stop.
9. For machines without a fence, press the Start button once to reset control power. If your machine has a fence, the multistretch will reset as soon as the E-stop is released.
10. 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 film clamp if so equipped.
11. The system is now ready to begin the first wrapping cycle.
12. Press and hold the Start button for the amount of time set in the machine settings to start the machine.

**Figure 3 - 3**  
**Loading the Film**



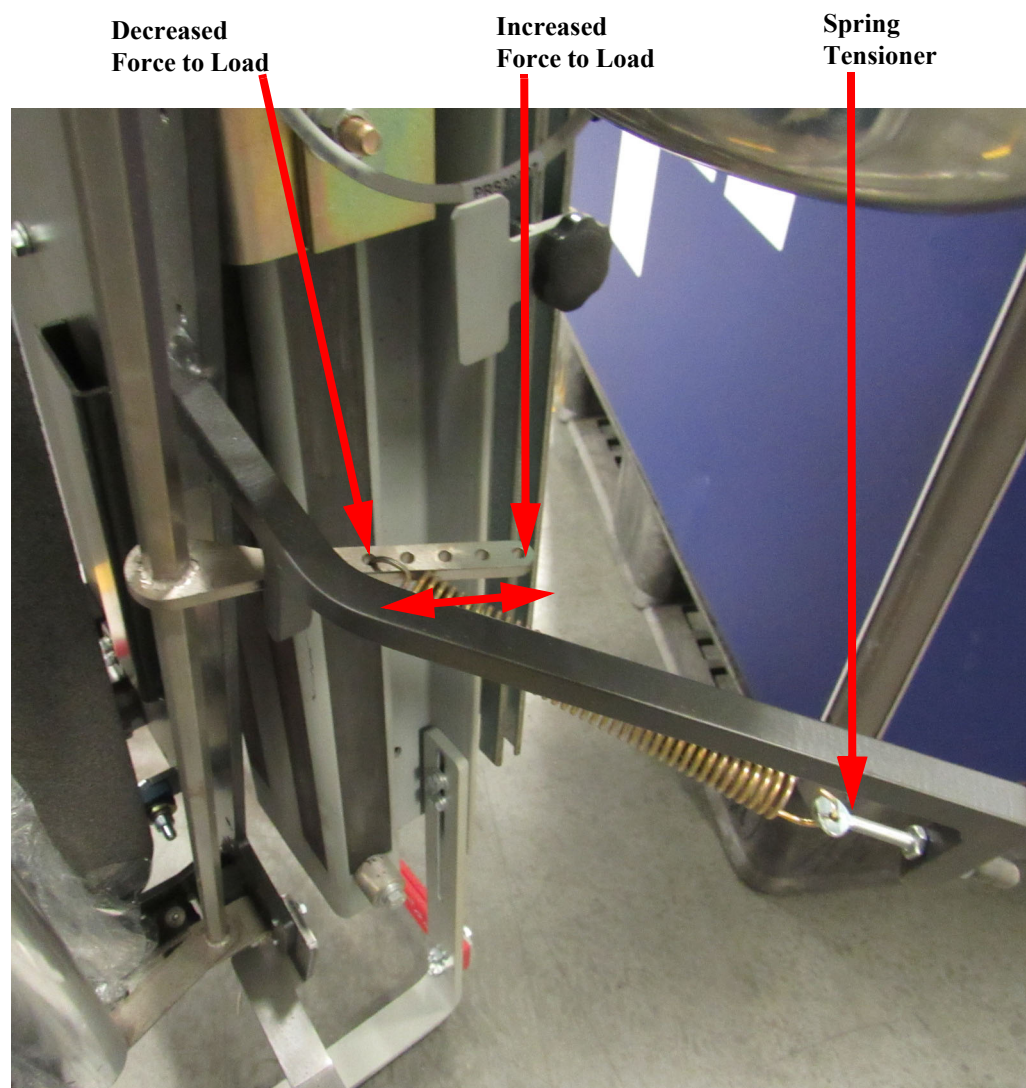


## Dancer Bar Tension Adjustment

The S-Carriage has a tension adjustment that allows the user to change the tension on the dancer bar. The standard tension is at the furthest inward position, as shown below.

- Adjust the spring to another position to increase the force to the load. Take into account that the film tension setting may need to be adjusted on the HMI if changes are made to the dancer bar tension adjustment.
- For additional adjust-ability use the spring tensioner, shown below. The further the spring is pulled, more tension is added to the dancer bar.
- The light and heavy gauge springs are provided with your machine. Use the light spring to for less tension and the heavy spring for more tension.

**Figure 3 - 4**  
**Dancer Bar Tension**  
**Adjustment**












# Universal Go-To Buttons

The buttons in the chart below are found throughout most HMI screens. The buttons allow the user to easily navigate back to any of the screens.

**Table 3-1. The Universal Go-To Button Descriptions**

STATE 1	DESCRIPTION
	The Info icon displays information about each button on the HMI screen that you are currently viewing.
 Run	Press this button to go to the Run Screen. The icon will illuminate in green when the screen is currently active.
 Wrap Settings	Press this button to go to the Wrap Settings Screen. The icon will illuminate in green when the screen is currently active.
 Menu	Press this button to go to the Menu Screen. The icon will illuminate in green when the screen is currently active.
 Machine Settings	Press this button to go to the Machine Settings Screen. The icon will illuminate in green when the screen is currently active.
 Diagnostics	Press this button to go to the Diagnostics Screen. The icon will illuminate in green when the screen is currently active.
 Login	Press this button to go to the Security Settings Screen.

# Log In Permissions

## No Login

1. Machine Operation via the 'Run' screen
  - A. Start Machine
  - B. Stop Machine
  - C. Fault Reset
  - D. Reinforcement Wrap activation
  - E. High/Low rotational speed selection
  - F. Home Machine
2. Menu Screen
  - A. Manual jogging
  - B. Wrap Recipe Selection
  - C. Production Data
3. Diagnostics Screen

## User Login

- Everything above, plus:
1. Wrap Settings
    - A. Top/Bottom Wraps
    - B. Carriage Up/Down Speed
    - C. Wrap Direction
    - D. Additional wrap options

## Maintenance Login

- Everything above, plus:
1. Maintenance Settings
    - A. Main Drive settings
    - B. Reinforcement settings
    - C. Timers
    - D. Machine Setup
    - E. Multistretch Settings
    - F. VFD Parameters
    - G. Additional machine settings

## Admin Login

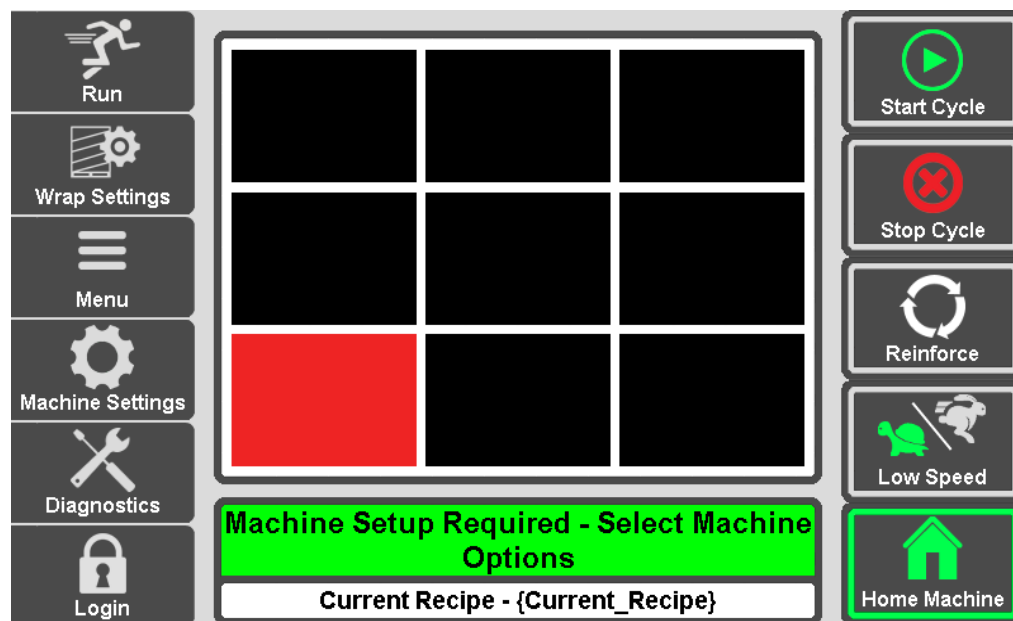
- Everything above, plus:
1. Maintenance Settings
    - A. Factory Defaults

# Run Screens




## Run Screen

This is the Run screen used for primary functions of the machine. The red block in the Orion block logo will travel the perimeter of the logo showing the position of the turntable in relation to the home proximity sensor.





**Figure 3 - 5**  
**The Run Screen**



**Table 3-2. The Run Screen Button Descriptions**

STATE 1	DESCRIPTION	STATE 2
	Press and hold this button to start the machine. This must be held until the Start Delay timer is complete to start the machine.	
	Press this button to pause the wrap cycle. When paused, the Carriage and Main Drive will stop, and will wait for the Resume Cycle button to be pressed before resuming the wrap cycle.	
	Press this button to resume the wrap cycle, if the cycle is currently paused.	

**Table 3-2. The Run Screen Button Descriptions (Continued)**

STATE 1	DESCRIPTION	STATE 2
 <b>Reset Cycle</b>	Press this button to either stop the current wrap cycle or reset any displayed faults.	
 <b>Reinforce</b>	Press this button to apply the predefined reinforcement wraps to the load. If the Reinforcement Wraps value is set to zero, reinforcement wraps will be applied as long as the Reinforce button is pressed.	<b>REINFORCING</b>
 <b>Low Speed</b>	Press this button to toggle between High Speed and Low Speed operation. When High Speed is selected, the Main Drive will travel at the predefined High Speed value during the wrap cycle. When Low Speed is selected, the Main Drive will travel at the predefined Low Speed value during the wrap cycle.	
 <b>Home Machine</b>	Press this button to send the machine to its Home Position. When pressed, the Carriage will travel to its bottom limit, and the Main Drive will travel to its predefined End of Cycle Position.	

## Maintenance Prompt

This is the Maintenance Prompt Screen. When preventative maintenance is required the prompt and picture of the maintenance is displayed. Press Acknowledge to confirm that the procedure was completed and reset the counter. Press Snooze to delay the counter for 100 cycles before the prompt re-displays.

**Figure 3 - 6**  
**The Maintenance Prompt Screen**



**Table 3-3. The Maintenance Prompt Screen Button Descriptions**

STATE 1	DESCRIPTION
ACKNOWLEDGE	Press this button to acknowledge the required maintenance prompt as completed.
SNOOZE	Press this button to snooze the required maintenance prompt. The prompt will remain in the alarm list and redisplay after 100 cycles and re-display until it is acknowledged.

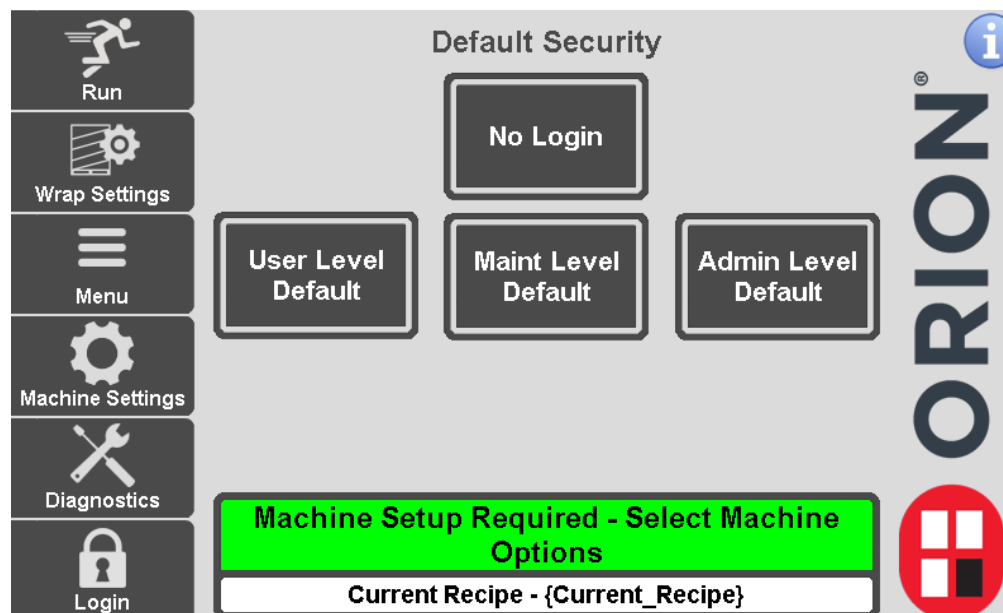
**Table 3-4. The Maintenance Prompts**

<b>PREVENTATIVE MAINTENANCE REQUIRED</b>	<b>FREQUENCY (LOADS)</b>
<b>INSPECT RUBBER MULTISTRETCH ROLLERS. CLEAN AS NEEDED.</b>	<b>5,760</b>
<b>INSPECT BELT CONDITION. ADJUST AS NEEDED.</b>	<b>5,760</b>
<b>INSPECT BENEATH TURNTABLE. CLEAN DEBRIS AS NEEDED.</b>	<b>17,280</b>
<b>INSPECT TURNTABLE SUPPORT CASTERS FOR GOOD CONDITION.</b>	<b>17,280</b>
<b>INSPECT TURNTABLE CHAIN. APPLY LUBRICATION AS NEEDED.</b>	<b>17,280</b>
<b>INSPECT ROTARY ARM CHAIN. APPLY LUBRICATION AS NEEDED.</b>	<b>17,280</b>
<b>INSPECT MULTISTRETCH CHAIN AND BELT. TENSION AND/OR LUBRICATE AS NEEDED.</b>	<b>17,280</b>
<b>CHECK HOT WIRE FOR EXCESSIVE BUILDUP. REPLACE IF KINKED OR BENT.</b>	<b>17,280</b>
<b>INSPECT PNEUMATIC HARDWARE (A MODELS). ADJUST AS NEEDED.</b>	<b>17,280</b>
<b>LUBRICATE RING BEARING.</b>	<b>34,560</b>
<b>INSPECT CARRIAGE LIFT CHAIN (S MODEL). TENSION AND/OR LUBRICATE AS NEEDED.</b>	<b>34,560</b>
<b>INSPECT COMMUTATOR ASSEMBLY. BLOW OUT DEBRIS AS NEEDED.</b>	<b>34,560</b>

## Security Settings Screen

This is the Security Settings screen. This screen allows you to choose the default security setting used after the login expires.

**Figure 3 - 7**  
**The Security Settings Screen**



**Table 3-5. The Security Settings Screen Button Descriptions**

STATE 1	DESCRIPTION
NO LOGIN	Press this button to set the Default Security level to 'No Login'. When selected, the machine will automatically log out on powerup, or after the logout timer has expired.
USER LEVEL	Press this button to set the Default Security level to 'User'. When selected, the machine will automatically log in to the User security level on powerup, or after the logout timer has expired.
MAINTENANCE LEVEL	Press this button to set the Default Security level to 'Maintenance'. When selected, the machine will automatically log in to the Maintenance security level on powerup, or after the logout timer has expired.
ADMIN LEVEL	Press this button to set the Default Security level to 'Administrator'. When selected, the machine will automatically log in to the Administrator security level on powerup, or after the logout timer has expired.

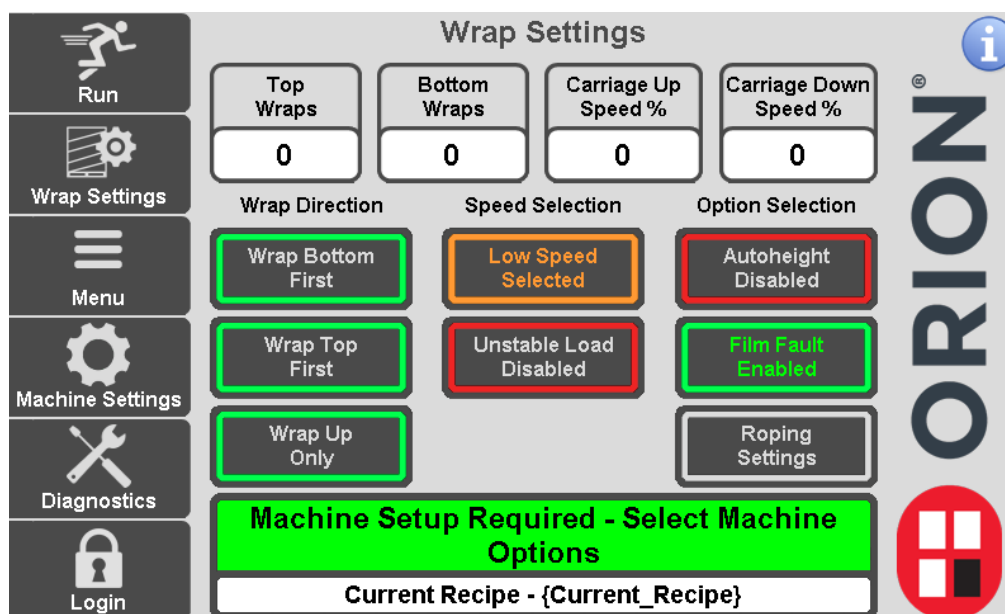
# Wrap Setting Screens

## Wrap Settings Screen

**Note:** To adjust the wrap settings, you must be logged in. Press the login button in the bottom left corner of the screen. Enter ADMIN then press the checkmark, then X to close the keypad.

This is the Wrap Settings screen. This screen allows you to set the number of top and bottom wraps and the speed percentage of the carriage up and down travel. You may also choose wrap pattern options such as, Wrap Bottom First, Wrap Top First, Low Speed/ High Speed, Unstable Load Enabled or Disabled, Autoheight Enabled or Disabled, or Film Fault Enabled or Disabled. You can view each pattern settings on the Recipe Viewing Screen, see “Recipe Viewing Screen” on page 3 - 19.

**Figure 3 - 8**  
**The Wrap Settings Screen**



**Table 3-6. The Wrap Settings Screen Button Descriptions**

STATE 1	DESCRIPTION	STATE 2
TOP WRAPS	Press this button to set the number of top wraps applied to the load. Parameters are 1-20.	
BOTTOM WRAPS	Press this button to set the number of bottom wraps applied to the load. Parameters are 1-20.	
CARRIAGE UP SPEED	Press this button to change the speed of the carriage on the upward move, in terms of percentage. Min - 5% Max - 100%	



**Table 3-6. The Wrap Settings Screen Button Descriptions (Continued)**

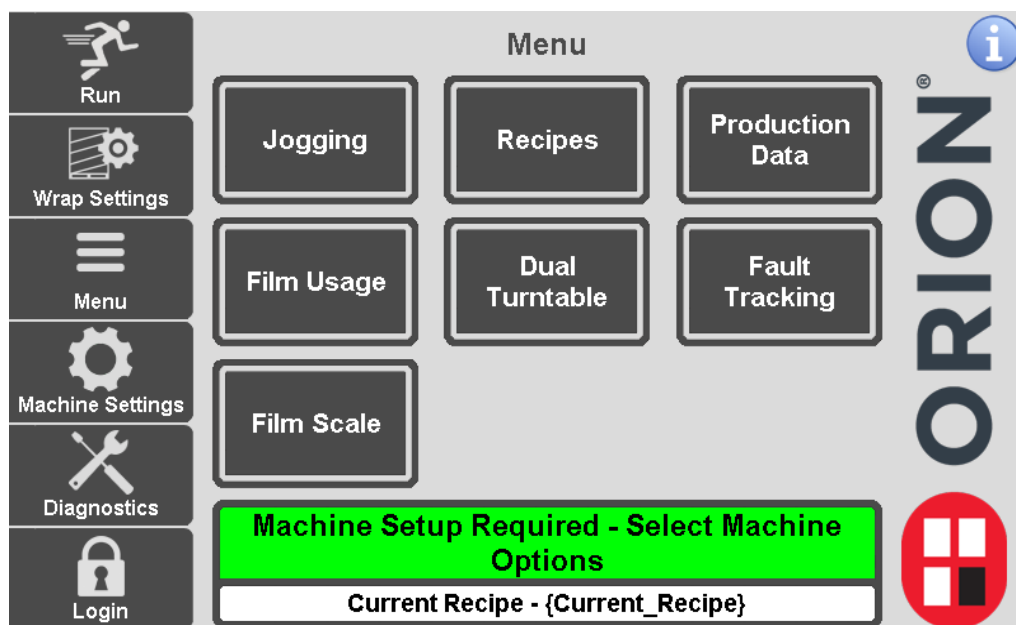
STATE 1	DESCRIPTION	STATE 2
<b>CARRIAGE DOWN SPEED</b>	Press this button to change the speed of the carriage on the downward move, in terms of percentage. Min - 5% Max - 100%	
<b>WRAP BOTTOM FIRST</b>	Press this button to select the Wrap Bottom First wrap sequence. When selected, the wrapper will apply the bottom wraps first. When complete, the Carriage will travel to the top of the load and apply the top wraps. When complete, the Carriage will travel to the bottom and complete the cycle.	
<b>WRAP TOP FIRST</b>	Press this button to select the Wrap Top First wrap sequence. When selected, the Carriage will immediately travel to the top of the load and apply the top wraps. When complete, the Carriage will travel to the bottom, apply the bottom wraps, and complete the cycle.	
<b>WRAP UP ONLY</b>	Press this button to wrap up only. The machine will wrap to the top, then stop the cycle.	
<b>LOW SPEED SELECTED</b>	Press this button to toggle between High Speed and Low Speed operation. When High Speed is selected, the Main Drive will travel at the predefined High Speed value during the wrap cycle. When Low Speed is selected, the Main Drive will travel at the predefined Low Speed value during the wrap cycle.	<b>HIGH SPEED SELECTED</b>
<b>UNSTABLE LOAD DISABLED</b>	Press this button to enable or disable the Unstable Load wrap cycle. When enabled, the Main Drive will travel at Low Speed until the wrapper has completed one top wrap. After one top wrap is completed, the Main Drive will travel at High Speed for the remainder of the cycle. If Low Speed is selected, the Main Drive will travel at Low Speed for the entire cycle.	<b>UNSTABLE LOAD ENABLED</b>
<b>AUTOHEIGHT DISABLED</b>	Press this button to enable or disable the Autoheight photoeye. When enabled, the Carriage will travel up, during the wrap cycle, until the Autoheight photoeye no longer sees a load. It will continue to travel until the Autoheight Delay time is complete. When disabled, the Carriage will travel up, during the wrap cycle, until it reaches the Top Limit sensor.	<b>AUTOHEIGHT ENABLED</b>
<b>FILM FAULT DISABLED</b>	Press this button to enable or disable the End of Roll or Broken Film fault. When disabled, the wrap cycle will continue even if the film has broken or there is no film left on the roll.	<b>FILM FAULT ENABLED</b>
<b>ROPING SETTINGS</b>	Press this button to go to the Roping Settings Screen.	

# Menu Screens

## Menu Screen

This is the Menu screen. This screen allows you to navigate the HMI screens.

**Figure 3 - 9**  
**The Menu Screen**



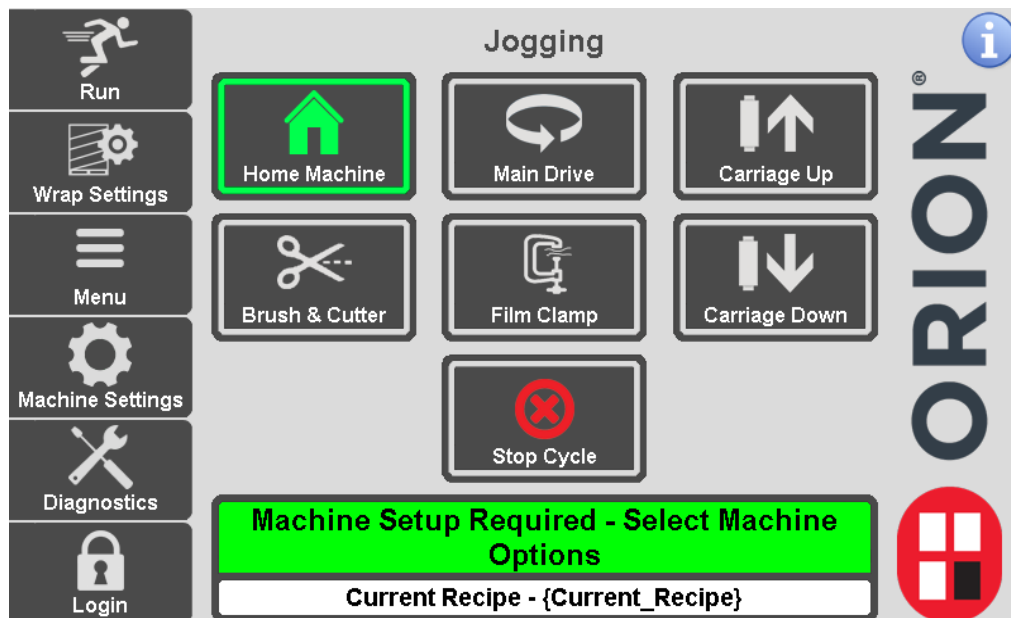
**Table 3-7. The Menu Screen Button Descriptions**

STATE 1	DESCRIPTION
JOGGING	Press this button to go to the Jogging Screen. See “Jogging Screen” on page 3 - 15.
RECIPES	Press this button to go to the Recipes Screen. See “Recipe Screen” on page 3 - 17.
PRODUCTION DATA	Press this button to go to the Production Data Screen. See “Production Data Screen” on page 3 - 18.
FILM USAGE	Press this button to go to the Film Usage Screen. See “Film Usage Screen” on page 3 - 20.
DUAL TURNTABLE	Press this button to go to the Dual Turntable Screen. See “Dual Turntable” on page 3 - 23.
FAULT TRACKING	Press this button to go to the Fault Tracking Screen. See “Fault Tracking” on page 3 - 24.
FILM SCALE	Press this button to go to the Film Scale Screen.




## Jogging Screen

This is the Jogging Screen. This screen allows jogging of each component of the machine.





**Figure 3 - 10**  
**The Jogging Screen**



**Table 3-8. The Jogging Screen Button Descriptions**

STATE 1	DESCRIPTION
 <b>Home Machine</b>	Press this button to move the machine to the home position.
 <b>Main Drive</b>	Press this button to jog the main drive (turntable/ tower) in the direction of normal operation. The main drive moves until the operator releases the jog button.
 <b>Carriage Up</b>	Press this button to jog the carriage upwards. The carriage move slowly upwards until the operator releases the jog button.

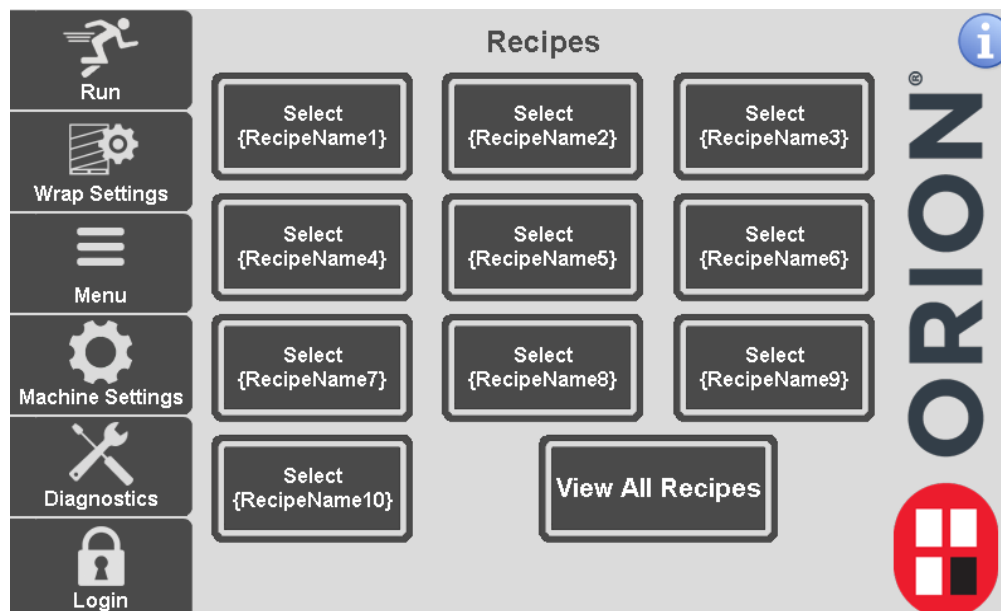
**Table 3-8. The Jogging Screen Button Descriptions (Continued)**

STATE 1	DESCRIPTION
 <p><b>Carriage Down</b></p>	<p>Press this button to jog the carriage downwards. The carriage move slowly downwards until the operator releases the jog button.</p>
 <p><b>Film Clamp</b></p>	<p>Press this button to toggle through the film clamp stages.</p>
 <p><b>Brush &amp; Cutter</b></p>	<p>Press this button to manually trigger the brush and cut sequence.</p>
 <p><b>Reset Cycle</b></p>	<p>Press this button to reset faults. If you press this button while the machine is running, the machine will abort the current wrap cycle.</p>

## Recipe Screen

This is the Recipe screen. This screens allows the user to select different wrap recipes quickly. Changes made to a recipe are saved to the active recipe.

**Figure 3 - 11**  
**The Recipe Screen**



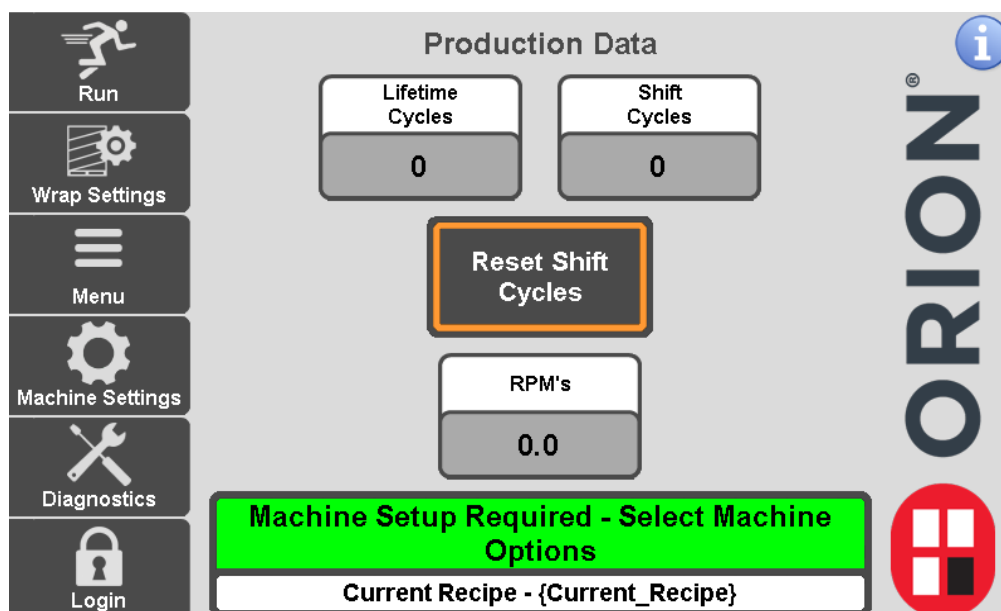
**Table 3-9. The Recipe Screen Button Descriptions**

STATE 1	DESCRIPTION	STATE 2
SELECT RECIPE #	Press a recipe button to choose between the different recipe wrap settings. Changes made to a recipe are saved to the active recipe. If you attempt to change to a different recipe while the wrapper is loading, then the new recipe you select will display as loading and will only change once the current wrap cycle is complete.	RUNNING RECIPE 1 LOADING RECIPE 1
VIEW ALL RECIPES	Press this button to go to the Recipe Viewing screen. See “Recipe Viewing Screen” on page 3 - 19.	

## Production Data Screen

This is the Production Data screen. This screen displays the lifetime cycles and shift cycles. You may also reset the shift cycle counter.

**Figure 3 - 12**  
**The Production Data**  
**Screen**



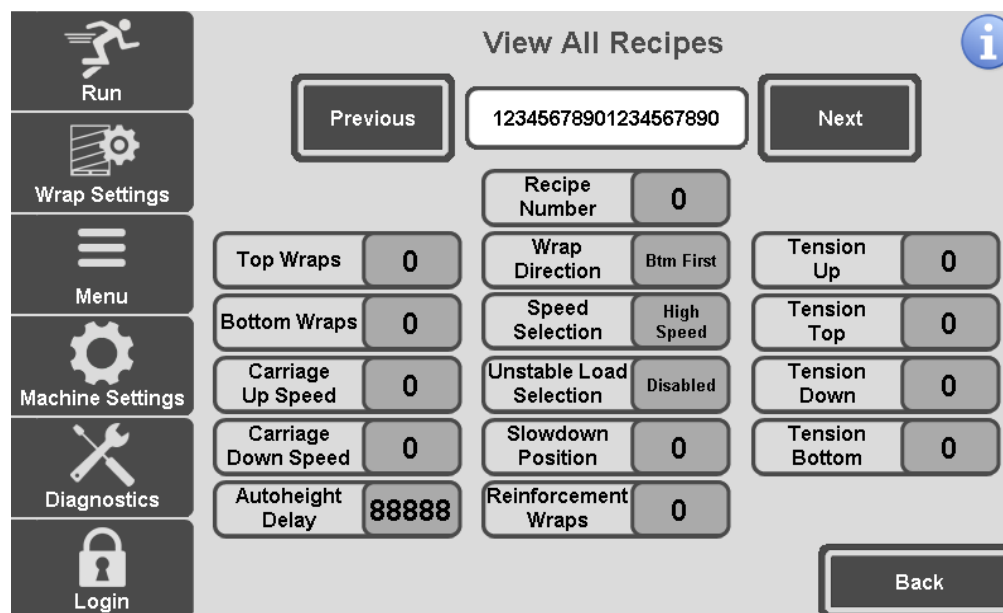
**Table 3-10. The Production Data Screen Button Descriptions**

STATE 1	DESCRIPTION
LIFETIME CYCLES	This display shows the number of cycles the machine has run, in total.
SHIFT CYCLES	This display shows the number of cycles the machine has run since the last shift cycle reset.
RESET SHIFT CYCLES	Press this button to reset the shift cycle counter to zero.
RPM'S	This display shows the actual running speed of the machine, in rotations per minute.

## Recipe Viewing Screen

This is the Recipe Viewing screen. This screen allows you to view each recipe settings. This is helpful for a quick glance at each recipe's parameters.

**Figure 3 - 13**  
**The Recipe Viewing Screen**



**Table 3-11. The Recipe Viewing Screen Button Descriptions**

STATE 1	DESCRIPTION
RECIPE	Press the recipe name to edit the name of the recipe.
PREVIOUS	Press this button to go to the previous Recipe View screen.
NEXT	Press this button to go to the next Recipe View screen.
BACK	Press this button to go back to the Recipe screen.

## Film Usage Screen

This is the Film Usage screen. The entries on this screen are used to calculate the film usage when Theoretical film usage is selected.

**Figure 3 - 14**  
**The Film Usage**  
**Screen**

The screenshot shows the 'Film Usage' screen. On the left is a vertical menu with icons and labels: Run, Wrap Settings, Menu, Machine Settings, Diagnostics, and Login. The main area contains several input fields and buttons. At the top, 'Pallet Length' and 'Pallet Width' are both set to '9999 in'. To their right, 'Film Gauge' is set to '9999' and 'Pre-Stretch' is set to '9999 %'. Below these, 'Today' is set to '100.0 oz' and 'Previous Cycle' is set to '100.0 oz'. There are 'Reset' buttons next to both 'Today' and 'Previous Cycle'. At the bottom, 'Total' is set to '100000.0 oz' with a 'Reset' button. A large green button labeled 'Machine Setup Required - Select Machine Options' is at the bottom center, with a text field below it showing 'Current Recipe - {Current\_Recipe}'. A 'Film Usage Settings' button is on the right side.

**Table 3-12. Film Usage Screen Button Descriptions**

STATE 1	DESCRIPTION
PALLET LENGTH	Press this button to enter the Pallet Length for film usage calculation when theoretical calculation is used.
PALLET WIDTH	Press this button to enter the Pallet Width for film usage calculation when theoretical calculation is used.
FILM GAUGE	Press this button to enter the Film Gauge used on the machine for film usage calculation when theoretical calculation is used.
PRE-STRETCH	Press this button to enter the Pre-stretch Percentage that the carriage is running. 260% is the standard carriage. The entered percentage is used to calculate film usage when theoretical calculation is used.
TODAY	This display shows the number of ounces of film used today.
RESET	Press this button to reset the Today Film ounces display to zero.
PREVIOUS CYCLE	This display shows the number of ounces of film used on the previous cycle.
TOTAL	This display shows the total number of ounces of film used since the last reset.
RESET	Press this button to reset the Total Film ounces display to zero.
FILM USAGE SETTINGS	Press this button to go to the Film Usage Settings Screen.



## Film Usage Settings

This is the Film Usage Settings screen. This screen is used to set the parameters that allow the machine and film monitoring system to calculate the film usage of the machine.

**Figure 3 - 15**  
**The Film Usage**  
**Settings Screen**

**Table 3-13. Film Usage Screen Button Descriptions**

STATE 1	DESCRIPTION
FILM USAGE GOAL	Press this button to enter the film usage goal, in ounces, per load. This information will be used to display your film goal and actual use data in the machine and film monitoring system.
LOWER SPEC LIMIT	Press this button to set the lower spec limit. This information will be used to display your film goal and actual use data in the machine and film monitoring system.
UPPER SPEC LIMIT	Press this button to set the upper spec limit. This information will be used to display your film goal and actual use data in the machine and film monitoring system.
PALLET LENGTH	Press this button to enter the Pallet Length for film usage calculation when theoretical calculation is used.
PALLET WIDTH	Press this button to enter the Pallet Width for film usage calculation when theoretical calculation is used.
FILM GAUGE	Press this button to enter the Film Gauge used on the machine for film usage calculation when theoretical calculation is used.
PRE-STRETCH	Press this button to enter the Pre-stretch Percentage that the carriage is running. 260% is the standard carriage. The entered percentage is used to calculate film usage when theoretical calculation is used.

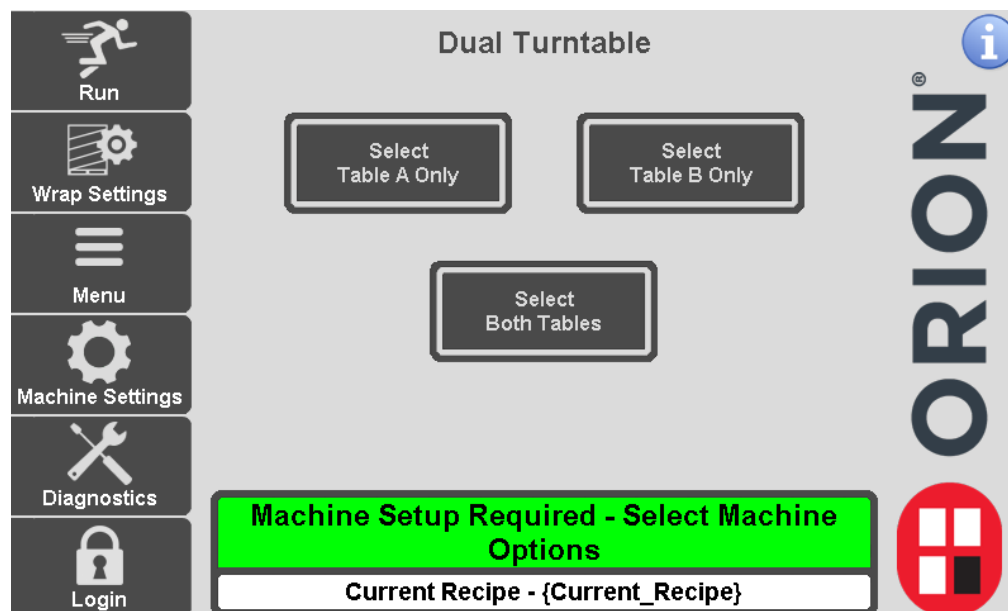
**Table 3-13. Film Usage Screen Button Descriptions (Continued)**

STATE 1	DESCRIPTION
<b>FILM WIDTH</b>	Press this button to enter the film width used. 20 inch and 30 inch carriages are available.
<b>HOURLY GOAL</b>	Press this button to enter the hourly goal for wrap cycles. The goal will affect the charts in your Machine and Film Monitoring System output.
<b>WORKING HOURS</b>	Press this button to choose the number of working hours in a day of production. The working hours will affect the charts in your Machine and Film Monitoring System output.
<b>STANDARD RECIPE TOP WRAPS</b>	Press this button to set the standard recipe number of top wraps. This is the number of top wraps your quality department has determined to use on a standard wrap.
<b>STANDARD RECIPE BOTTOM WRAPS</b>	Press this button to set the standard recipe number of bottom wraps. This is the number of bottom wraps your quality department has determined to use on a standard wrap.
<b>THEORETICAL</b>	Select Theoretical when your machine is not equipped with the Sentinel™ film weighing system. When in this mode, the film usage is calculated based on the user entered parameters entered on this screen.
<b>SENTINEL</b>	Select Sentinel only when your machine is equipped with the Sentinel™ film weighing system. The scale on the carriage will calculate film usage based on the weight of the film spool before and after each load is run. Do not choose Sentinel when the machine is not equipped with the Sentinel
<b>BACK</b>	Press this button to go back to the Film Usage Screen.

## Dual Turntable

This is the Dual Turntable screen. This screen is only used when you have the dual turntable option.

**Figure 3 - 16**  
**The Dual Turntable**  
**Screen**



**Table 3-14. Dual Turntable Screen Button Descriptions**

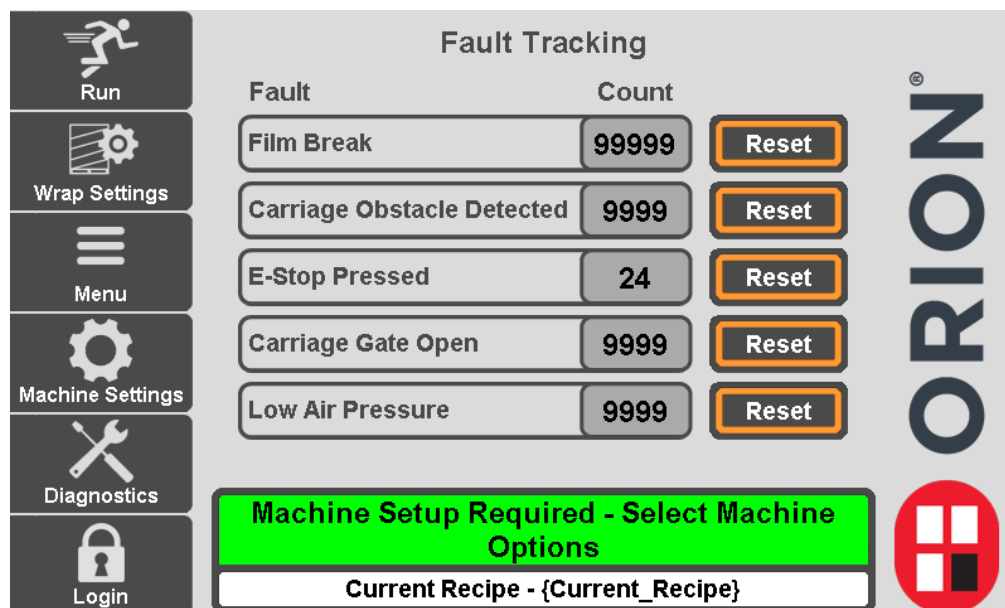
STATE 1	DESCRIPTION
SELECT TABLE A ONLY	Press this button to choose to run on the A table only.
SELECT TABLE B ONLY	Press this button to choose to run on the B table only.
SELECT BOTH TABLES	Press this button to alternately run table A and table B.

## Fault Tracking

This is the Fault Tracking screen. This screen shows the counters for each of the following fault conditions:

- Film Break
- Carriage Obstacle Detected
- E-Stop Pressed
- Carriage Gate Open
- Low Air Pressure

**Figure 3 - 17**  
**The Fault Tracking Screen**



**Table 3-15. Film Usage Screen Button Descriptions**

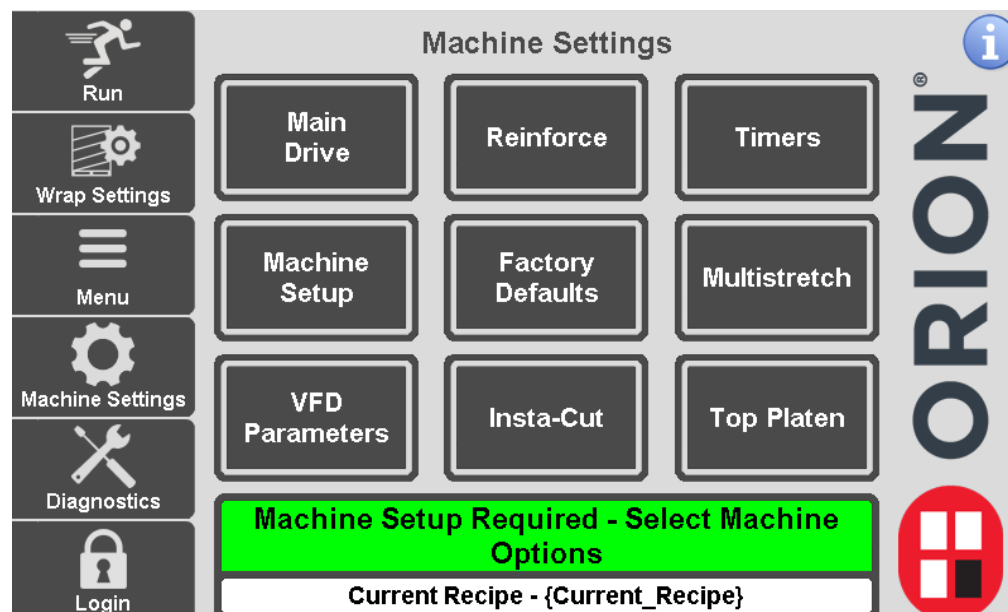
STATE 1	DESCRIPTION
RESET	Press the reset button next to any of the fault counters to reset the counter to zero.

# Machine Settings Screens

## Machine Settings Screen

This is the Machine Settings Screen. This screen allows access to each of the machine setting adjustments.

**Figure 3 - 18**  
**The Machine Settings Screen**



**Table 3-16. The Machine Settings Screen Button Descriptions**

STATE 1	DESCRIPTION
MAIN DRIVE	Press this button to go to the Main Drive Screen. See “Main Drive Screen” on page 3 - 27.
REINFORCE	Press this button to go to the Reinforce Screen. See “Reinforce Wrap Setup” on page 3 - 28.
TIMERS	Press this button to go to the Timers Screen. See “Insta-Cut Screen” on page 3 - 37.
MACHINE SETUP	Press this button to go to the Machine Setup Screen. See “Machine Setup Screen” on page 3 - 31.
FACTORY DEFAULTS	Press this button to go to the Factory Defaults Screen. See “Factory Defaults Screen” on page 3 - 34.
MULTISTRETCH	Press this button to go to the Multistretch Screen. See “Multistretch Settings Screen” on page 3 - 35.
VFD PARAMETERS	Press this button to go to the VFD Parameters Screen. See “The VFD Parameters Screen” on page 3 - 36.

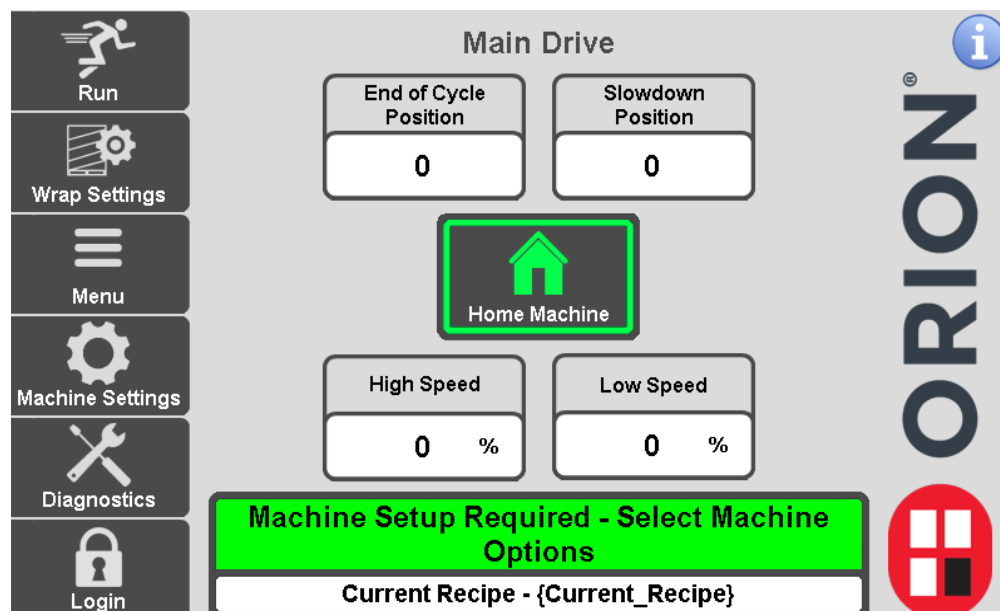
**Table 3-16. The Machine Settings Screen Button Descriptions (Continued)**

STATE 1	DESCRIPTION
INSTA-CUT	Press this button to go to the Insta-Cut Screen. See “Insta-Cut Screen” on page 3 - 37.
TOP PLATEN	Press this button to go to the Top Platen Screen.

## Main Drive Screen

This is the Main Drive screen. This screen allows adjustment of the Main Drive (turntable or rotary arm drive.)

**Figure 3 - 19**  
**The Main Drive**  
**Screen**



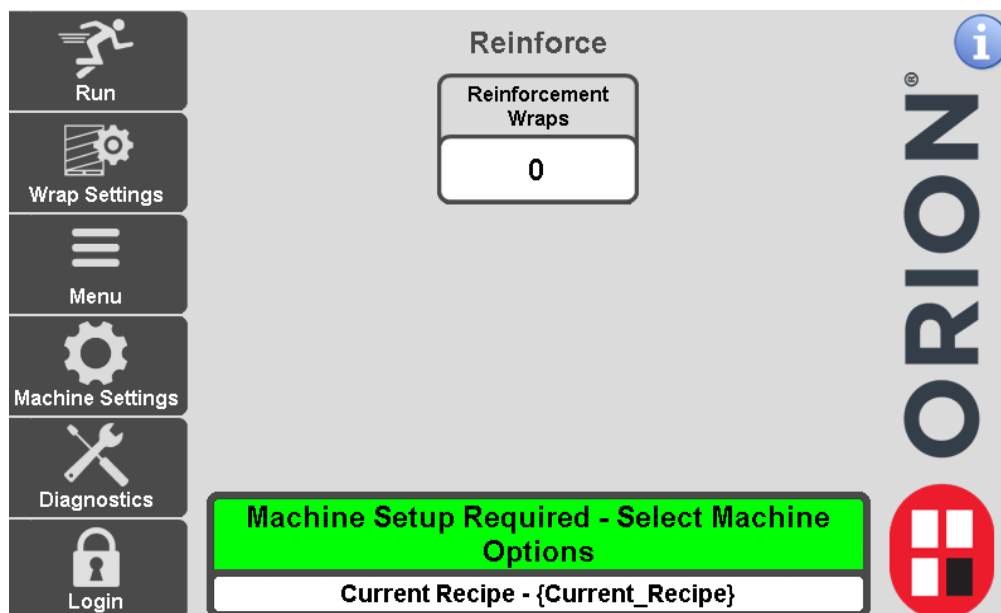
**Table 3-17. The Main Drive Screen Button Descriptions**

STATE 1	DESCRIPTION
END OF CYCLE POSITION	Press this button to modify the End of Cycle Position value. This value determines the tooth count position at which the Main Drive will stop at the end of a wrap cycle, or when the Home Machine button is pressed. Min - 0 Max - 50
SLOWDOWN POSITION	The slow down position is when the turntable or tower starts to decel before stopping at home. An earlier slow down position might be needed for heavier loads and a later slowdown position for lighter loads. The value is the tooth count in which the machine will start to decelerate.
Home Machine	Press this button to send the machine to its Home Position. When pressed, the Carriage will travel to its bottom limit, and the Main Drive will travel to its predefined End of Cycle Position.
HIGH SPEED	Press this button to modify the High Speed value, in terms of hertz. This value determines the speed at which the Main Drive will travel during the wrap cycle when High Speed is selected. Min - 8 Hz Max - 27 Hz
LOW SPEED	Press this button to modify the Low Speed value, in terms of hertz. This value determines the speed at which the Main Drive will travel during the wrap cycle when Low Speed is selected. Min - 27 Hz Max - 55 Hz

## Reinforce Wrap Setup

This is the Reinforce Wraps Setting Screen. This screen allows the user to set the number of reinforce wraps that are applied when the reinforce button on the Run Screen is pressed.

**Figure 3 - 20**  
**The Reinforce Setup**  
**Screen**



**Table 3-18. The Reinforce Wraps Screen Button Descriptions**

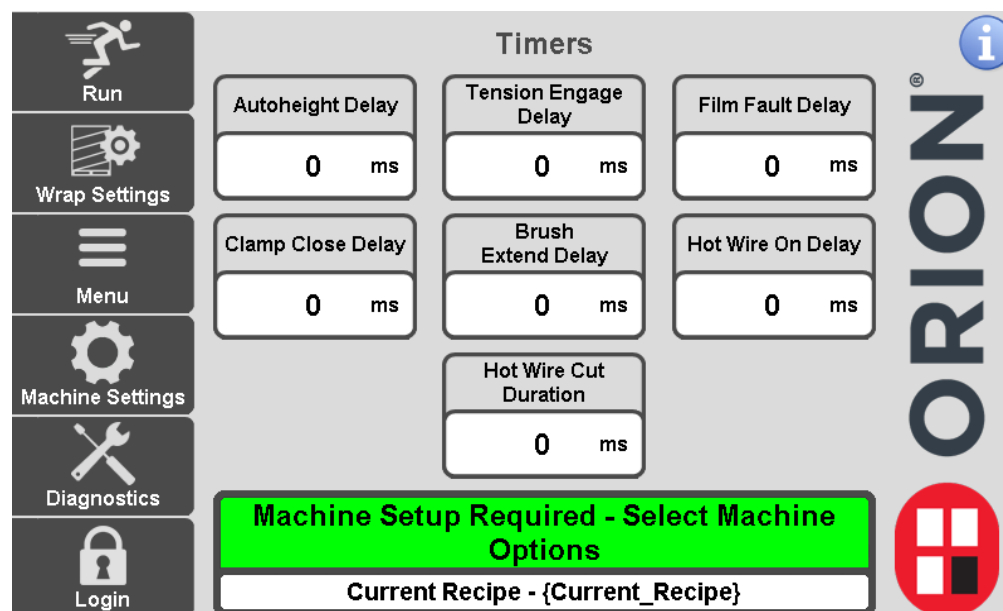
STATE 1	DESCRIPTION
REINFORCE WRAPS	Press this button to set the number of reinforce wraps that are applied when the enable reinforce wraps button is pressed on the Run screen.



## Timers Screen

This is the Timers Screen. This screen allows adjustment of the timers involved in the machine cycle. See the Table below for descriptions and parameters of each setting.

**Figure 3 - 21**  
**The Timers Screen**



**Table 3-19. The Timers Screen Button Descriptions**

STATE 1	DESCRIPTION
<b>AUTOHEIGHT DELAY</b>	Press this button to modify the Autoheight Delay value, in terms of milliseconds. This value determines the amount of time that the Carriage will continue to travel up during the wrap cycle after the Autoheight photoeye no longer detects a load. This is used to adjust the amount of overlap on the top of the load. Min - 0 ms Max - 10000 ms
<b>TENSION ENGAGE DELAY</b>	Press this button to modify the Tension Engage Delay value, in terms of milliseconds. This value determines the amount of time, at the beginning of the wrap cycle, that the Multistretch will pay out film at normal speed before applying tension. This is to keep film from pulling out of the clamp or away from the load. Min - 0 ms Max - 10000 ms
<b>FILM FAULT DELAY</b>	Press this button to modify the Film Fault Delay value, in terms of milliseconds. This value determines the amount of time, during a wrap cycle, that the Multistretch must be inactive before triggering an End of Film Roll or Broken Film fault. Min - 0 ms Max - 10000 ms
<b>CLAMP CLOSE DELAY</b>	Press this button to modify the Clamp Close Delay value, in terms of milliseconds. This value determines the amount of time, after the Main Drive has reached the End of Cycle position, that the machine will delay before initiating the Clamp and Cut sequence. Min - 0 sec Max - 3 sec

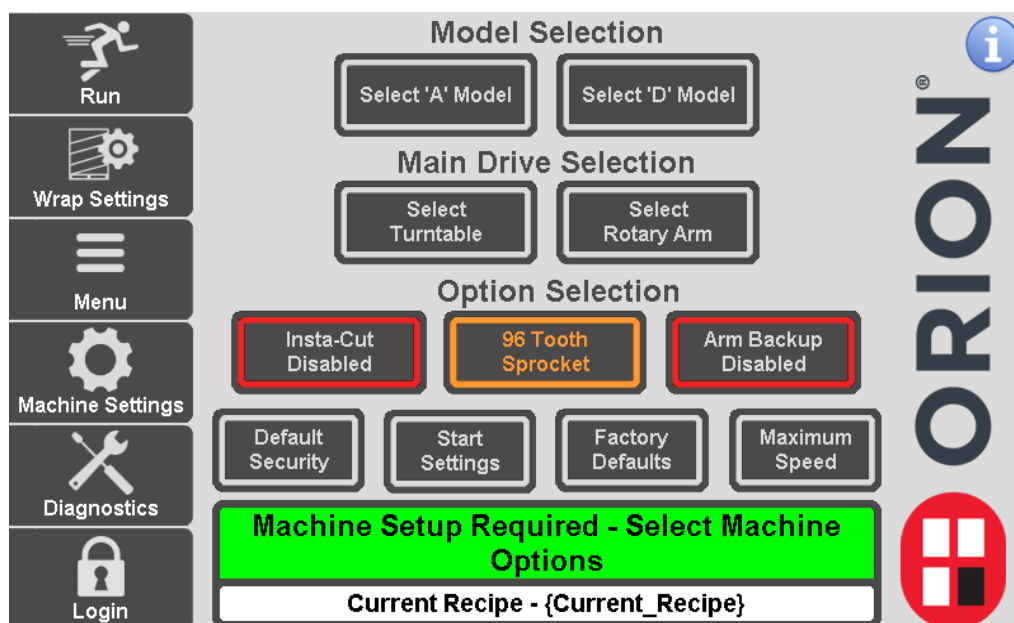
**Table 3-19. The Timers Screen Button Descriptions (Continued)**

STATE 1	DESCRIPTION
<b>BRUSH EXTEND DELAY</b>	Press this button to modify the Brush Extend Delay value, in terms of milliseconds. This value determines the amount of time, after the Brush and Cutter arm has begun to extend, that the Brush will delay before extending to wipe the film tail against the load. Min - 0 ms Max - 5000 ms
<b>HOT WIRE ON DELAY</b>	Press this button to modify the Hot Wire On Delay value, in terms of milliseconds. This value determines the amount of time, after the Brush and Cutter arm has begun to extend, that the Hot Wire will delay before turning on to cut the film. Min - 0 ms Max - 5000 ms
<b>HOT WIRE CUT DURATION</b>	Press this button to modify the Hot Wire Cut Duration value, in terms of milliseconds. This value determines the amount of time, after the Hot Wire has turned on, that it will remain on to cut the film. <b>Warning:</b> Too high of a value may destroy the hot wire. Min - 1000 ms Max - 7000 ms

## Machine Setup Screen

This is the Machine Setup Screen. This screen is used when setting up the initial machine configuration. The technicians who assembled your machine already set the type of machine you have on this screen. You will not need to make any changes on this screen in day-to-day use.

**Figure 3 - 22**  
**The Machine Setup Screen**



**Table 3-20. The Machine Setup Screen Button Descriptions**

STATE 1	DESCRIPTION	STATE 2
<b>SELECT A MODEL</b>	Press this button to select model A.	<b>A MODEL SELECTED</b>
<b>SELECT D MODEL</b>	Press this button to select model D.	<b>D MODEL SELECTED</b>
<b>SELECT TURNTABLE</b>	Press this button to select that the machine is a turntable machine.	<b>TURNTABLE SELECTED</b>
<b>SELECT ROTARY ARM</b>	Press this button to select that the machine is a rotary arm machine.	<b>ROTARY ARM SELECTED</b>
<b>INSTA-CUT DISABLED</b>	Press this button to activate or de-activate Insta-Cut.	<b>INSTA-CUT ENABLED</b>
<b>PRESS FOR 96 TOOTH SPROCKET</b>	Press this button to select whether the machine has a 96 tooth or a 112 tooth sprocket.	<b>PRESS FOR 112 TOOTH SPROCKET</b>
<b>ARM BACKUP DISABLED</b>	Press this button to enable or disable the Arm Backup feature (RTA model only). When enabled, the Rotary Arm will reverse to the Home Prox after the film was clamped and cut.	<b>ARM BACKUP ENABLED</b>

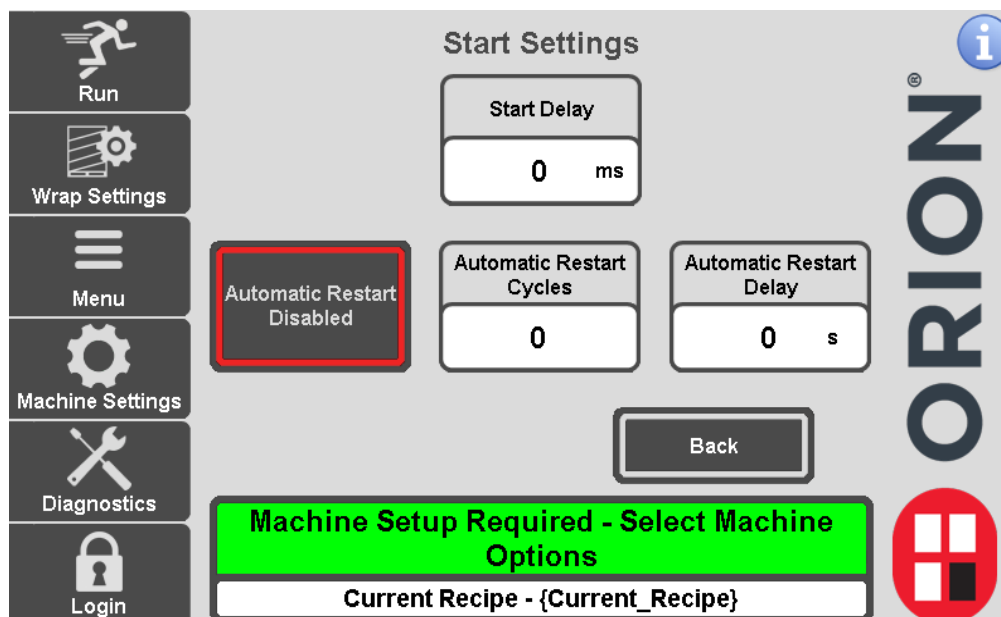
**Table 3-20. The Machine Setup Screen Button Descriptions (Continued)**

STATE 1	DESCRIPTION	STATE 2
DEFAULT SECURITY	Press this button to go to the Security Settings Screen.	
START SETTINGS	Press this button to go to the Start Settings Screen.	
FACTORY DEFAULTS	Press this button to go to the Factory Defaults Screen.	
MAXIMUM SPEED	Press this button to go to the Maximum Speed Screen.	

## Start Delay Screen

This is the Start Delay screen. On this screen, you may set the amount of time, in milliseconds that the start button must be pressed before the machine starts.

**Figure 3 - 23**  
**The Start Delay Screen**



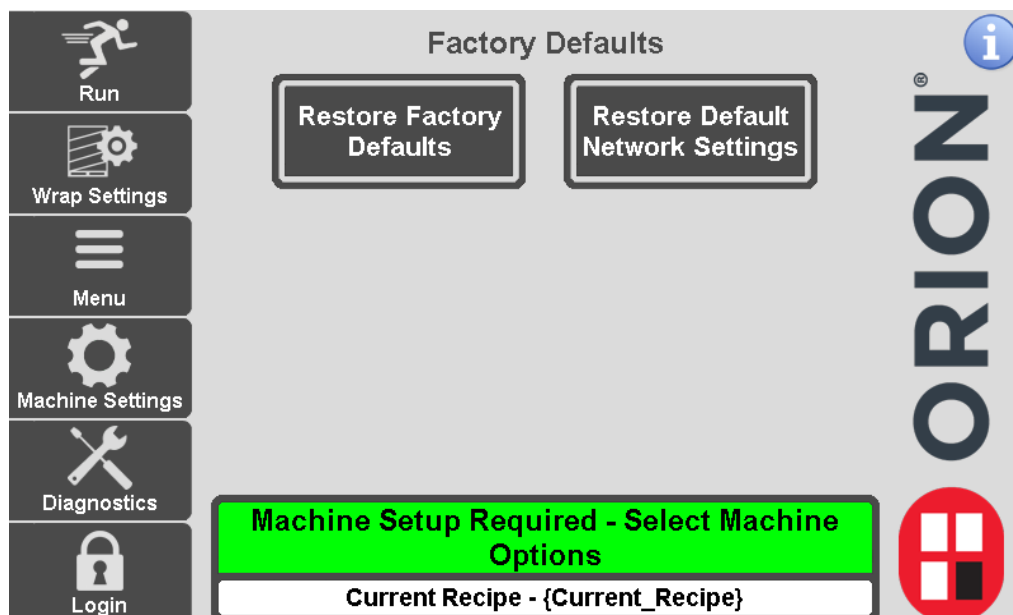
**Table 3-21. The Start Delay Screen Button Descriptions**

STATE 1	DESCRIPTION	
START DELAY	Press this button to modify the Start Delay value, in terms of milliseconds. This value determines the amount of time that the Start pushbutton must be pressed before the machine will start. Min - 500 ms Max - 5000 ms	
AUTOMATIC RESTART DISABLED	Press this button to enable or disable automatic restart mode. When automatic restart mode is enabled, the machine will automatically restart at the end of its cycle after the time indicated on the automatic restart delay timer elapses.	AUTOMATIC RESTART ENABLED
AUTOMATIC RESTART CYCLES	This sets the number of cycles that the machine will automatically run.	
AUTOMATIC RESTART DELAY	This modifies the delay time between the machine's automatic restart cycles.	
BACK	Press this button to go to the Machine Setup screen.	

## Factory Defaults Screen

This is the Factory Defaults Screen. This screen allows authorized users to go back to the factory default settings.

**Figure 3 - 24**  
**The Factory Defaults Screen**



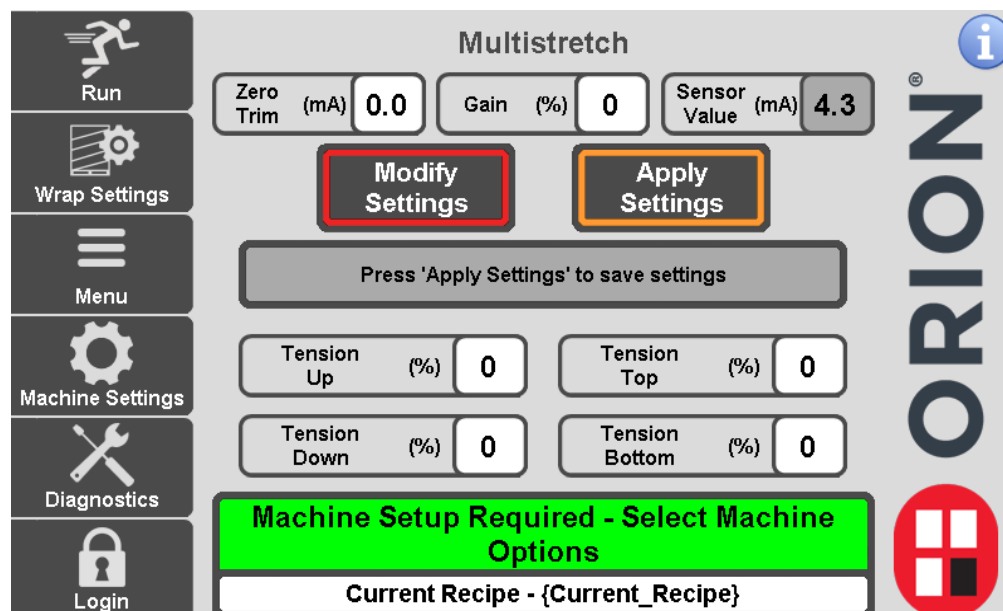
**Table 3-22. The Factory Defaults Screen Button Descriptions**

STATE 1	DESCRIPTION
RESTORE FACTORY DEFAULTS	Press this button to delete the currently entered factory settings and replace them with the original factory default settings. This will replace all Wrap Settings, Machine Settings, and Recipes with the factory default parameters.
RESTORE DEFAULT NETWORK SETTINGS	Press this button to restore default network settings to the machine.

## Multistretch Settings Screen

This is the Multistretch Settings (MIB) screen. This page is useful primarily to repair personnel when troubleshooting the machine.

**Figure 3 - 25**  
**The Multistretch**  
**Screen**



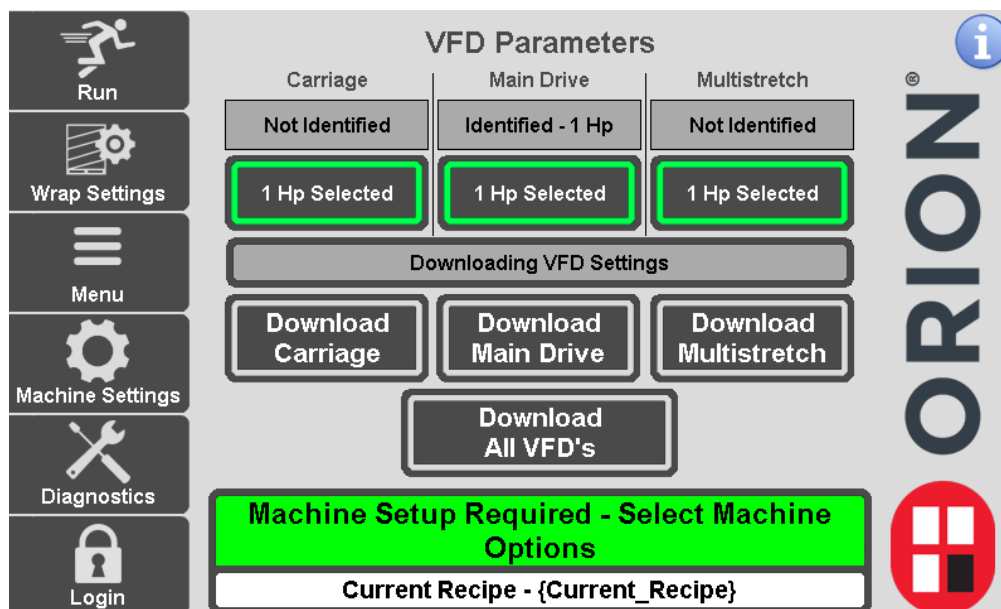
**Table 3-23. The Multistretch Screen Button Descriptions**

STATE 1	DESCRIPTION
ZERO TRIM	Press this button to modify the Zero Trim datapoint, in terms of milliamps. This value determines at which point the Multistretch will begin paying out film as the dancer bar is deflected. This value should be .5 mA higher than the Hall Effect Sensor reading with the dancer bar at rest. Min - 3.mA Max - 8 mA
GAIN	Press this button to modify the Gain datapoint, in terms of percentage. This value sets percentage of deflection of the dancer bar that is required for the Multistretch to pay out film at maximum speed. Min - 10% Max - 100%
SENSOR VALUE	
HALL EFFECT SENSOR	This displays the current dancer bar Hall Effect Sensor reading, in terms of milliamps.
MODIFY SETTINGS	Press this button for access to modify the Zero Trim or Gain datapoints. The Multistretch is disabled while modifying the datapoints.
APPLY SETTINGS	Press this button to accept the current Zero Trim and Gain datapoints and apply them to the Multistretch. When complete, the drive will be enabled again.
FILM TENSION	Press this button to modify the Film Tension datapoint, in terms of percentage. This value limits the maximum speed at which the Multistretch will pay out film, which creates tension. Min - 0% Max - 100%

## The VFD Parameters Screen

This is the VFD Parameters screen. On this screen, you can identify the horsepower for each drive or transfer VFD parameters from the PLC to the VFD's.

**Figure 3 - 26**  
**The VFD Parameters Screen**



**Table 3-24. The VFD Parameters Screen Button Descriptions**

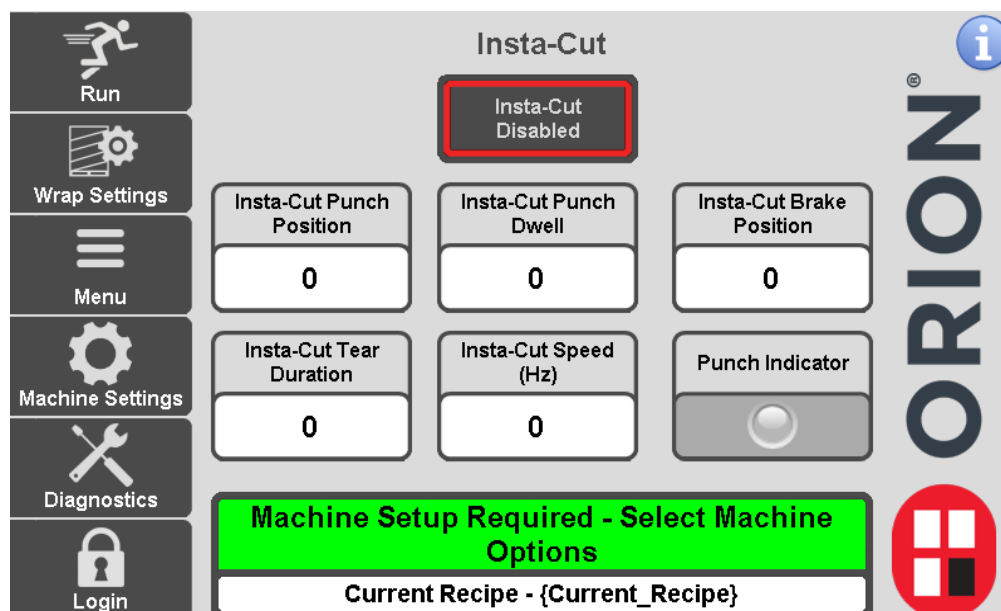
STATE 1	DESCRIPTION
NOT IDENTIFIED	Displayed if the machine cannot automatically identify the size of VFD currently installed. In this case, the VFD size must be manually selected before downloading.
1/2 HP IDENTIFIED	Displayed if the machine identifies the current VFD as half horsepower drive.
1 HP IDENTIFIED	Displayed if the machine identifies the current VFD as a one horsepower drive.
SELECT VFD SIZE	If the machine cannot automatically identify the size of the VFD, press this button to manually select the size of VFD currently installed.
1/2 HP SELECTED	Displayed if the current VFD is manually selected as a half horsepower drive.
1 HP SELECTED	Displayed if the current VFD is manually selected as a one horsepower drive.
DOWNLOAD MAIN DRIVE	Downloads the default Main Drive VFD parameters from the PLC to the VFD.
DOWNLOAD CARRIAGE	Downloads the default Carriage VFD parameters from the PLC to the VFD.
DOWNLOAD MULTISTRETCH	Downloads the default Multistretch VFD parameters from the PLC to the VFD.
DOWNLOAD ALL VFD'S	Downloads the default VFD parameters from the PLC to the VFD.



## Insta-Cut Screen

This is the Insta-Cut screen. This screen is only used for machine equipped with Insta-Cut. You may enable or disable Insta-Cut or adjust any of the Insta-Cut parameters.


**Figure 3 - 27**  
**The Insta-Cut Screen**



**Table 3-25. The Insta-Cut Screen Button Descriptions**

STATE 1	DESCRIPTION	STATE 2
<b>INSTA-CUT ENABLED</b>	Press this button to toggle between Insta-Cut On or Insta-Cut Off. This allows the operator to disable the Insta-Cut function.	<b>INSTA-CUT DISABLED</b>
<b>INSTA-CUT PUNCH POSITION</b>	Press this button to modify the Insta-Cut Punch Position. This is the tooth count position at which the Insta-Cut puncher activates to punch a hole in the film. Min - 20 Max - 96 or 112, depending on sprocket selection.	
<b>INSTA-CUT PUNCH DWELL</b>	Press this button to modify the Insta-Cut Punch Dwell. This is the amount of teeth that the Insta-Cut puncher will stay activated to create a hole in the film. Min - 2 Max - 15	
<b>INSTA-CUT BRAKE POSITION</b>	Press this button to modify the Insta-Cut Brake Position. This is the tooth count position at which the Multistretch will stop paying out film, which causes the film to tear. Min - (Insta-Cut Punch Position + Insta-Cut Punch Dwell) Max - 96 or 112, depending on sprocket selection.	
<b>INSTA-CUT TEAR DURATION</b>	Press this button to modify the Insta-Cut Tear Duration. This is the amount of teeth that the Main Drive will continue to travel at the predefined Insta-Cut Speed before slowing down to Jog Speed and stopping at home. Min - 0 Max - 96 or 112, depending on sprocket selection.	

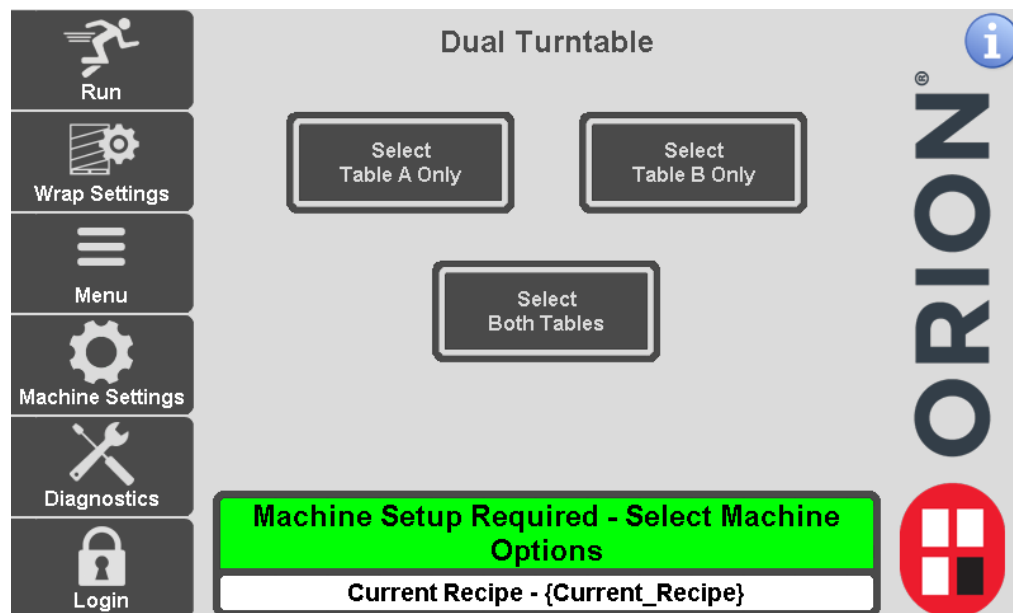
**Table 3-25. The Insta-Cut Screen Button Descriptions (Continued)**

STATE 1	DESCRIPTION	STATE 2
<b>INSTA-CUT SPEED HZ</b>	Press this button to modify the Insta-Cut Speed. This is the speed at which the Main Drive will travel during the Insta-Cut sequence. Min - 8 Hz Max - 27 Hz	
 <p>Insta-Cut Punch Indicator</p>	This indicator will glow green when the Insta-Cut puncher is active.	

## Dual Turntable Screen

This is the Dual Turntable Screen. This screen is only used for Dual Turntable equipped machines. From this screen, you may set the A or B only tables to run or you can choose to alternate between running the A and B tables every other cycle.

**Figure 3 - 28**  
**The Dual Turntable**  
**Screen**



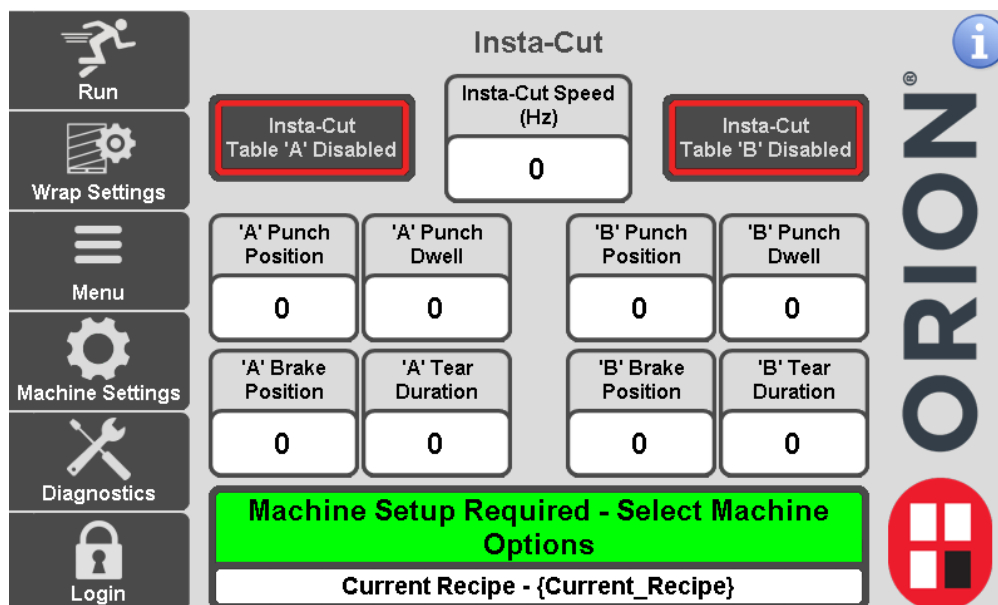
**Table 3-26. The Dual Turntable Screen Button Descriptions**

STATE 1	DESCRIPTION
SELECT TABLE A ONLY	Press this button to only use Table A, which is the table that is closest to the tower.
SELECT TABLE B ONLY	Press this button to only use Table B, which is the table that is farthest from the tower.
SELECT BOTH TABLES	Press this button to use both tables. The machine will alternate between the A and B tables at the end of each wrap cycle.

## Dual Insta-Cut Screen

This is the Dual Turntable Insta-Cut Screen. This screen is only used for Dual Turntable machines which also have Insta-Cut.


**Figure 3 - 29**  
**The Dual Insta-Cut Screen**



**Table 3-27. The Insta-Cut Screen Button Descriptions**

STATE 1	DESCRIPTION	STATE 2
<b>INSTA- CUT TABLE A ENABLED</b>	Press this button to toggle between Insta-Cut On or Insta-Cut Off for table A. This allows the operator to disable the Insta-Cut function.	<b>INSTA-CUT TABLE A DISABLED</b>
<b>INSTA- CUT TABLE B ENABLED</b>	Press this button to toggle between Insta-Cut On or Insta-Cut Off for table B. This allows the operator to disable the Insta-Cut function.	<b>INSTA-CUT TABLE B DISABLED</b>
<b>A INSTA-CUT PUNCH POSITION</b>	Press this button to modify the table A Insta-Cut Punch Position. This is the tooth count position at which the Insta-Cut puncher activates to punch a hole in the film. Min - 20 Max - 96 or 112, depending on sprocket selection.	
<b>A INSTA-CUT PUNCH DWELL</b>	Press this button to modify the table A Insta-Cut Punch Dwell. This is the amount of teeth that the Insta-Cut puncher will stay activated to create a hole in the film. Min - 2 Max - 15	
<b>A INSTA-CUT BRAKE POSITION</b>	Press this button to modify the table A Insta-Cut Brake Position. This is the tooth count position at which the Multistretch will stop paying out film, which causes the film to tear. Min - (Insta-Cut Punch Position + Insta-Cut Punch Dwell) Max - 96 or 112, depending on sprocket selection.	

**Table 3-27. The Insta-Cut Screen Button Descriptions (Continued)**

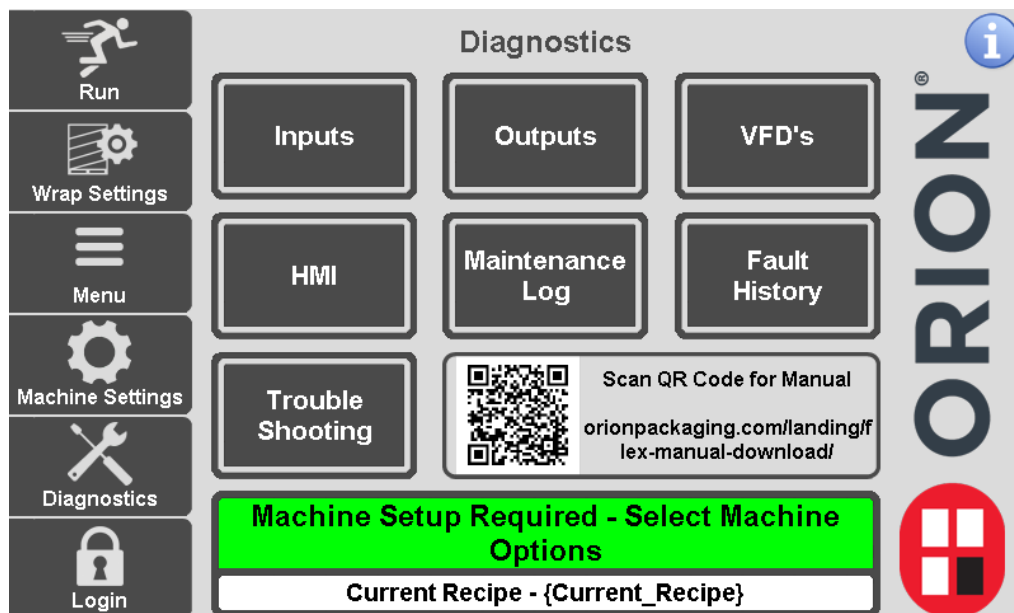
STATE 1	DESCRIPTION	STATE 2
<b>A INSTA-CUT TEAR DURATION</b>	Press this button to modify the table A Insta-Cut Tear Duration. This is the amount of teeth that the Main Drive will continue to travel at the predefined Insta-Cut Speed before slowing down to Jog Speed and stopping at home. Min - 0 Max - 96 or 112, depending on sprocket selection.	
<b>B INSTA-CUT PUNCH POSITION</b>	Press this button to modify the table B Insta-Cut Punch Position. This is the tooth count position at which the Insta-Cut puncher activates to punch a hole in the film. Min - 20 Max - 96 or 112, depending on sprocket selection.	
<b>B INSTA-CUT PUNCH DWELL</b>	Press this button to modify the table B Insta-Cut Punch Dwell. This is the amount of teeth that the Insta-Cut puncher will stay activated to create a hole in the film. Min - 2 Max - 15	
<b>B INSTA-CUT BRAKE POSITION</b>	Press this button to modify the table B Insta-Cut Brake Position. This is the tooth count position at which the Multistretch will stop paying out film, which causes the film to tear. Min - (Insta-Cut Punch Position + Insta-Cut Punch Dwell) Max - 96 or 112, depending on sprocket selection.	
<b>B INSTA-CUT TEAR DURATION</b>	Press this button to modify the table B Insta-Cut Tear Duration. This is the amount of teeth that the Main Drive will continue to travel at the predefined Insta-Cut Speed before slowing down to Jog Speed and stopping at home. Min - 0 Max - 96 or 112, depending on sprocket selection.	
<b>B INSTA-CUT SPEED HZ</b>	Press this button to modify the Insta-Cut Speed. This is the speed at which the Main Drive will travel during the Insta-Cut sequence. Min - 8 Hz Max - 27 Hz	
 <p>Insta-Cut Punch Indicator</p>	This indicator will glow green when the Insta-Cut puncher is active.	

# Diagnostics Screens

## Diagnostics Screen

This is the Diagnostics screen. This screen allows navigation to each of the Diagnostic Screens.

**Figure 3 - 30**  
**The Diagnostics Screen**



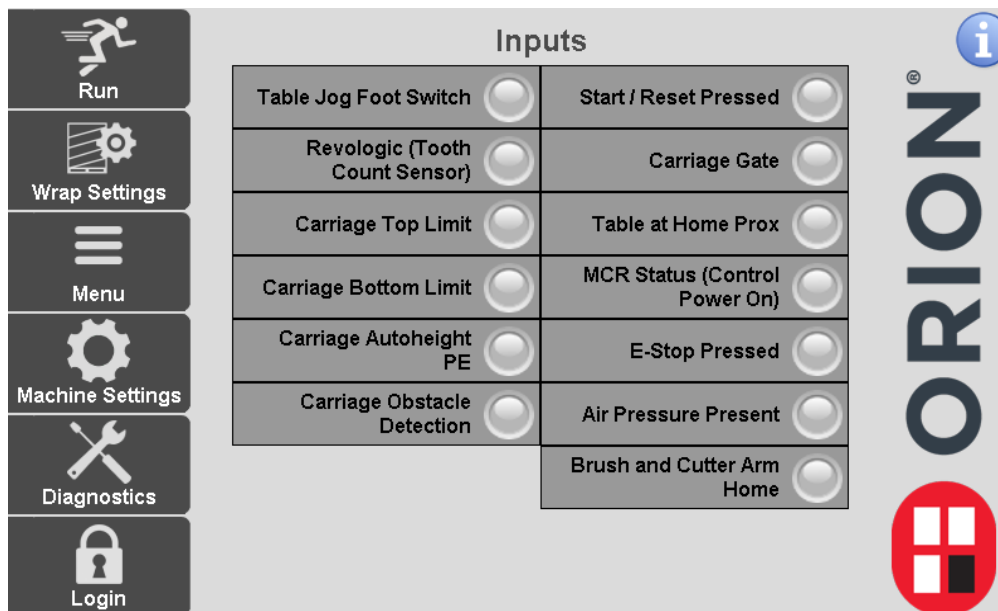
**Table 3-28. The Diagnostics Screen Button Descriptions**

STATE 1	DESCRIPTION
INPUTS	Press this button to go to the Inputs Screen. See “The Inputs Screens” on page 3 - 43.
OUTPUTS	Press this button to go to the Outputs Screen. See “The Outputs Screens” on page 3 - 44.
VFD'S	Press this button to go to the VFD's Screen. See “The VFD Diagnostics Screen” on page 3 - 45.
HMI	Press this button to go to the HMI Screen. See “HMI Setup” on page 3 - 46.
MAINTENANCE LOG	Press this button to go to the Maintenance Log Screen. See “Maintenance Log Screen” on page 3 - 47.
FAULT HISTORY	Press this button to go to the Fault History Screen. See “Fault History Screen” on page 3 - 48.
TROUBLESHOOTING	Press this button to display the interactive troubleshooting guide. You can press links on the first page to view the help topic needed. Maintenance information is also included at the end of the guide.

## The Inputs Screens

This is the Inputs screen. This screen shows the status of the machine inputs. There is another screen similar to this for displaying output status.

**Figure 3 - 31**  
**The Inputs Screen**



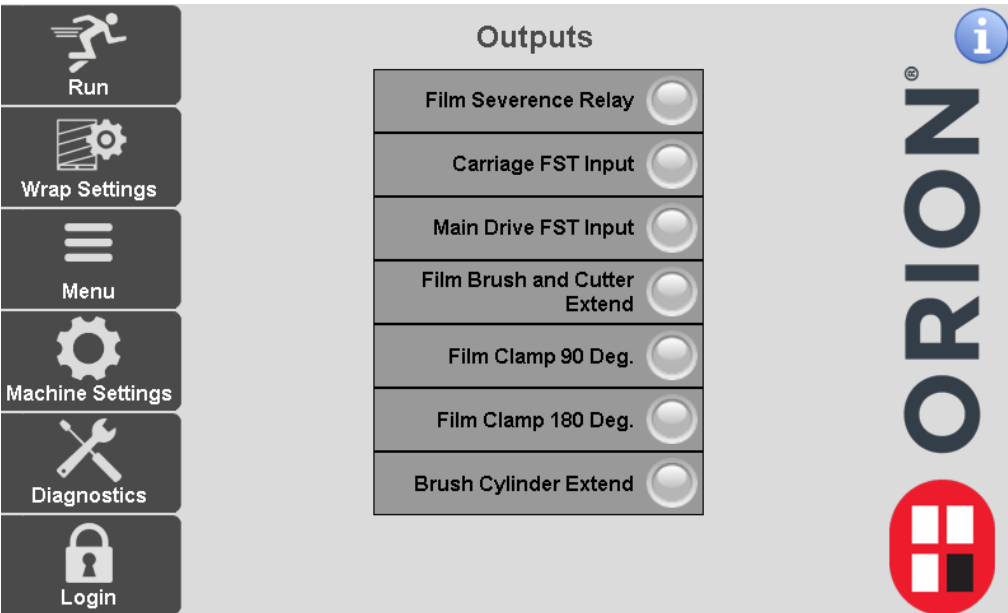
**Table 3-29. The Input Screen Button Descriptions**

STATE 1	DESCRIPTION
	<p>Grey represents an inactive input. Green represents an active input.</p>

# The Outputs Screens

This is the Outputs screen. This screen shows the status of the machine outputs. There is another screen similar to this for displaying input status.

**Figure 3 - 32**  
**The Outputs Screen**



**Table 3-30. The Output Screen Button Descriptions**

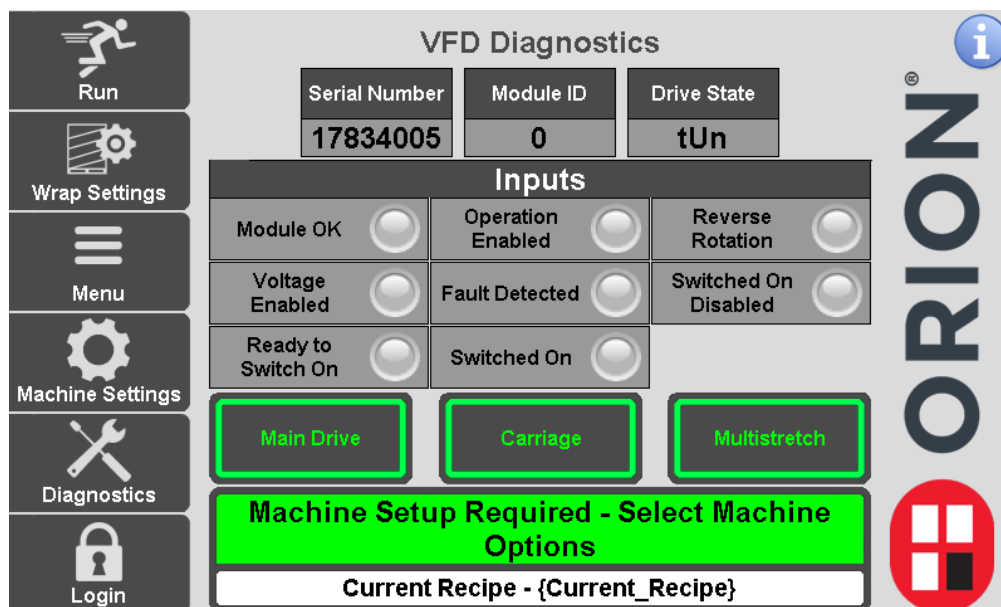
STATE 1	DESCRIPTION
	Grey represents an inactive output. Green represents an active output.




## The VFD Diagnostics Screen

This is the VFD Diagnostics screen. This screen allows you to view the diagnostics information about each VFD.

**Figure 3 - 33**  
**The VFD Diagnostics Screen**



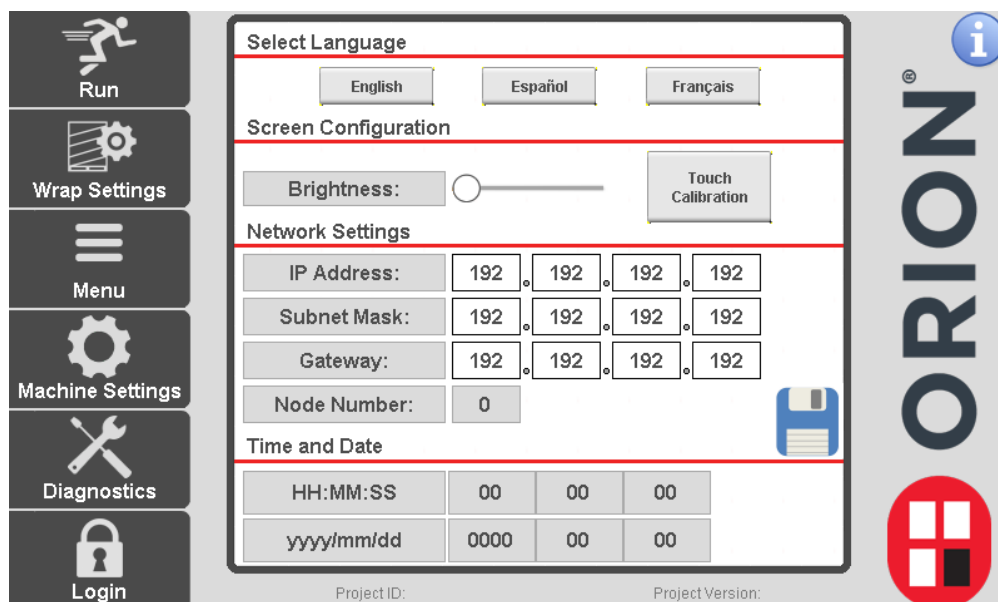
**Table 3-31. The VFD Diagnostics Screen Button Descriptions**

STATE 1	DESCRIPTION
SERIAL NUMBER	This displays the serial number of the selected VFD.
MODULE ID	This displays the Module ID of the selected VFD.
DRIVE STATE	This displays the current Drive State of the selected VFD.
CARRIAGE	Press this button to select the Carriage input view.
TURNTABLE	Press this button to select the Turntable input view.
MULTISTRETCH	Press this button to select the Multistretch input view.
	Gray represents an inactive input. Green represents an active input.


## HMI Setup

This is the HMI Setup Screen. This screen allows you to choose the HMI language, set the screen brightness, adjust the network settings, calibrate the touchscreen touch points, and set the date and time.

**Figure 3 - 34**  
**The HMI Setup**  
**Screen**



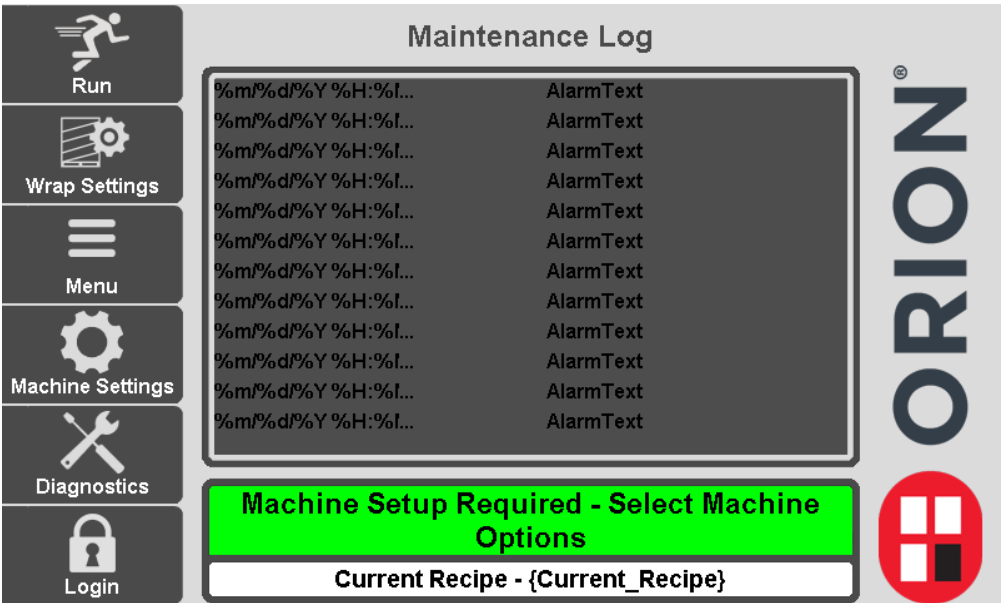
**Table 3-32. The HMI Setup Screen Button Descriptions**

STATE 1	DESCRIPTION
ENGLISH	Press this button to switch the HMI text to English.
ESPAÑOL	Press this button to switch the HMI text to Spanish.
BRIGHTNESS	Use the slider to adjust the brightness of the HMI screen. Slide to the right to increase the brightness. Slide to the left to decrease the brightness.
TOUCH CALIBRATION	Press this button to go to the touch calibration screen. This is used to set the alignment of the touch screen. There are multiple targets to press to align the screen.
NETWORK SETTINGS	When logged in as an Administrator, you can edit the IP Address, Subnet Mask, Gateway, or Node number. Press save, when done editing. If you are not logged in with the correct credentials, these settings are read-only.
	Press this button to save the Network Settings. If you navigate away from the screen without saving, the entered network settings will not take effect.
TIME AND DATE	Press the numbers to edit the time and date. The format is hours (01-24), minutes (0-59), seconds (0-59). The date is set by year (####), month (1-12), and day (1-31).

# Maintenance Log Screen

This is the Maintenance Log screen. This screen allows you to look back at the maintenance alarms and whether they were Acknowledged or Snoozed.

**Figure 3 - 35**  
**The Maintenance Log Screen**



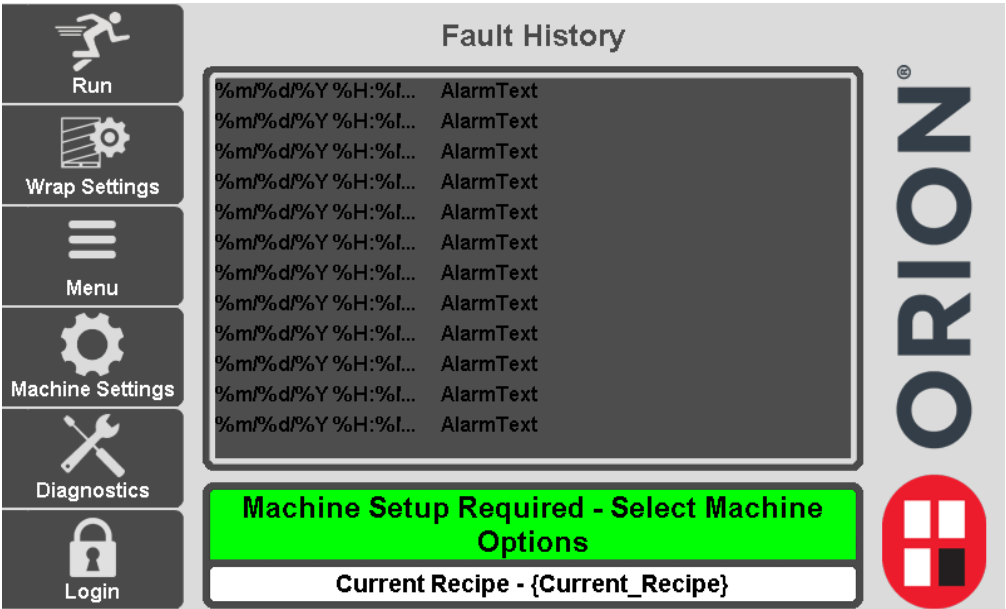
**Table 3-33. The Maintenance Log Screen Button Descriptions**

STATE 1	DESCRIPTION
ANY DISPLAY	The displays on this screen cannot be altered on this screen. These displays show the Maintenance Log for the indicated maintenance notifications.

# Fault History Screen

This is the Fault History screen. The screen displays the faults and the time they occurred.

**Figure 3 - 36**  
**The Fault History**  
**Screen**



**Table 3-34. The Fault History Screen Button Descriptions**

STATE 1	DESCRIPTION
ANY DISPLAY	The displays on this screen cannot be altered on this screen. These displays show the Fault History Log.

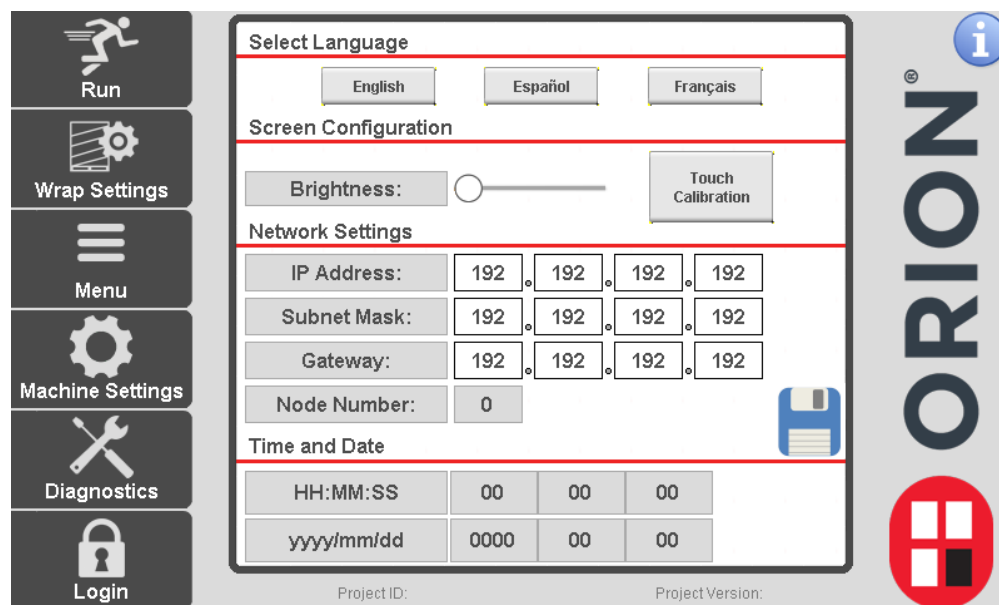
# Flex Dashboard Remote Viewing

## Setting up Dashboard Remote Viewing

Your new flex machine has the capability of remotely viewing the status from your computer browser on the same network. You will need your network administrator to advise what IP address should be used for your flex machine.

1. Press Login to log into Admin level security.
2. Enter the user password. Press Enter.
3. Press Diagnostics.
4. Press HMI.
5. Enter the IP network settings approved by your system administrator.
6. Press Save (Disk Icon.)

**Figure 3 - 37**  
**Setting the IP**  
**Address**

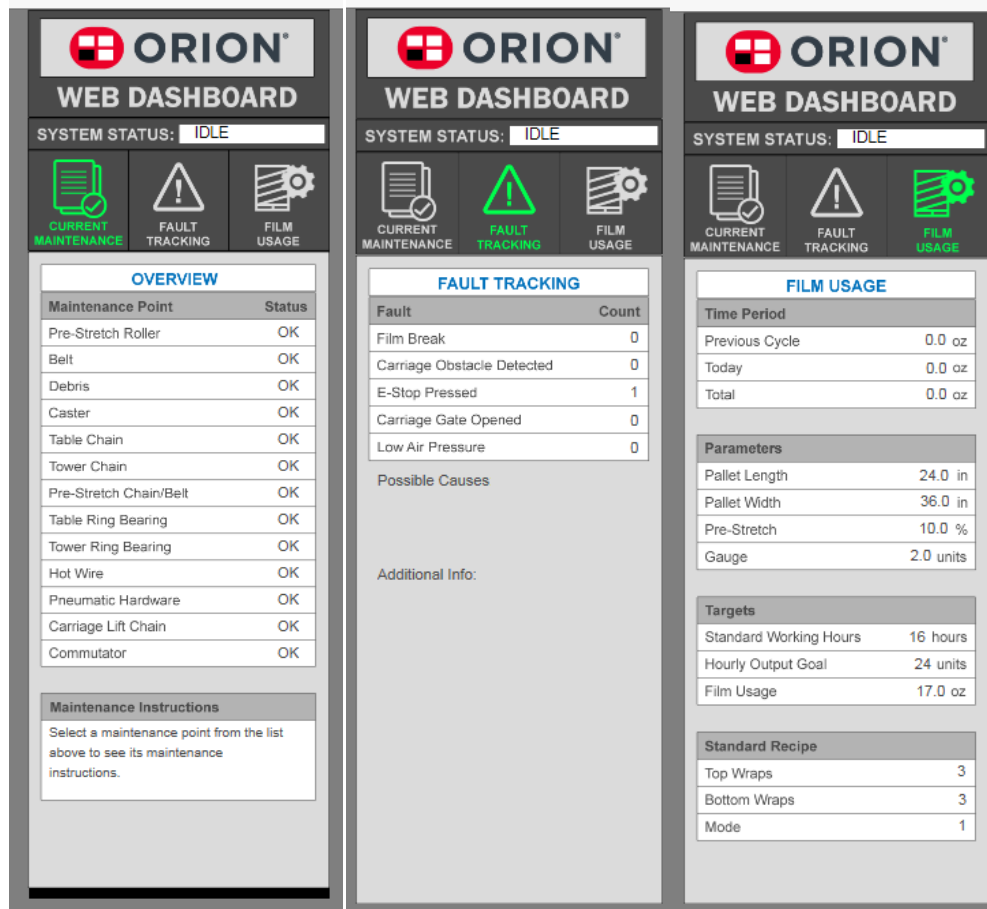


7. On the back of the HMI, connect an ethernet cord to the Eth IF2 connector. Route to your network router.
8. On your computer browser connected to the same network, enter the IP address you assigned to the flex machine then /dashboard.asp.
9. Example: 192.168.1.2/dashboard.asp

(Continued on Next Page)

10. Once the correct address is entered followed by /dashboard.asp, the dashboard will display.
11. This screen allows you to view the Status of your machine, the Production data, Recent Faults, and Current Recipe running.

**Figure 3 - 38**  
**Flex Dashboard**



## Information & Alarm Messages

The message and alarm displays are divided into two separate charts in this section.

- Message Displays - Various non-critical status messages
- Alarm Displays - Operation critical alarms/faults

### Message Displays

The messages in this section are the various non-critical status messages. These messages are for informational purposes. For critical alarms, see “Alarm Displays” on page 3 - 55.

**Note:** Not all messages in this list are applicable to your machine. The alarm messages on you machine may vary based on machine options.

**Table 3-35. The Information and Alarm Displays**

MESSAGE	DESCRIPTION	CORRECTION
<b>MACHINE SETUP REQUIRED - SELECT MACHINE OPTIONS</b>	The machine setup parameters are not set.	See “Machine Setup Screen” on page 3 - 31.
<b>APPLYING TOP WRAPS</b>	The machine is currently applying the top wraps.	This is for informational purposes only. No correction necessary.
<b>END OF FILM ROLL OR BROKEN FILM</b>	The film has broken or the roll ran out.	Re-load a new roll if out. If broken, monitor the film. Replace roll if problem persists. See troubleshooting chart for broken film troubleshooting tips.
<b>CYCLE ENDING</b>	The cycle is ending.	This is for informational purposes only. No correction necessary.
<b>CYCLE PAUSED</b>	The cycle is paused.	Resume, when ready. Press the resume button on the Run screen.
<b>E-STOP PRESSED</b>	The E-stop button is currently pressed.	Release the E-stop button to allow operation. Press Start to reset control power, then press and hold start for the amount of time set up in the parameters.

**Table 3-35. The Information and Alarm Displays (Continued)**

MESSAGE	DESCRIPTION	CORRECTION
<b>CARRIAGE GATE OPEN</b>	The carriage gate is currently open.	Close the carriage to allow operation. Check the interlock switch.
<b>HOMING MACHINE</b>	The machine is homing.	Allow the machine to home prior to starting.
<b>LOW AIR PRESSURE</b>	The machine pneumatic pressure is low.	Check the pneumatic supply. Ensure 80 PSI is available.
<b>PRESS START BUTTON TO RESET CONTROL POWER</b>	The machine is not reset.	Press Start to reset control power prior to starting.
<b>MOVING TO BOTTOM OF LOAD</b>	The carriage is moving to the bottom of the load.	This is for informational purposes only. No correction necessary.
<b>MOVING TO TOP OF LOAD</b>	The carriage is moving to the top of the load.	This is for informational purposes only. No correction necessary.
<b>CARRIAGE OBSTACLE DETECTED - CLEAR &amp; PRESS RESET</b>	The obstacle detection is tripped.	See “Carriage Obstacle Detect Error Recovery” on page 3 - 2.
<b>READY TO WRAP - PRESS &amp; HOLD START BUTTON</b>	The machine is reset and ready to run.	Press and hold the start button for the amount of time set in the parameters to start the machine.
<b>APPLYING REINFORCEMENT WRAPS</b>	Reinforce wraps are currently being applied.	Once the reinforce wraps are completed, the machine will continue its cycle.
<b>TOWER OBSTACLE DETECTED</b>	The tower has an obstruction.	Check for a mechanical bind. Clear the cause of the fault. Reset and restart, when ready.
<b>APPLYING BOTTOM WRAPS</b>	The bottom wraps are currently being applied.	This is for informational purposes only. No correction necessary.
<b>WRAP CYCLE IS COMPLETE</b>	The wrap cycle is now complete.	Remove the load, when ready.



**Table 3-35. The Information and Alarm Displays (Continued)**

MESSAGE	DESCRIPTION	CORRECTION
<b>CLAMPING &amp; CUTTING FILM</b>	The machine is now in the clamp and cut cycle.	This is for informational purposes only. No correction necessary.
<b>INITIALIZING</b>	The machine is initializing.	There is a brief initialization sequence once the machine is reset. Allow the machine to initialize prior to starting.
<b>LIGHT CURTAIN BLOCKED</b>	The light curtain is blocked (if equipped.)	Clear the obstruction from the light curtain to allow operation.
<b>SAFETY SYSTEM NOT READY</b>	The safety controller is not ready to run.	Allow the safety system to initialize prior to running.
<b>FAULTS EXIST</b>	Faults currently exist.	Correct the cause of the fault. Press reset to reset the fault condition once the cause is corrected.
<b>CARRIAGE MOVING UP TOO SLOWLY</b>	The carriage is moving upward too slowly.	Check for the cause of the carriage not moving correctly. Check the belt drive behind the back panel. Check for a jam or obstruction on the track.
<b>CARRIAGE MOVING DOWN TOO SLOWLY</b>	The carriage is moving downward too slowly.	Check for the cause of the carriage not moving correctly. Check the belt drive behind the back panel. Check for a jam or obstruction on the track.
<b>BRUSH AND CUTTER NOT HOME</b>	The brush and cutter are not home.	Cycle the brush and cutter. Check why the brush and cutter can't reach the home position.
<b>MULTISTRETCH VFD NOT READY</b>	The indicated VFD is not ready to run.	Check the fault code on the VFD display in the electrical cabinet. See VFD manual for fault code information.
<b>MAIN DRIVE VFD NOT READY</b>		
<b>CARRIAGE VFD NOT READY</b>		

**Table 3-35. The Information and Alarm Displays (Continued)**

MESSAGE	DESCRIPTION	CORRECTION
<b>DOWNLOADING VFD PARAMETERS - PLEASE WAIT</b>	The VFD parameters are transferring to the VFD's from the PLC.	Wait until the process is completed.
<b>X2X COMMUNICATION FAULT - PRESS E-STOP TO CLEAR FAULT</b>	There is an X2X communication fault, press and release the E-stop button to clear the fault.	Contact Orion Packaging if problem persists.
<b>RS485 COMMUNICATION FAULT - PRESS E-STOP TO CLEAR FAULT</b>	There is an RS485 communication fault, press and release the E-stop button to clear the fault.	Contact Orion Packaging if problem persists.
<b>MODIFYING MULTISTRETCH SETTINGS</b>	The stretch settings modification is in progress.	Allow the settings to complete prior to start-up.

## Alarm Displays

The messages in this section are the various critical status messages. For non-critical alarms, see “Message Displays” on page 3 - 51.

Correct the condition and press the Fault Reset button to clear the message and continue machine operation. A description of these messages appears on the following pages.

**Note:** Not all messages in this list are applicable to your machine. The alarm messages on you machine may vary based on machine options.

**Table 3-36. The Information and Alarm Displays**

MESSAGE	DESCRIPTION	CORRECTION
<b>NO CONTROL POWER</b>	Control Power is not present.	Press the Control Power reset button prior to starting the machine.
<b>CARRIAGE GATE OPEN DURING CYCLE</b>	The carriage gate opened during the cycle.	Check for the cause of the unlatch. Re-latch and restart, when ready.
<b>END OF ROLL OR BROKEN FILM</b>	The film has broken or the roll ran out.	Re-load a new roll if out. If broken, monitor the film. Replace roll if problem persists. See troubleshooting chart for broken film troubleshooting tips.
<b>CARRIAGE MOVING UP TOO SLOWLY</b>	The carriage is moving upward too slowly.	Check for the cause of the carriage not moving correctly. Check the belt drive behind the back panel. Check for a jam or obstruction on the track.
<b>CARRIAGE MOVING DOWN TOO SLOWLY</b>	The carriage is moving downward too slowly.	Check for the cause of the carriage not moving correctly. Check the belt drive behind the back panel. Check for a jam or obstruction on the track.
<b>CARRIAGE DOOR OPEN</b>	The carriage door is currently open.	Close the carriage door to allow operation.
<b>LOW AIR PRESSURE</b>	The machine pneumatic pressure is low.	Check the pneumatic supply. Ensure 80 PSI is available.
<b>BRUSH AND CUTTER NOT HOME</b>	The brush and cutter are not home.	Cycle the brush and cutter. Check why the brush and cutter can't reach the home position.

**Table 3-36. The Information and Alarm Displays (Continued)**

MESSAGE	DESCRIPTION	CORRECTION
<b>OBSTACLE DETECTED</b>	The tower has an obstruction.	Check for a mechanical bind. Clear the cause of the fault. Reset and restart, when ready.
<b>MULTISTRETCH VFD NOT READY</b>	The indicated VFD is not ready to run.	Check the fault code on the VFD display in the electrical cabinet. See VFD manual for fault code information.
<b>MAIN DRIVE VFD NOT READY</b>		
<b>CARRIAGE VFD NOT READY</b>		
<b>X2X COMMUNICATION ERROR</b>	There is an X2X communication fault, press and release the E-stop button to clear the fault.	Contact Orion Packaging if problem persists.
<b>RS485 COMMUNICATION ERROR</b>	There is an RS485 communication fault, press and release the E-stop button to clear the fault.	Contact Orion Packaging if problem persists.

Troubleshooting Contents

Troubleshooting .....4-1



## 4. Troubleshooting

### Troubleshooting

This troubleshooting chart details problems you may encounter with your Flex series stretchwrapper along with the cause and solution. If the problem(s) cannot be solved after consulting this section and/or appropriate sections of this manual, call Orion at (800) 333-6556.

**Table 4-1. Troubleshooting Chart**

PROBLEM	POSSIBLE CAUSE	SOLUTION
<b>Control Panel / Error Messaging - No Control Power / E-stop Is Flashing</b>	E-Stop circuit is activated. E-stop is depressed.	Perform E-Stop reset sequence. 1. Close the carriage and close guards if they exist on your machine. 2. Pull E-Stop to the OUT position. 3. Press Green Start button once to reset the machine. 4. Press and hold Green Start Button until the machine starts.
	Safety Photocells not aligned. Photocell alignment (RT models and Table machines with safety fencing) Photocell lights should change state when objects block, then unblock photocells.	Re-align photocells with their respective reflectors, then perform an E-Stop Reset.
	Wiring in the E-stop circuit is compromised. Perform continuity Check on all wiring in the e-stop circuit.	Refer to the electrical schematic for wiring layout and wire numbers.
	Components in the E-Stop circuit have failed. Test components individually including contact bodies.	Refer to the electrical schematic for wiring layout and wire numbers.
<b>Stored Values Revert To Zero Or Unusable Settings.</b>	High voltage spike or voltage brownout below 100 VAC has occurred. With a meter, observe voltage at the main power switch on the control panel during a wrap cycle.	1. Remove all household extension cords. 2. Move machine to a different power outlet. 3. Have an electrician verify site power supply.

**Table 4-1. Troubleshooting Chart (Continued)**

PROBLEM	POSSIBLE CAUSE	SOLUTION
<b>Turntable / Tower Rotation- Turntable / Tower Will Not Stop In The Correct Position. (Table Does Stop At End Of Cycle-but In Wrong Position</b>	Turntable end of cycle positioning counter value is set incorrectly. Observe the Turntable end of cycle positioning counter value on the HMI.	Refer to the factory default settings value list.
	Slow Down Position for Tower / Turntable Timer is adjusted too high. Observe the Slow Down Position for Tower /Turntable Timer value on the HMI.	Refer to the factory default settings value list.
	Table / Tower preset speeds are set incorrectly. The table / turntable is overhauling and the drive can not stop the load fast enough. Check the value of the SP-2-SP-3 and SP-4 parameters on the Table / Tower VFD. Ensure that they are set within correct values.	Refer to the factory default settings value list.
	Table / Tower deceleration value is set incorrectly. The table / turntable is overhauling and the drive can not stop the load fast enough. Check the value of the DEC parameter on the Table / Tower VFD. Ensure that it is set within the Orion factory default values.	Refer to the factory default settings value list.
	Component failure.	Check error message on the Table / Tower VFD display. Refer to the supplied VFD user manual for error message. Replace if needed.



**Table 4-1. Troubleshooting Chart (Continued)**

PROBLEM	POSSIBLE CAUSE	SOLUTION
<b>Turntable / Tower Will Not Stop In The Correct Position. (Table Does Not Stop Until E-stop Is Depressed Or Power Is Removed)</b>	Table Sprocket tooth count in the global setup screen is set incorrectly-for instance; a 96 tooth setting is chosen for a machine shipped with a 112 tooth sprocket or vice-versa.	Verify the machine type against the settings screen. Note: Standard E and D models are shipped with 96 tooth table sprockets, only A and HD (heavy duty) models are shipped with a 112 tooth sprocket. Refer to the Initial machine setup instructions to toggle the table tooth count settings. Reminder-password is required.
	Revo-logic™ sensor is mis-aligned with the table / tower driven sprocket.	Verify the gap setting between the Revo-logic™ sensor and the driven sprocket. Readjust if needed. Check the pulse count input on the PLC for an LED indication as each tooth passes in front of the Revo-logic™ sensor.
	Revo-logic™ sensor has failed.	Check for 24VDC at the sensor. Check for 24VDC Switching on the return wire to PLC at the sensor. No VDC Switching out? Replace sensor.
	Wiring in the Revo-logic™ sensor circuit has failed.	Run a continuity test on wiring from the sensor to the PLC and 24VDC supply rails. No continuity on any wire? Repair or replace wiring.
	True Home sensor has failed.	Check for 24VDC at the sensor. Check for 24VDC Switching on the return wire to PLC at the sensor. No VDC Switching out? Replace sensor.
	Wiring in the True Home sensor circuit has failed.	Run a continuity test on wiring from the sensor to the PLC and 24VDC supply rails. No continuity on any wire? Repair or replace wiring.
<b>Special Extended Mast, Split-base Or Any Models With The Mast Shipped Disconnected From The Base</b>	Revologic™ and True Home sensor wires crossed during final assembly on-site.	Wire numbers should match at the M12 quick disconnects. The connectors for both the Revologic™ and the True Home sensors can physically interchange. If the wire numbers do not match, Swap the M12 quick disconnect connectors located in the lower part of the tower.

**Table 4-1. Troubleshooting Chart (Continued)**

PROBLEM	POSSIBLE CAUSE	SOLUTION
<b>Turntable / Tower Rotates Inconsistently-(Table / Tower Turns With A Jerking Motion)</b>	Current Limiter in the rotation VFD is activating.	Check for a mechanical bind in the rotation mechanicals, such as: worn bearing(s) or casters, incorrectly tensioned chain, worn chain, alignment issues etc. Identify and repair or replace worn parts.
	VFD parameter settings are incorrect.	Review the parameter settings in the VFD. Refer to the supplied VFD Manual for procedure. Refer to the VFD manual and the Orion parameter settings sheet supplied with the machine for maximum frequency settings.
	Machine's supply voltage is too low.	Check AC voltage (at the On-Off switch terminals) while the machine is running under load. If voltage drops below 115, the supply is not strong enough to run the machine correctly. Contact plant electrician. Do not use household extension cords with the machine.
	Loose connections in the rotation circuit.	Remove power from machine. Check for loose connections in the rotation circuit such as; Primary supply to the rotation VFD, Secondary supply from the VFD to the drive motor and all connections in between. Re-seat all loose connections. Tighten connections correctly.
	Motor Failure.	Perform motor test per motor manufacturer's recommendations. Replace motor as needed.
	Reducer Failure.	Remove rotation reducer-separate motor from reducer. Rotate input shaft and check for binding. Replace reducer as needed.

**Table 4-1. Troubleshooting Chart (Continued)**

PROBLEM	POSSIBLE CAUSE	SOLUTION
<b>Turntable / Tower Will Not Rotate</b>	No control Power / E-Stop Condition.	E-Stop button is Flashing or Green Start button is not illuminated. Perform E-Stop Reset (pull E-Stop button to the out position then press the Green Start button so that it is Illuminated. Press Cycle reset on the Touchscreen.
	Machine is in Cycle Pause.	Observe the Cycle Pause Icon on the Run Screen. If it is illuminated, the machine is in a Pause state. Press Resume to resume wrapping.
	VFD parameter settings are incorrect.	Review the parameter settings in the VFD. Refer to the supplied VFD Manual for procedure. Refer to the VFD manual and the Orion parameter settings sheet supplied with the machine for maximum frequency settings.
	Blown Fuse.	Locate Table / Tower rotation control fuse. Remove fuse and check continuity. Bad Fuse? Replace with correct type.
	VFD Error.	Check the status of the table / tower motor controller (VFD) for error message. Refer to the VFD manual supplied with the machine for error messaging solutions.
	Open circuit to the motor.	Check wire continuity from VFD to Motor. Repair or replace open wiring.
	Motor Failure.	Perform motor test per motor manufacturer's recommendations. Replace Motor as needed.

**Table 4-1. Troubleshooting Chart (Continued)**

PROBLEM	POSSIBLE CAUSE	SOLUTION
<b>Carriage Lift (Up &amp; Down) Carriage Will Not Move Up Or Down (In Either Manual Mode Or During An Auto Wrap Cycle)</b>	Carriage Speeds set below 5%.	Check the numerical value of the carriage up and down speeds on the touchscreen. Password may be required depending on the Security Settings. Increase the carriage up and down speeds on the touchscreen to above 5%.
	Carriage Travel limit strikers set improperly.	Check the physical positions of the travel limit strikers. 1. Set the Up Travel limit striker to the highest wrapping requirement position within the machine's capability or a jam may occur. 2. Position the Bottom travel striker to the lowest wrapping requirement level within the machine's capability or a false Belt Error may occur.
	Lift Belt Error (Visible obstruction) has occurred.	Check for a physical obstruction in the carriage toward travel path and Lift Belt Error shown on the touchscreen. If there is an actual obstruction, refer to the "Carriage Obstacle Detect Error Recovery" inset in your manual.
	VFD parameter settings are incorrect.	Review the parameter settings in the VFD. Refer to the supplied VFD Manual for procedure. Refer to the VFD manual and the Orion parameter settings sheet supplied with the machine for maximum frequency settings.

**Table 4-1. Troubleshooting Chart (Continued)**

PROBLEM	POSSIBLE CAUSE	SOLUTION
<b>Carriage Lift (Up &amp; Down) Carriage Will Not Move Up Or Down (In Either Manual Mode Or During An Auto Wrap Cycle)</b>	A False (No visible obstruction) lift belt error has occurred.	Remove upper-rear access panel on the back of the mast. Observe the position of the lift belt roller switch at the top, inside of the mast. The belt should be between the metal frame and the switch's roller lever. The lever roller should be activated. If the belt is placed incorrectly, re-set belt so that it is between the frame and the switch's lever roller. The switch may need to be re-positioned as to not give a false signal.
	Current Limiter in the carriage lift VFD is activating.	Check for a mechanical bind in the carriage lift mechanicals, such as, worn belt wheel bearings incorrectly aligned belt or carriage safety cam-locks. Identify and repair or replace worn parts.
	Maximum speed setting on the VFD is incorrect.	Review the maximum frequency parameter settings in the VFD. Refer to the supplied VFD Manual for procedure. Refer to the VFD manual and the Orion parameter settings sheet supplied with the machine for maximum frequency settings.
	Machine's supply voltage is too low.	Check AC voltage (at the On-Off switch terminals) while the machine is running under load. If voltage drops below 115, the supply is not strong enough to run the machine correctly. Contact plant electrician. Do not use household extension cords with the machine.
	Loose connections in the carriage lift circuit.	Remove power from machine. Check for loose connections in the carriage lift circuit such as; Primary supply to the Lift VFD, Secondary supply from the VFD to the drive motor and all connections in between. Re-seat all loose connections. Tighten connections correctly.

**Table 4-1. Troubleshooting Chart (Continued)**

PROBLEM	POSSIBLE CAUSE	SOLUTION
<b>Carriage Lift (Up &amp; Down) Carriage Will Not Move Up Or Down (In Either Manual Mode Or During An Auto Wrap Cycle)</b>	Blown Fuse.	Locate carriage lift control fuse. Remove fuse and check continuity. Bad Fuse? Replace with correct type.
	Motor failure.	Perform motor test per motor manufacturer's recommendation. Replace Motor as needed.
	Reducer failure.	Remove Carriage Lift reducer-separate motor from reducer. Rotate input shaft and check for binding Replace reducer as needed.
<b>Carriage Will Not Move Up Or Down (In Auto Wrap Cycle Only-but Works Fine In Manual Mode).</b>	Auto-height photocell positioned incorrectly.	Check the position of the Auto-height photocell. Make sure it is aimed at the load. If the load is too short for the photocell to see, the carriage will not move up-this is normal. Re-Aim the photocell correctly.
	Auto-height sensor has failed.	Check for 24VDC at the sensor. Check for 24VDC switching on the return wire to PLC at the sensor. No VDC Switching out at the sensor? Replace sensor.
	Wiring in the Auto-height sensor circuit has failed.	Run a continuity test on wiring from the sensor to the PLC and 24VDC supply rails. No continuity on any wire?= repair or replace wiring.

**Table 4-1. Troubleshooting Chart (Continued)**

PROBLEM	POSSIBLE CAUSE	SOLUTION
<b>Carriage Is Jammed At The Top Of The Mast. (Carriage Will Not Move Up Or Down)</b>	Carriage bottom travel switch did not activate correctly, possibly sticking.	Belt is tangled around drum. Belt is wrapped backwards or twisted. Check switch by manually activating (wiggling) the roller tip. If the switch does not activate and release it's input on the PLC correctly, replace the switch. The belt will need to be removed and re-wound correctly. The carriage will need to be brought down manually. Refer to the "Carriage Obstacle Detect Error Recovery" inset in your manual.
	Carriage bottom travel striker is set too low for switch to activate properly.	Belt is tangled around drum. Belt is wrapped backwards or twisted. Raise the bottom limit striker so that the carriage travel switch activates it's PLC input before the carriage physically hits the machine's framework. The belt will need to be removed and re-wound correctly. The carriage will need to be brought down manually. Refer to the "Carriage Obstacle Detect Error Recovery" inset in your manual.
<b>Film Feed / Stretch Functions No Power Feed</b>	E-Stop circuit is activated. E-stop is depressed.	Perform E-Stop reset sequence. 1. Close the carriage and close guards if they exist on your machine. 2. Pull E-Stop to the OUT position. 3. Press Green Start button once to reset the machine. 4. Press and hold Green Start Button until the machine starts.
	Film is threaded incorrectly.	Compare film with threading diagram on top of carriage. Re-thread film carriage.
	VFD parameter settings are incorrect .	Review the parameter settings in the VFD. Refer to the supplied VFD Manual for procedure. Refer to the VFD manual and the Orion parameter settings sheet supplied with the machine for maximum frequency settings.

**Table 4-1. Troubleshooting Chart (Continued)**

PROBLEM	POSSIBLE CAUSE	SOLUTION
<b>Film Feed / Stretch Functions No Power Feed</b>	Zero or Gain settings for the hall effect (Film Feed Trigger) are incorrect.	Observe the feedback value of the hall effect located on the touchscreen. Re-set the ZERO and GAIN values according to the film feed setup instructions in the manual. ZERO setting should be a value of at least ten above the hall effect feedback value to operate properly.
	Maximum speed setting on the VFD is incorrect.	Review the maximum frequency parameter settings in the VFD. Refer to the supplied VFD Manual for procedure. Refer to the VFD manual and the Orion parameter settings sheet supplied with the machine for maximum frequency settings.
	hall effect device is positioned incorrectly.	Check to make sure hall effect device is not touching the dancer bar cam. Adjust the hall effect-to-cam gap is correct... approx 16th of an inch gap.
	Dancer bar cam is positioned incorrectly.	Make sure the cam rotates in such a way as to create a gap between the hall effect device and the cam itself. Adjust the cam correctly.
	hall effect sensor has failed.	Check for 24VDC at the sensor. Check for variable 24VDC on the return wire to PLC at the sensor. No variable VDC out? Replace sensor.
	Open circuit from the hall effect device to the analog input card.	Check wire continuity from hall effect device to the analog input card. Repair or replace open wiring.
	Analog I.O. card has failed.	Check the hall effect feedback value on the MIB screen. If the hall effect value increases with dancer movement, but the analog I.O. card does not fluctuate voltage out, then the analog I.O. card has failed. Replace analog I.O. card.
	Open circuit from the PLC analog card to the VFD analog input.	Check wire continuity from the PLC analog card output to the VFD analog input. Repair or replace open wiring.
	Open circuit from the stretch VFD to the film feed motor	Check wire continuity from the stretch VFD outputs to the film feed motor. Repair or replace open wiring.



**Table 4-1. Troubleshooting Chart (Continued)**

PROBLEM	POSSIBLE CAUSE	SOLUTION
<b>Film Feed / Stretch Functions No Power Feed</b>	Motor failure.	Perform motor test per motor manufacturer's recommendations. Replace Motor as needed.
<b>Film Feed Runs Or Creeps Continuously</b>	MIB values at the touchscreen are out of calibration.	Observe the feedback value of the hall effect located on the touchscreen. Re-set the ZERO and GAIN values according to the film feed setup instructions in the manual. ZERO setting should be a value of at least ten above the hall effect feedback value to operate properly.
	Hall effect device is positioned incorrectly.	Check to make sure hall effect device is not touching the dancer bar cam. Adjust the hall effect-to-cam gap is correct... approx 16th of an inch gap.
	Dancer bar cam is positioned incorrectly.	Make sure the cam rotates in such a way as to create a gap between the hall effect device and the cam itself. Adjust the cam correctly.
	Hall effect device has failed	Perform tests mentioned above. If this does not resolve the issue, replace the hall effect device.
	Minimum speed setting on the VFD is incorrect.	Review the minimum frequency parameter settings in the VFD. Refer to the supplied VFD Manual for procedure. Refer to the VFD manual and the Orion parameter settings sheet supplied with the machine for minimum frequency settings.
<b>Film Breakage Issues Film Breaks Inside The Carriage (Usually Between The Rubber Stretch Rollers)</b>	Incorrect gauge / type film is being used for the application.	Review the film's stretch capability. The film used should be able to effectively stretch 280% at ambient temperatures. Remove any film that does not comply with the machine's requirements or, change the stretch sprocket on the machine to stretch below the film's fatigue value.
	Film is damaged.	Observe the edges and sides of the roll for damage from handling. Replace improper film with film in good condition.

**Table 4-1. Troubleshooting Chart (Continued)**

PROBLEM	POSSIBLE CAUSE	SOLUTION
<b>Film Breakage Issues Film Breaks Inside The Carriage (Usually Between The Rubber Stretch Rollers)</b>	Film is wound incorrectly.	Film may be wound incorrectly from the manufacturer. Look for heavy, raised stripes along the feed axis of the film. This is known as "gauge banding". Replace improper film with film in good condition.
	Film core is damaged or incorrectly sized.	The film core should fit the machine's film mandrels. Cores that are too small or damaged can cause the film to not rest in the correct position. Replace improper film with film in good condition.
	Film roll sets too low in relation to the feed rollers.	Look for film traveling under the bottom edge of the trailing rubber roller. Adjust the bottom film mandrel to allow the bottom edge of the film to run correctly on the trailing rubber roller.
	Film mandrel drag or resistance is not allowing the film to unwind properly.	Look for excessive wear under the bottom mandrel. Lubricate the bottom and center of the mandrel. Replace worn parts.
	Film carriage aluminum "pressure" rollers are mis-aligned with the rubber rollers. Film is slipping across the rollers.	With the film removed from the carriage, look for an inconsistent gap between the aluminum and rubber rollers-top and bottom on both sides of the rubber rollers. Using the socket head cap screws, re-align the aluminum rollers to the rubber rollers. Set the gap between the aluminum and rubber rollers so that there is only a slight rotational resistance between the rollers.
	Aluminum pressure rollers are damaged.	Carefully review the aluminum rollers for cuts or nicks. Any raised spots can damage the film and propagate a tear. Polish the affected areas with a purple scotch brite pad or fine abrasive until the protrusions are leveled or replace with a new part.

**Table 4-1. Troubleshooting Chart (Continued)**

PROBLEM	POSSIBLE CAUSE	SOLUTION
<b>Film Breakage Issues Film Breaks Inside The Carriage (Usually Between The Rubber Stretch Rollers)</b>	Rubber rollers are damaged	Carefully review the rubber rollers for cuts or nicks. Any raised spots can damage the film and propagate a tear. Raised spots can be carefully shaved or sanded smooth but if the surface showing craters or holes so that the surface is not level, then the roller needs to be replaced.
<b>Film Is Breaking Between The Last Aluminum Roller And The Load</b>	Film tension is set too high.	Film runs through the carriage properly and there are no sharp corners on the load, but the film still breaks. Lower the film tension value at the touch-screen.
	Zero or Gain settings for the hall effect (Film Feed Trigger) are incorrect.	Observe the feedback value of the hall effect located on the touchscreen. Re-set the ZERO and GAIN values according to the film feed setup instructions in the manual. ZERO setting should be a value of at least ten above the hall effect feedback value to operate properly.
	Tension spring is too heavy for the application.	Film carriage appears to be calibrated correctly and film appears to be correct. Film still breaks or damages a light load with the film tension set at values below 10%. Replace the standard tension spring with the light duty tension spring (supplied with the machine).
	Film roll sets too low in relation to the feed rollers.	Look for film traveling under the bottom edge of the trailing rubber roller. Adjust the bottom film mandrel to allow the bottom edge of the film to run correctly on the trailing rubber roller.
	Sharp edges are cutting the film	Observe the load. See if the film break starts at any one sharp edge. Options are: 1. Correct the load if possible. 2. Reduce the film tension at the touch-screen. 3. Change film type used. 4. Reduce the prestretch ratio.

**Table 4-1. Troubleshooting Chart (Continued)**

PROBLEM	POSSIBLE CAUSE	SOLUTION
<b>Film Is Breaking Between The Last Aluminum Roller And The Load</b>	Pallet greatly overhangs the load.	Observe the load. See if the film break starts at the corners of the pallet. Options are: 1. Reduce the film tension at the touch-screen. 2. Reduce the stretch ratio. 3. Do not wrap the pallet with the load. Raise the bottom position striker.
	Film is damaged.	Observe the edges and sides of the roll for damage from handling. Replace improper film with film in good condition.
	Film is wound incorrectly.	Film may be wound incorrectly from the manufacturer. Look for heavy, raised stripes along the feed axis of the film. This is known as "gauge banding". Replace improper film with film in good condition.
	Stretch chain and / or belt geometry is incorrect. Out of alignment components can cause feed drag.	Remove film carriage cover. Look for loose chain and / or belt. Look for the belt pulleys and the chain sprockets to be in correct alignment. Adjust as needed by repositioning the combination sprocket-pulley.
	Intermittent break in the cabling between the carriage and the control panel.	Observe the film feed during a cycle. If the film only breaks when the carriage is in a certain spot in it's travel, then continuity is suspect. Perform a continuity check on all wiring pertaining to the carriage while jogging the carriage up and down. If a break in continuity occurs, repair or replace the cable.

**Table 4-1. Troubleshooting Chart (Continued)**

PROBLEM	POSSIBLE CAUSE	SOLUTION
<b>"A" Model Specific Issues Film Clamp Not Operating Properly. (Opening And Closing Inconsistently)</b>	Clamp close delay timer at the touchscreen is incorrect for the application.	Look for the clamp to close smoothly, but at the wrong time. Observe the factory preset value on the settings screen. Re-adjust the clamp close delay timer as needed.
	Air pressure to the machine is too low.	Observe the pressure gauge at the pressure regulator behind the lower rear access panel. Air supply to the machine should be 80 PSI @ 3CFM.
	Air cylinder flow controls are set incorrectly.	If the regulator shows correct pressure, the flow controls are suspect. Check the flow controls by manually activating the clamp jog function on the touchscreen. Adjust the flow controls on the clamp cylinders so that they operate smoothly.
	Air lines are pinched or obstructed.	observe all 1/4 inch polyflow tubing. Remove any obstruction. Correct any pinched lines.
	Debris or condensation is in the air lines.	Purge the air filter / regulator. If water appears, then condensation is in the air lines. Correct the water issue, then purge the air lines by manually jogging the clamp until no water remains.
	Break in the wiring to the clamp solenoid.	There is DC voltage at the clamp PLC output, but no voltage at the clamp solenoids. Locate and repair break in the signal wiring between the PLC and solenoids.
	Clamp solenoids are defective	There is DC voltage at the clamp solenoids but the solenoids do not activate. Replace the clamp solenoids.
	Dual air passage is leaking.	Rotate the table manually with a load positioned on the table. Listen for any air leaks as the table rotates. If leakage is suspect, replace dual air passage.

**Table 4-1. Troubleshooting Chart (Continued)**

PROBLEM	POSSIBLE CAUSE	SOLUTION
<b>Film Cutter/ Brush Arm Not Operating Properly</b>	Brush extend timer at the touch-screen is incorrect for the application.	Look for the arm to activate smoothly, but at the wrong time. Observe the factory preset value on the settings screen. Re-adjust the brush extend timer as needed.
	Air pressure to the machine is too low.	Observe the pressure gauge at the pressure regulator behind the lower rear access panel. Air supply to the machine should be 80 PSI @ 3CFM.
	Air cylinder flow controls are set incorrectly.	If the regulator shows correct pressure, the flow controls are suspect. Check the flow controls by manually activation of the cutter jog function on the touchscreen. Adjust the flow controls on the clamp cylinders so that they operate smoothly.
	Air lines are pinched or obstructed.	observe all 1/4 inch polyflow tubing. Remove any obstruction. Correct any pinched lines.
	Debris or condensation is in the air lines.	Purge the air filter / regulator. If water appears, then condensation is in the air lines. Correct the water issue, then purge the air lines by manually jogging the cutter/ brush until no water remains.
	Break in the wiring to the cutter solenoid.	There is DC voltage at the cutter PLC output, but no voltage at the cutter/ brush solenoid. Locate and repair break in the signal wiring between the PLC and solenoids.
	Cutter / brush solenoids are defective	There is DC voltage at the cutter / brush solenoids but the solenoids do not activate. Replace the cutter/ brush solenoids.

**Table 4-1. Troubleshooting Chart (Continued)**

PROBLEM	POSSIBLE CAUSE	SOLUTION
<b>Film Cutter Not Cutting Film</b>	Load not positioned properly.	Look for underhung loads, or loads that are not centered on the table or in the proper wrap zone (RT only). The rear side of the load must be in line with the pallet stop for the clamp, brush and cutter to work properly. Re-center the load to the proper position on the table (or wrap zone on RT machines).
	Brush extend timer at the touch-screen is incorrect for the application.	Look for the arm to activate smoothly, but at the wrong time. Observe the factory preset value on the settings screen. Re-adjust the brush extend timer as needed.
	Cutter wire is loose.	Check for wavy or bent cutter wire. The wire expands as it is heated. If the wire is not straight and under tension, then it will not be in the correct position to cut properly. If wire is loose or bent, repair or replace the wire.
	Blown Fuse.	Locate hot wire control fuse. Remove fuse and check continuity. Bad Fuse? Replace with correct type.





# Maintenance Contents

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## 5. Maintenance

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

### Motor Maintenance

The drive motors require little maintenance. Simply blow out debris with compressed air on a regular basis.

### 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:

**Table 5-1. Recommended Reducer Lubricants**

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

**Note:** For most applications, Mobil One Synthetic 75/90 gear lube is a preferred lubricant.

## 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.

**Note:** 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 stretch chain, wipe it with an oily cloth once a service quarter.

When machine is working in a dusty and damp environment, it may be necessary to repeat the cleaning operation more often.

Regarding chain lubricants please use the most common chain lubricants on the market. With time, the chain will tend to stretch.

The tower is equipped with automatic chain tensioner and does not need any adjustment.

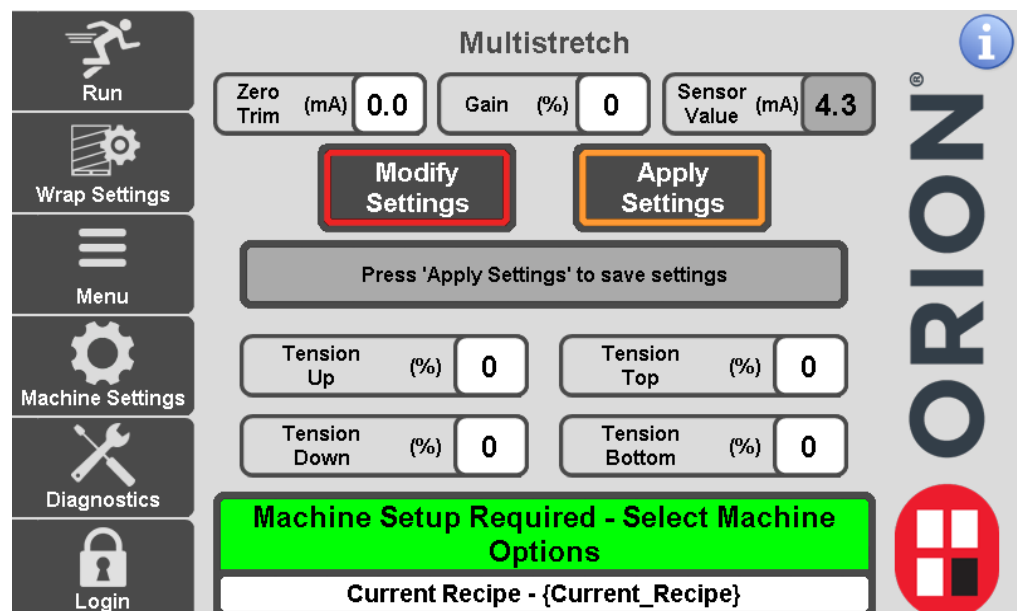
**Note:** First chain tension inspection must be done after the first two weeks of machine usage.

## Proximity Sensor Adjustment

Occasionally the Feed Back Proximity Sensor may need some adjustment. The position of the feed back proximity sensor against the cam is shown in Figure 5 - 1.

1. Power down machine.
2. Remove the carriage cover.
3. Unbolt the two nuts holding the proximity switch.
4. Turn the Proximity sensor to create the gap between the cam and the front side of proximity sensor about 1/8.”
5. Tighten on the nuts securing the Proximity Sensor.
6. Put the cover back on.
7. Power up machine.
8. To adjust the multistretch settings, you must be logged in. Press the login button in the bottom left corner of the screen
9. Enter the password then press the X to close the keypad.
10. Press the Machine Settings button.
11. Press the Multistretch button to go to the Multistretch Screen.
12. Press the Modify Settings button.
13. Adjust the Zero Trim to .5 mA over the current Hall Effect Sensor reading shown on the screen.

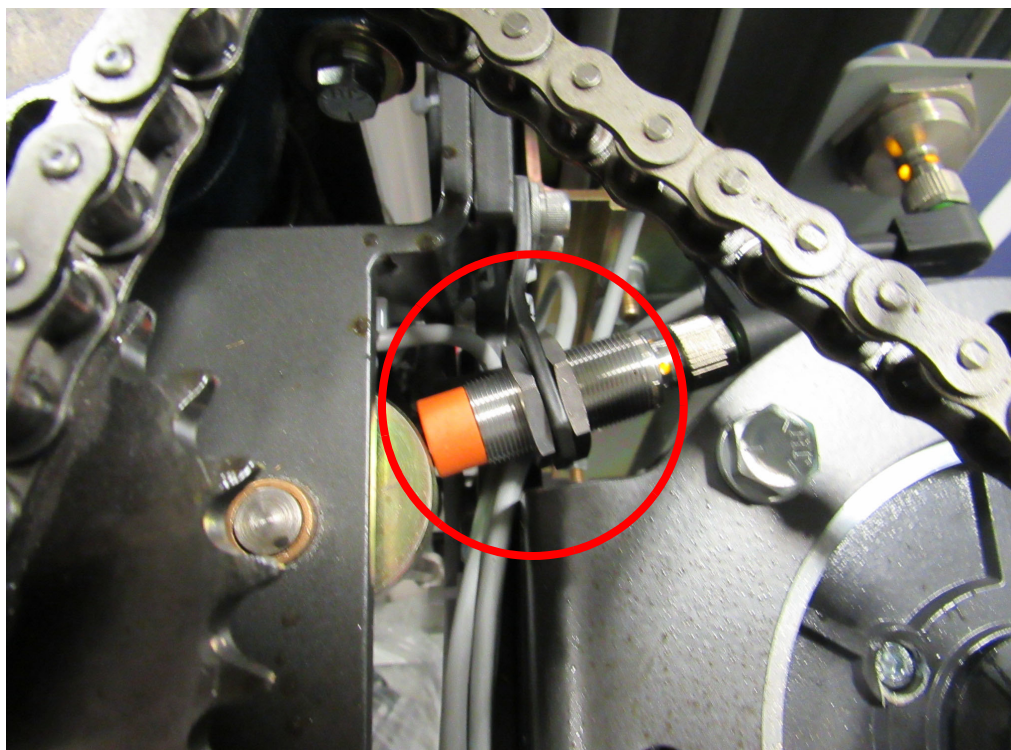
**Figure 5 - 1**  
**The Multistretch**  
**Screen**



(Continued on Next Page)

14. If not satisfied repeat the procedure.

**Figure 5 - 2**  
**Proximity Sensor**  
**Adjustment**



## Cleaning The Stretch Rollers

The film carriage requires the most attention when cleaning. The film carriage requires regular cleaning even if there are no product spills into the carriage area. Absolutely DO NOT use wash down methods on the film carriage.

- As the film goes through the rollers, a static charge develops from the film and pulls air borne dust and contaminants into the rollers. The glue that is impregnated to the film, called Tackifier, traps these contaminants to the rollers. Finally, the aluminum pressure rollers on the threading gate press the debris into the rollers causing the rubber rollers to glaze.
- If the rollers become glazed, the film may slip, causing film shear, thus causing film payout to be inconsistent or cause the film to tear regularly. This is completely normal under continued use and occurs on every stretch wrapper made no matter who the manufacturer is.
- The rubber rollers are recommended to be cleaned at every 2000 hours of running. Do not clean the rollers more than once a month unless special circumstances demand. This can cause the rollers to dry out. The cleaning requires only a stiff nylon bristle brush, rubbing alcohol (only)\*, and compressed air. The procedure is as follows.

**CAUTION** This procedure should only be performed by qualified service personnel.

1. Raise carriage to chest height.
2. Disconnect power from the machine.
3. Remove the film from the carriage.
4. Open the threading gate.
5. With the brush wet with rubbing alcohol, lightly scrub both rubber rollers while rotating them. The goal is to just get any debris out of the rollers.

**Note:** Rubbing alcohol is recommended because it is light enough to penetrate the rubber and it evaporates quickly.

6. After the entire rollers' surface has been cleaned, apply compressed air to the rollers to dry quickly.
7. Re-apply power.
8. Re-load film as discussed earlier.

## Preventative Maintenance Schedule

### PM Intervals

PM Intervals are based on an average usage of a 16 hour production day.

**Table 5-2. PM Frequency**

FREQUENCY	PERIOD	DESCRIPTION
12	LPH	(Hour)
96	LPS	(Shift)
192	LPD	(Day)
5760	LPM	(Month)
17,280	LP3M	(3Months)
34,560	LP6M	(6Months)

All general information about machine maintenance is based on normal machine working conditions: indoor, moderate dust and low moisture environment, and maximum rotation of 15 RPM. They should be regarded as guidelines, reviewed and corrected according to requirements of actual use and conditions.

## All H&L Standard Series

### 5,760 Loads or one month

- Inspect rubber stretch rollers. Clean as needed per instructions in manual.
- Inspect belt condition. Adjust as needed.

### 17,280 Loads or three months.

- Inspect under turntable. Clean debris as needed.
- Inspect turntable support casters for good condition.
- Inspect turntable chain. Apply a light coating of lubricant per instructions in manual.
- Inspect prestretch chain and belt. Tension as needed. Apply a light coating of lubricant per instructions in manual.
- Inspect carriage door spur sprockets.



## All H&L Heavy Duty (Ring Bearing) Series

### 5,760 Loads Or One Month

- Inspect rubber stretch rollers. Clean as needed per instructions in manual.
- Inspect belt condition. Adjust as needed.

### 17,280 Loads or three months.

- Inspect under turntable. Clean debris as needed.
- Inspect turntable support casters for good condition.
- Inspect turntable chain. Apply a light coating of lubricant per instructions in manual.
- Inspect prestretch chain and belt. Tension as needed. Apply a light coating of lubricant per instructions in this manual.
- Inspect carriage door spur sprockets.

### 34,560 Loads or 6 months.

- Lubricate ring bearing per instructions below.

### Ring Bearing Maintenance (If Applicable)

The ring bearing should be re-lubricated internally and externally.

Internally: Locate the grease zerk located directly on the ring bearing. Pump one full shot of grease into the zerk every six months. This should be plenty of lubrication for most applications. Pumping too much grease into the ring bearing can destroy the ring bearing by dislocating the rubber grease seal.

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.

**Table 5-3. Recommended Ring Bearing Lubricants**

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

**Table 5-3. Recommended Ring Bearing Lubricants**

MANUFACTURER	LUBRICANT
Valvoline	LB-2

## HPA LPA Series

### 5,760 Loads or one month

- Inspect rubber stretch rollers. Clean as needed per instructions in manual.
- Inspect belt condition. Adjust as needed.

### 17,280 Loads or three months.

- Inspect under turntable. Clean debris as needed.
- Inspect turntable support casters for good condition.
- Inspect turntable chain. Apply a light coating of lubricant per instructions in manual.
- Inspect prestretch chain and belt. Tension as needed. Apply a light coating of lubricant per instructions in manual.
- Check the cutter wire for excessive buildup. Replace if kinked or bent.
- Inspect the pneumatic hardware. Adjust as needed.
- Inspect carriage door spur sprockets.

### 34,560 Loads or 6 months.

- Lubricate ring bearing
- Inspect carriage lift chain. Tension and lubricate per instructions in manual.
- Inspect commutator assembly. Blow out debris per instructions in the manual.

## RTD Series

### @ 5760 Loads or one month

- Inspect rubber stretch rollers. Clean as needed per instructions in manual.
- Inspect belt condition. Adjust as needed.

### @ 17, 280 Loads or three months.

- Inspect tower drive chain. Apply a light coating of lubricant per instructions in manual.
- Inspect prestretch chain and belt. Tension as needed. Apply a light coating of lubricant per instructions in manual.
- Inspect the pneumatic hardware. Adjust as needed.
- Inspect carriage door spur sprockets.

### @ 34, 560 Loads or 6 months.

- Lubricate ring bearing per instructions in manual.
- Inspect carriage lift chain. Tension and lubricate per instructions in manual.
- Inspect commutator assembly. Blow out debris per instructions in the manual.

## RTA Series

### 5760 Loads or one month

- Inspect rubber stretch rollers. Clean as needed per instructions in manual.
- Inspect belt condition. Adjust as needed.

### 17, 280 Loads or three months.

- Inspect tower drive chain. Apply a light coating of lubricant per instructions in manual.
- Check the cutter wire for excessive buildup. Replace if kinked or bent.
- Inspect prestretch chain and belt. Tension as needed. Apply a light coating of lubricant per Instructions in this manual.
- Inspect the pneumatic hardware. Adjust as needed.
- Inspect carriage door spur sprockets.

### 34, 560 Loads or 6 months.

- Lubricate ring bearing per instructions in manual.
- Inspect carriage lift chain. Tension and lubricate per instructions in manual.
- Inspect commutator assembly. Blow out debris per instructions in this manual.



# Electrical Prints and Mechanical Drawings

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Mechanical Drawings . . . . .	6-2



## **6. Electrical Prints and Mechanical Drawings**

### **Electrical Prints**

# Mechanical Drawings

Download the mechanical drawings for your particular model on the Orion Webpage.  
<https://www.orionpackaging.com/products/service-manuals/>