

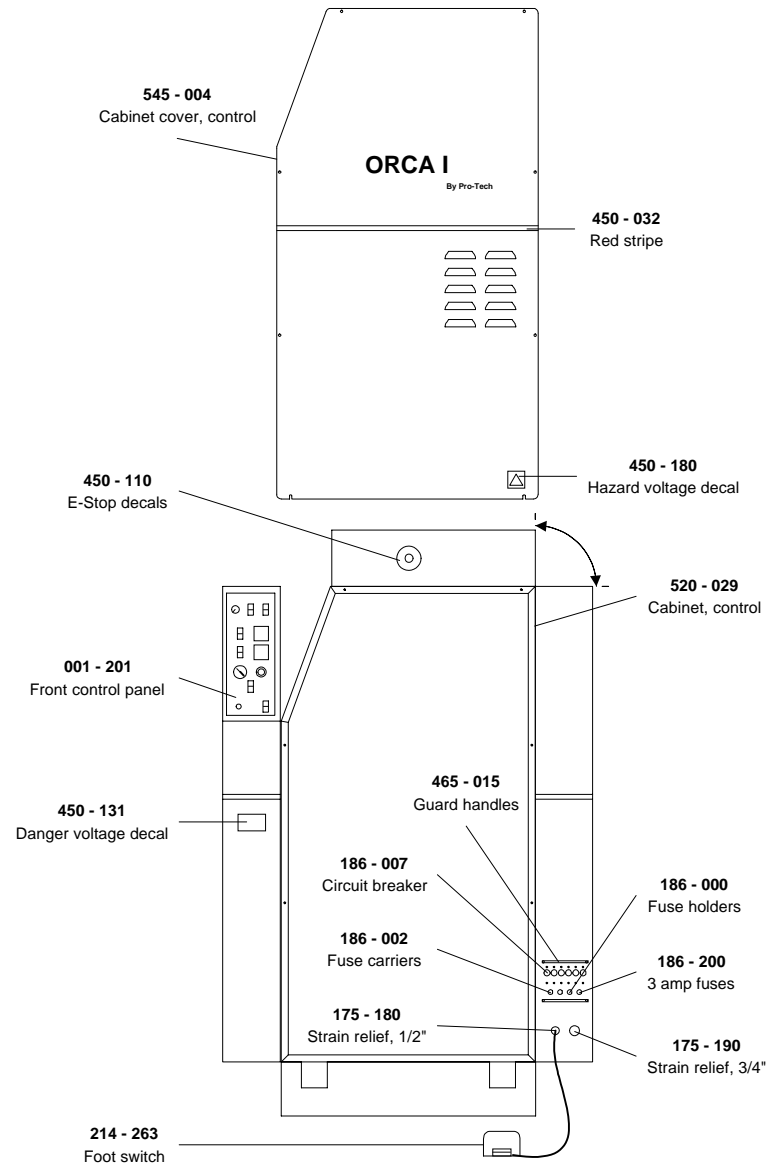
*Orca I SAE*  
*Illustrated Parts Booklet*  
*( 000 - 036 )*

*Available Options ;*

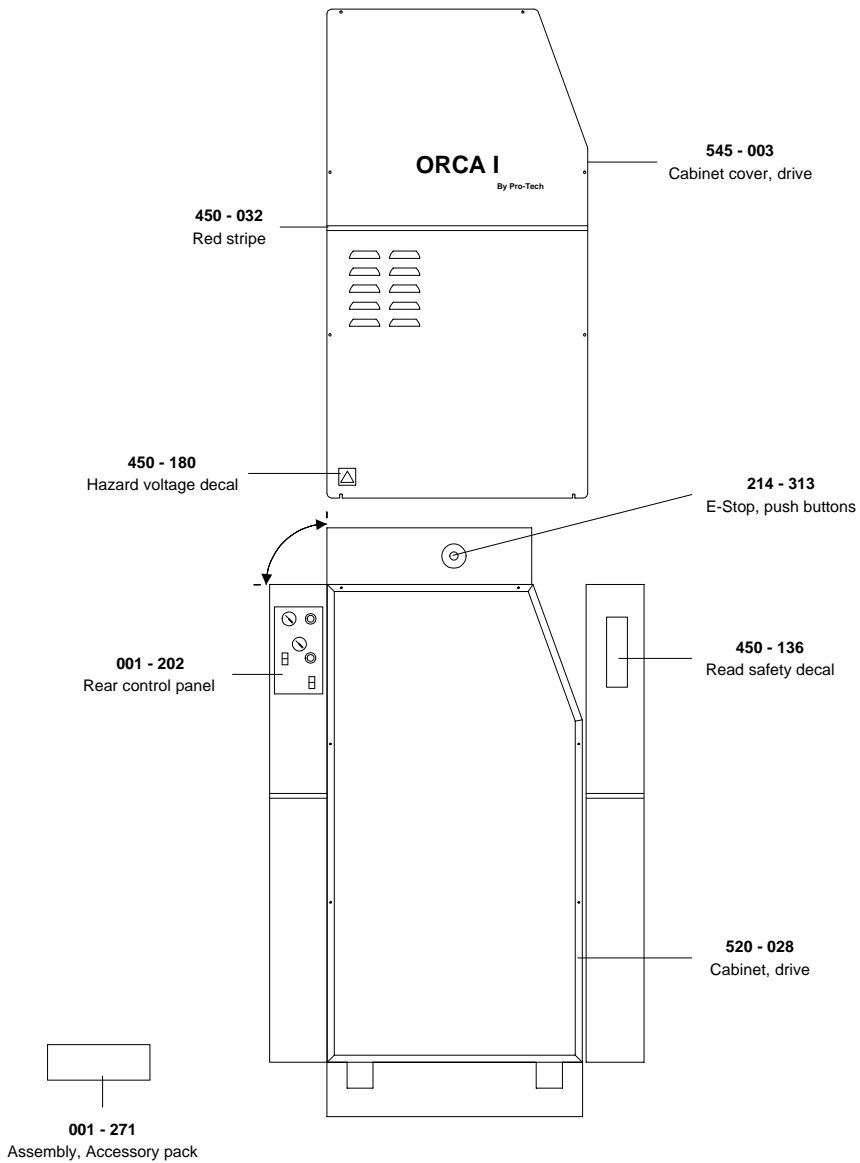
*001 - 299 ( Infeed slitters )*

*001 - 345 ( Outfeed table )*

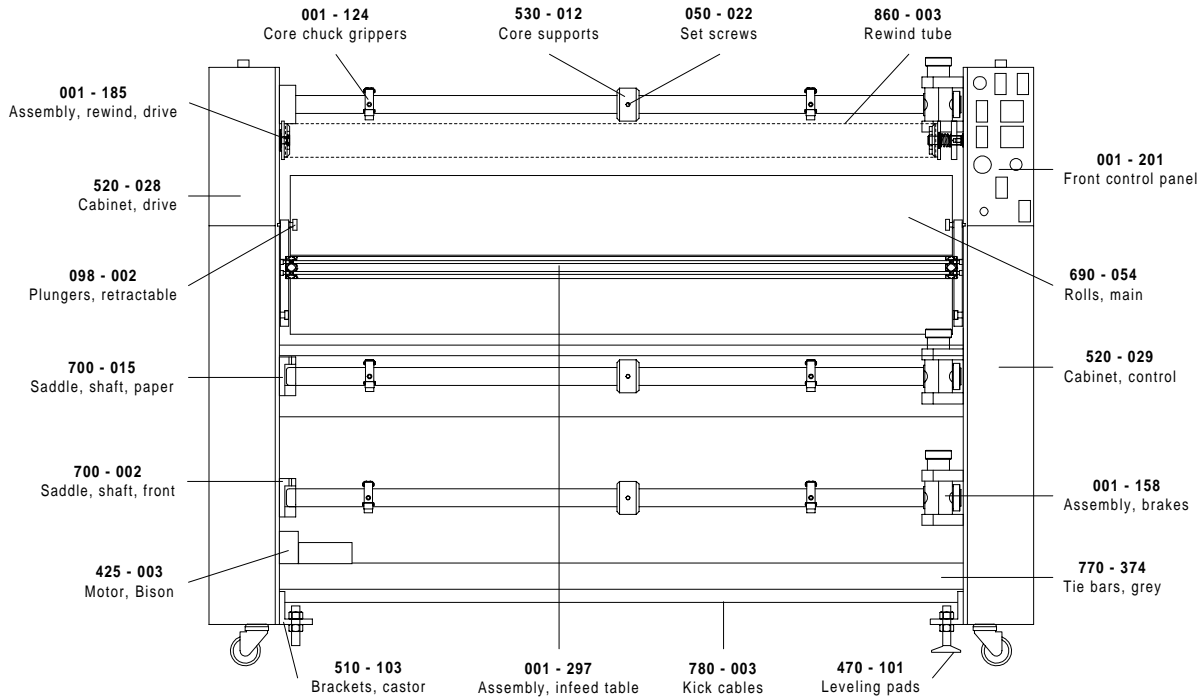
### Control Side



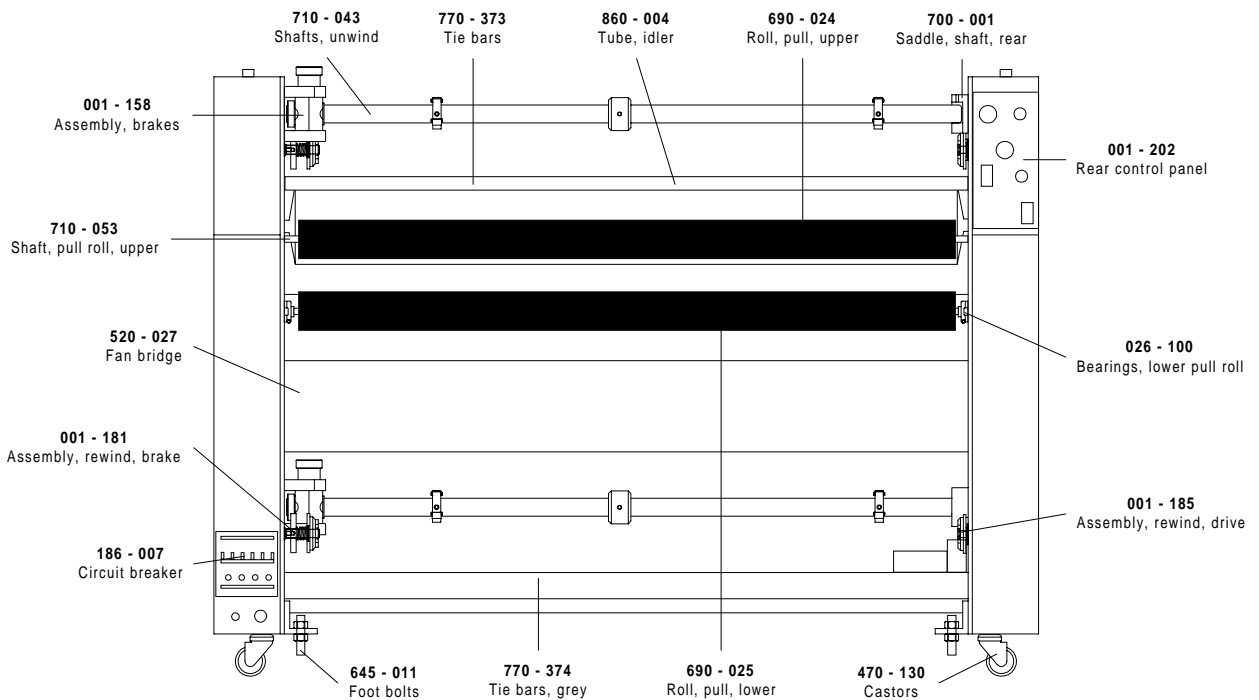
### Drive Side

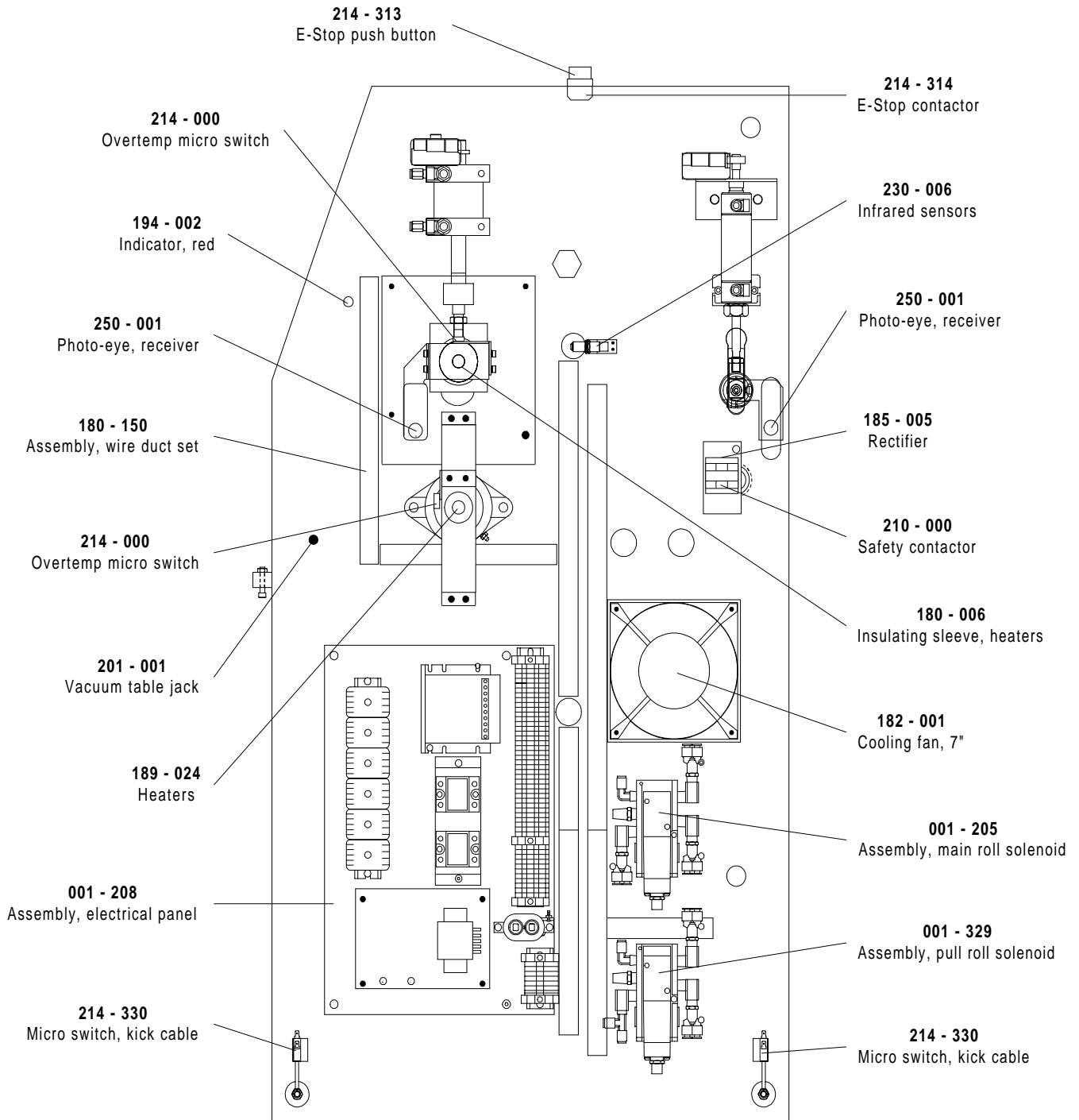


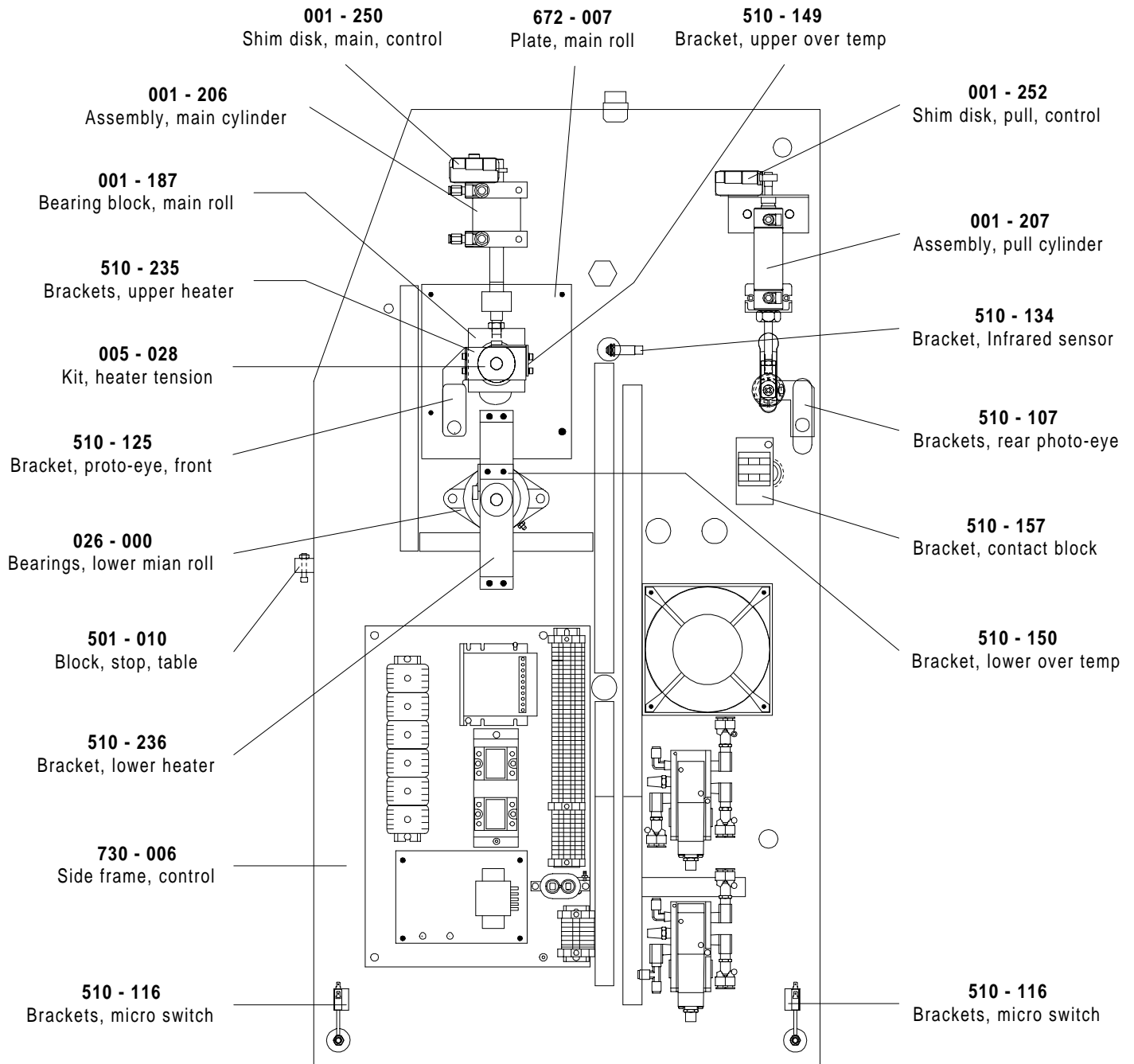
Front View

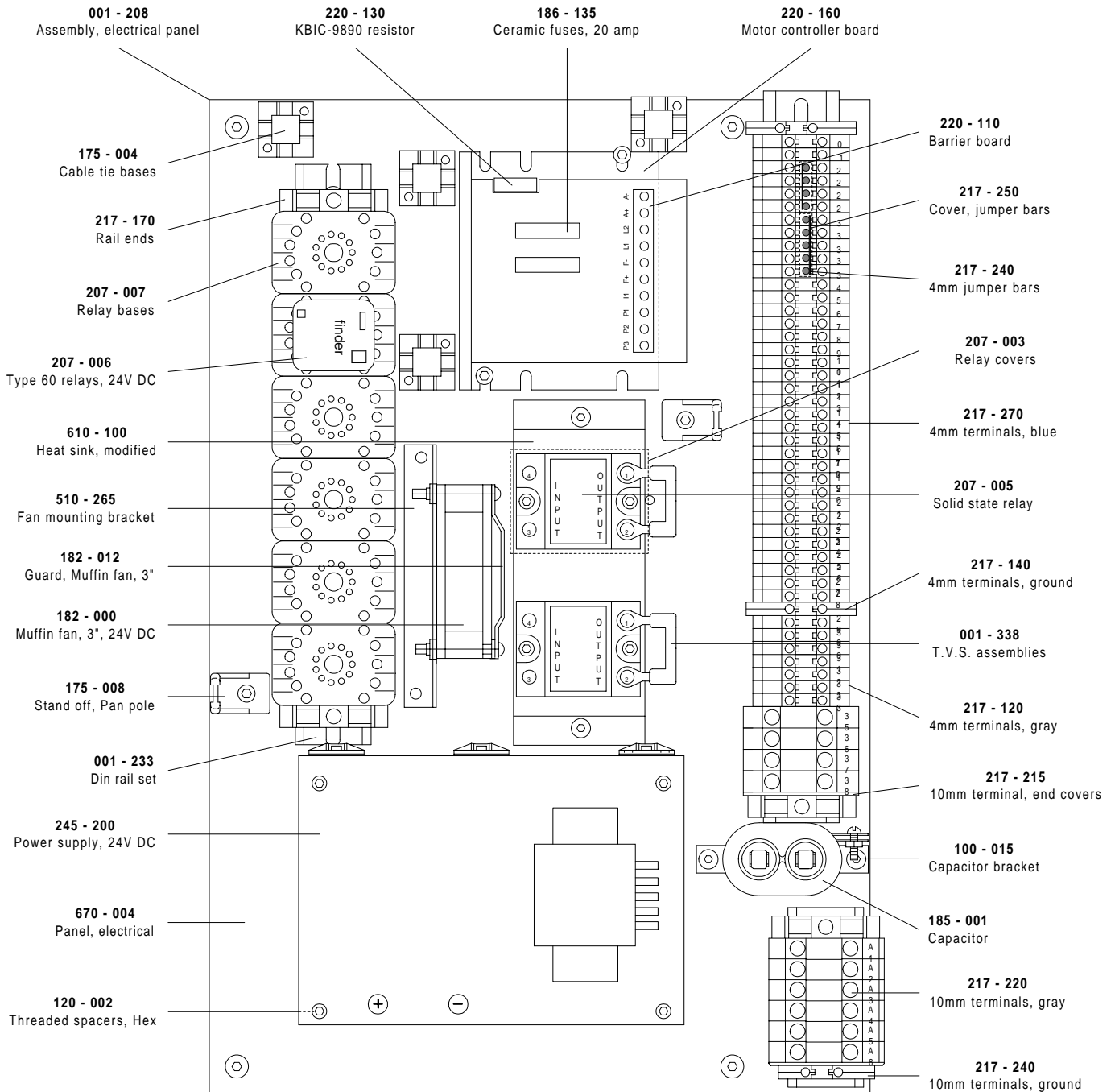


Rear View

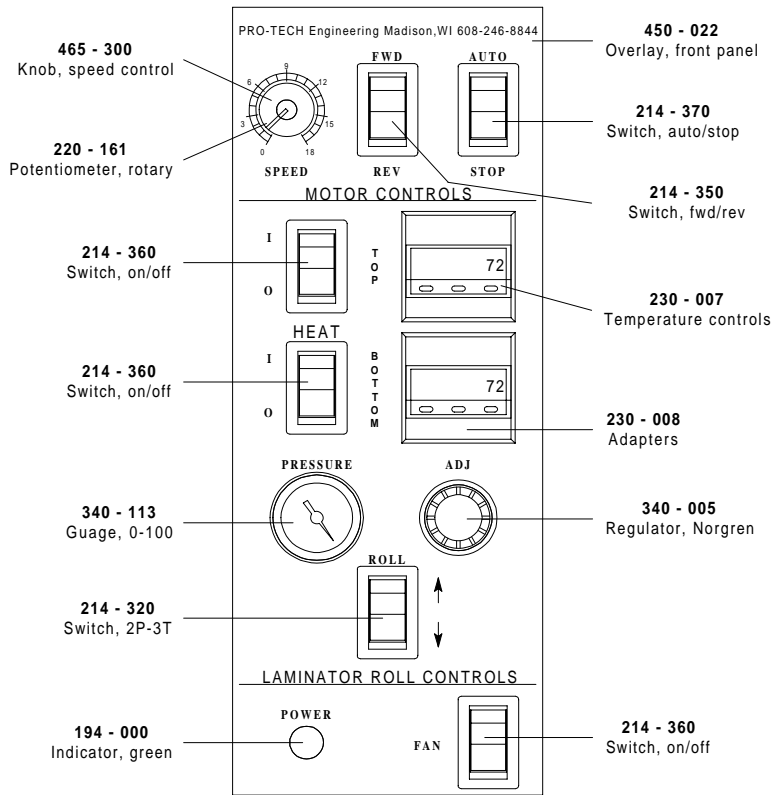




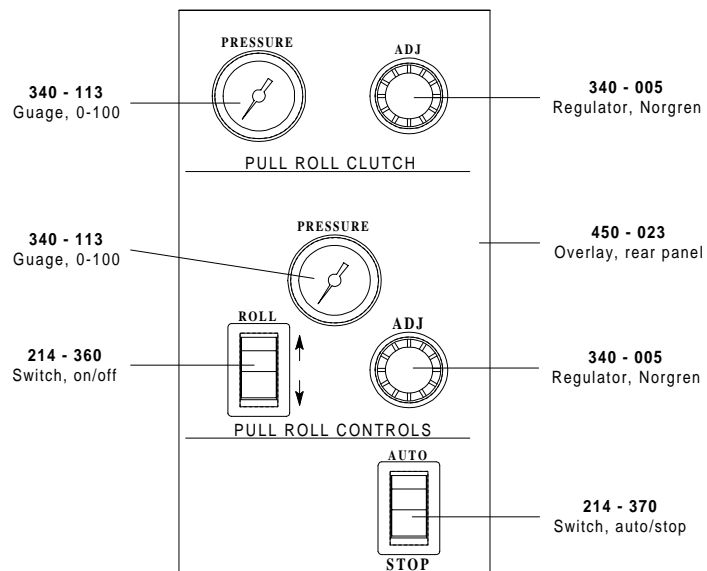


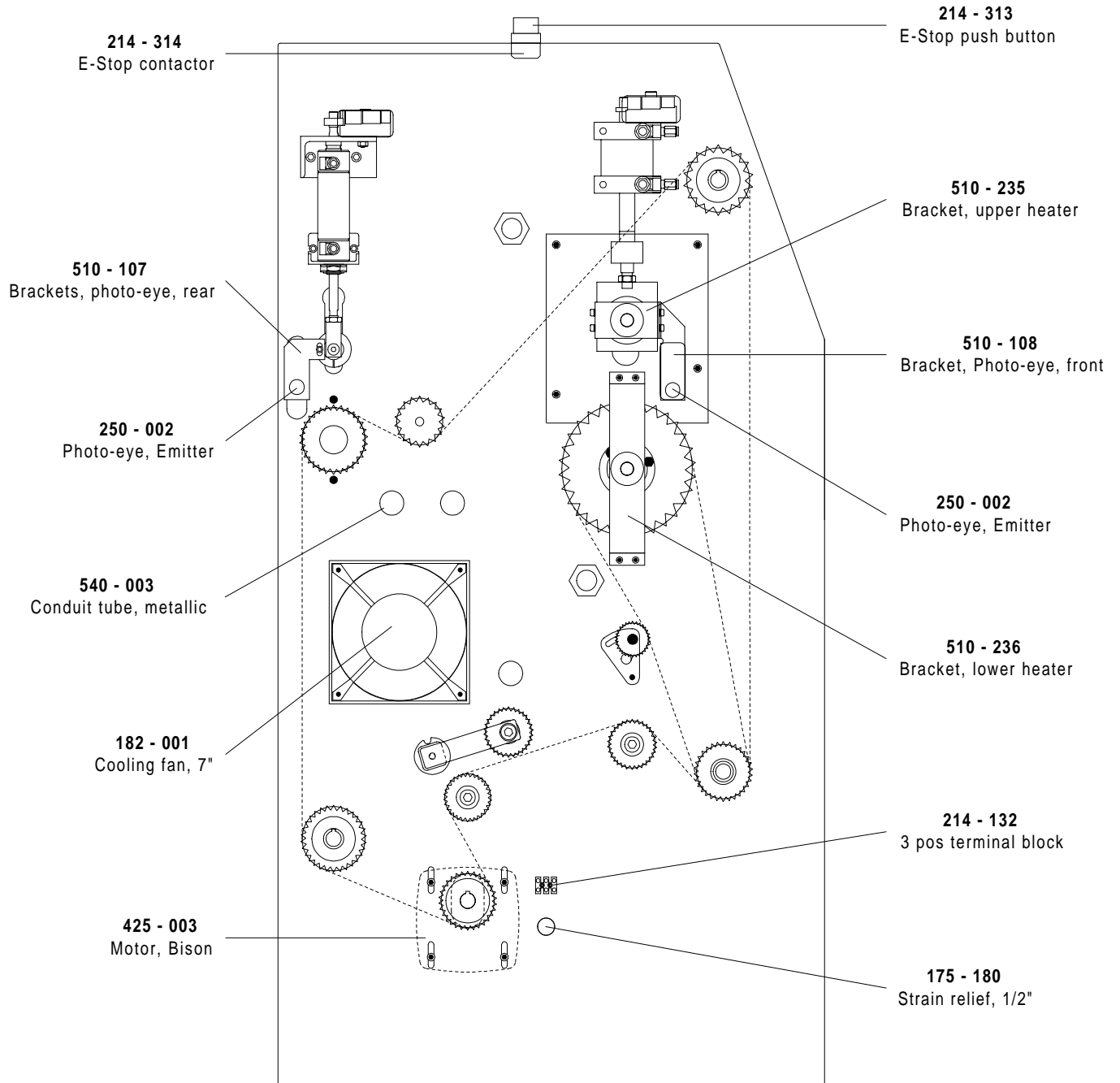


001 - 201 Front Control Panel

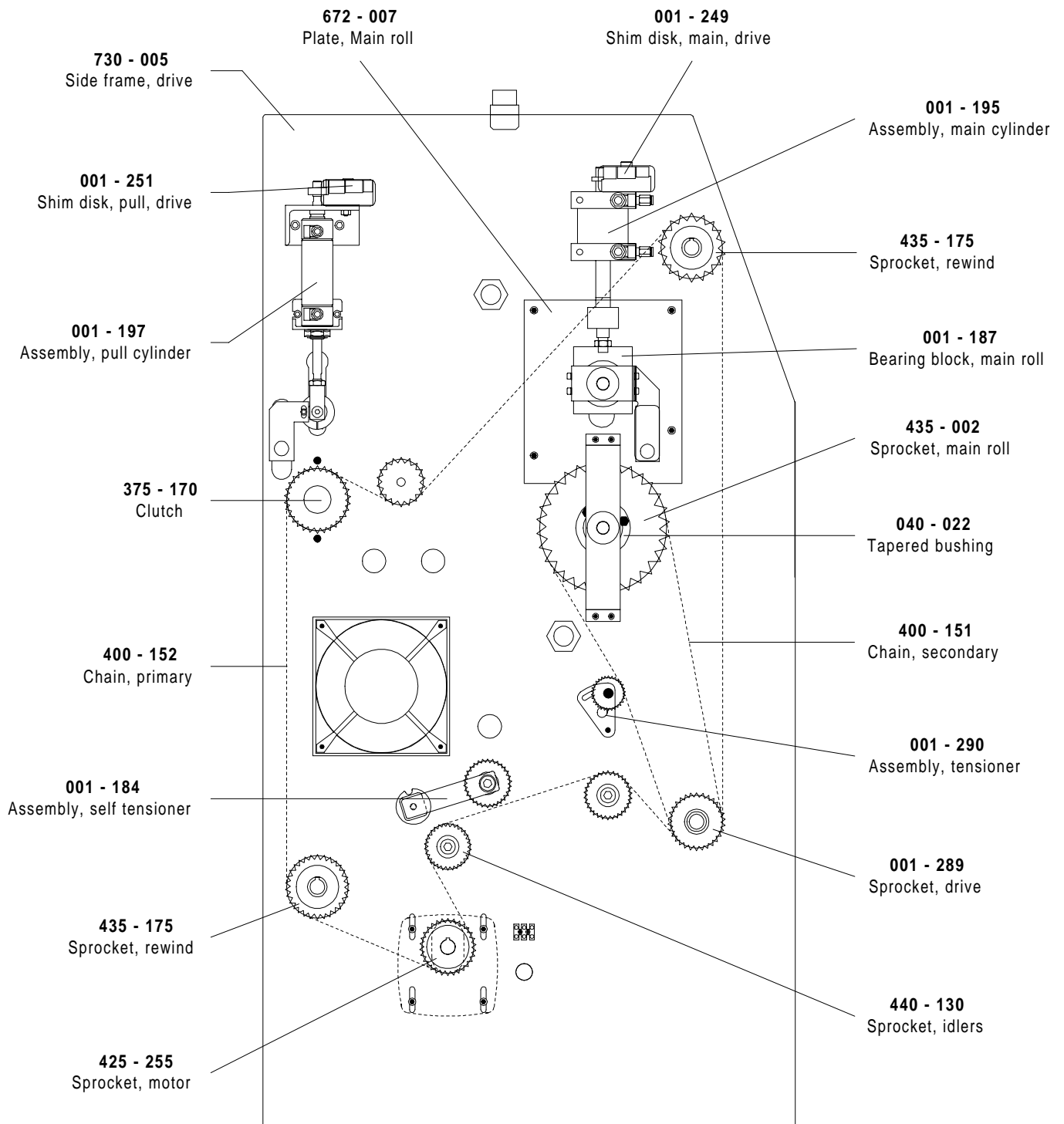


001 - 202 Rear Control Panel

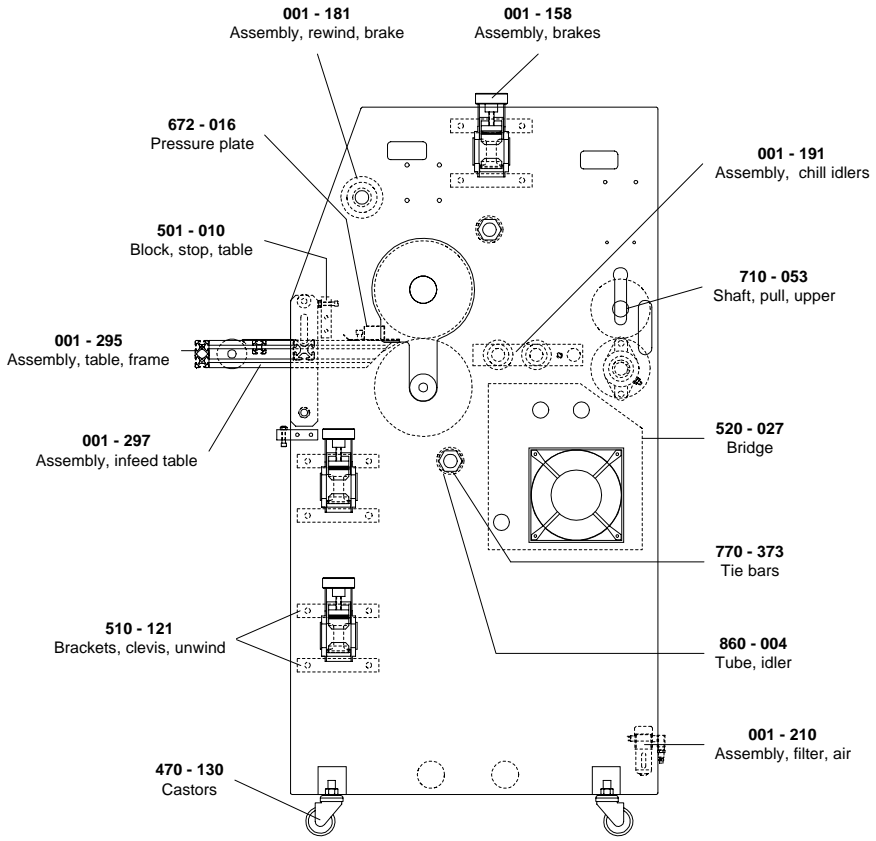




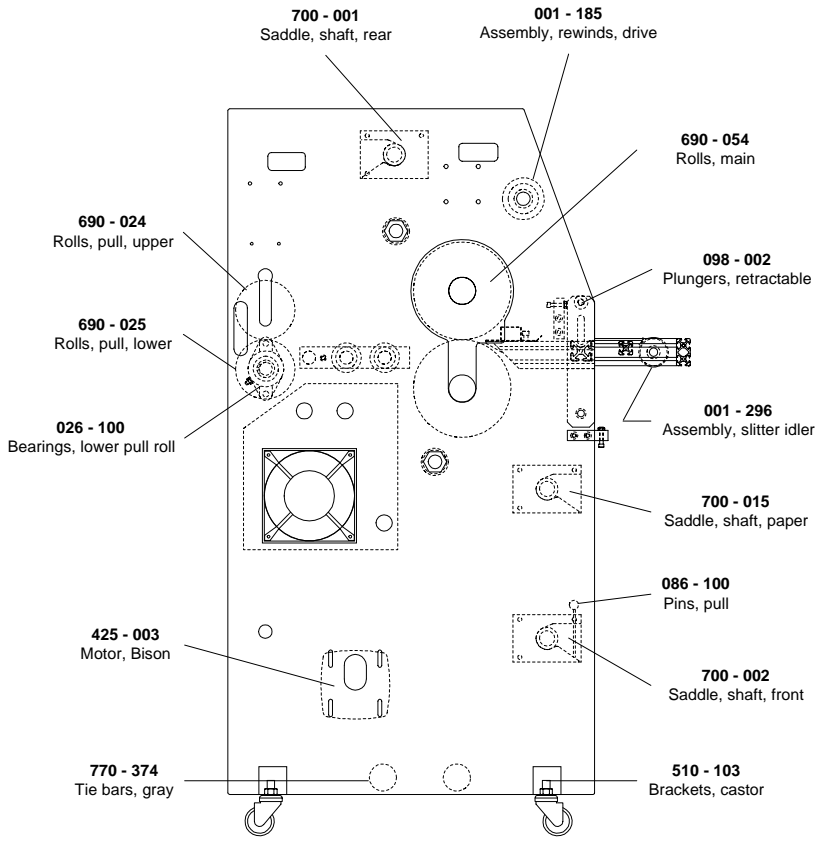




## Control Side

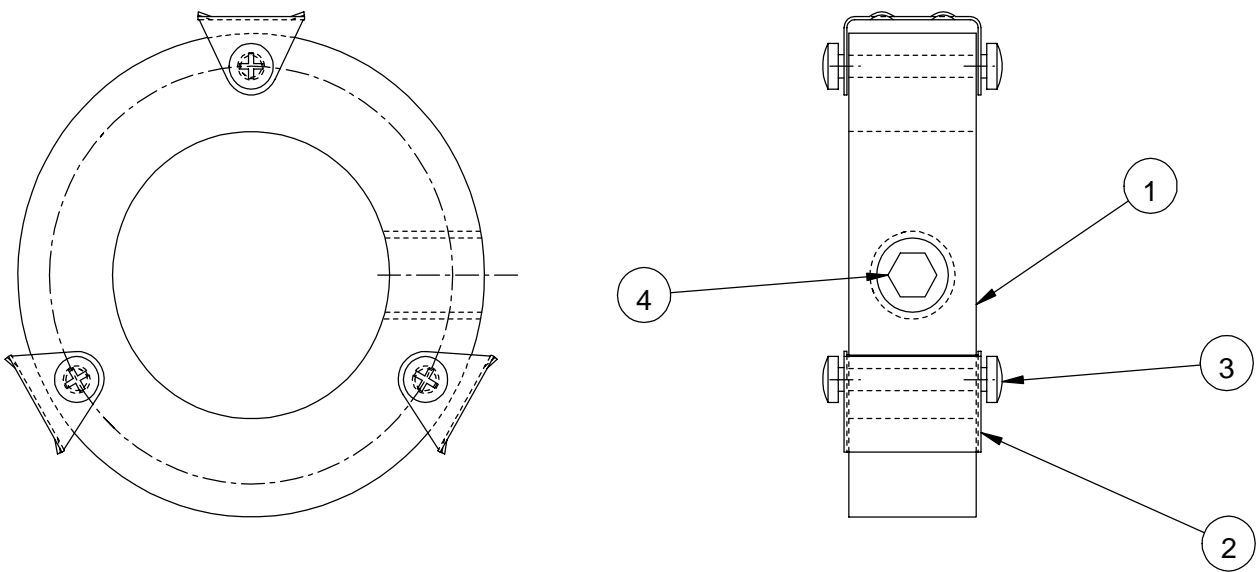


## Drive Side



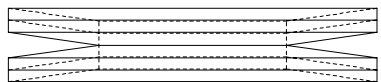
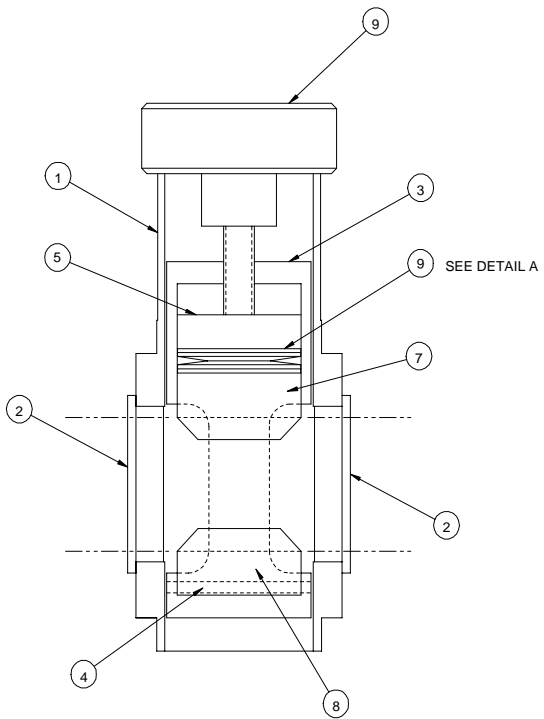
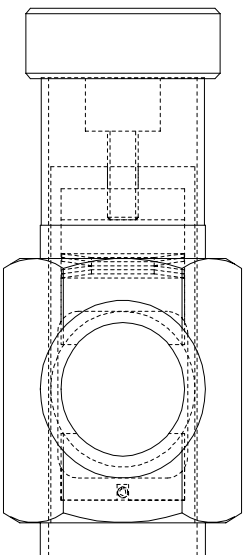
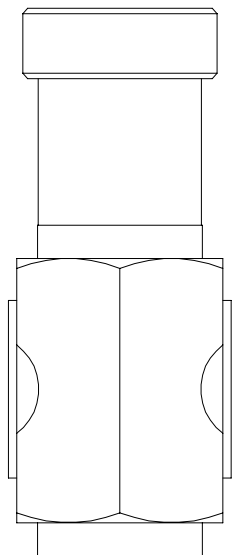
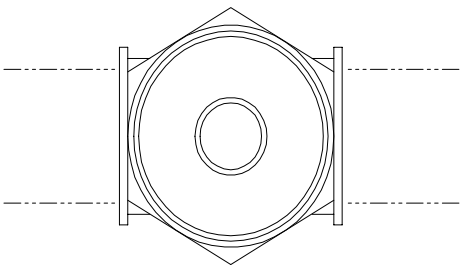
REQ'D	DESCRIPTION	PART NO.	ITEM
1	CHUCK,CORE,QUICK DISCONNECT	530-004	1
3	GRIPPER,CORE	100-032	2
6	SCREW,SELF-TAPPING,#6-32 X .375	-	3
1	SCREW,SET,BRASS TIP,1/2-13 X .5	050-007	4

△ A



This print is the property of PRO-TECH ENGR. The information thereon is remitted in confidence.			
UNLESS OTHERWISE SPECIFIED TOLERANCE		<b>Pro-Tech Engineering</b> 2117 N. Stoughton Rd. Madison, Wisconsin 53704 Phone (608) 246-8844 Fax (608) 246-4685	
DIM. AS SHOWN	TOL.		
X/X	P 1/64	125√	TITLE:
X.	P .050		<b>ASSEMBLY,CHUCK,CORE,1.625</b>
X.X	P .020		-
X.XX	P .010	ANGLES P 1D	DATE: 5-23-94
X.XXX	P .005		DRAWN BY: RAS
			DWG SCALE: A1
			Dwg: 001-124

REQ'D	DESCRIPTION	PART NO.	ITEM
1	PIN, PIVOT, UNWIND	625-008	1
2	BUSHING, FLANGE, NYLON	500-006	2
1	HOUSING, BRAKE	625-022	3
1	ROLL PIN, 1/8 X 1-3/4	095-105	4
1	PISTON, BRAKE	625-019	5
4	SPRING, DISC, 3/4 X 1-1/2	089-009	6
1	PAD, BRAKE, TOP	625-020	7
1	PAD, BRAKE, BOTTOM	625-021	8
1	KNOB, ADJUSTMENT, BRAKE	465-020	9



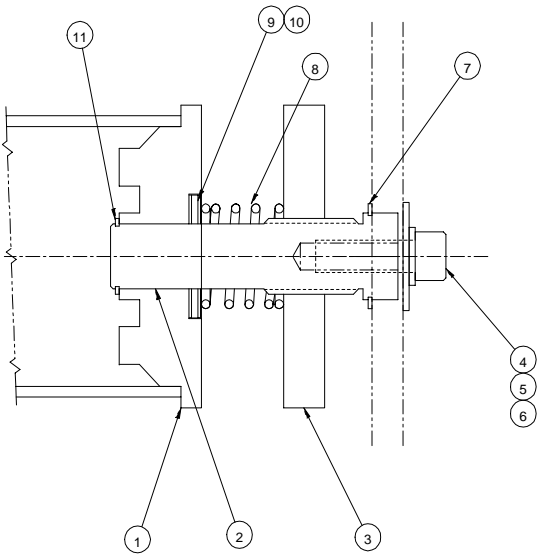
UDETAIL  
DISC SPRING  
ORIENTATION

3X SCALE

SHEET 1 OF UNLESS OTHERWISE SPECIFIED REFERENCE		FINIS TUBE		TITLE: ASSEMBLY, BRAKE	
2536	2507	1166	1161	0937	
QTY	REV	DATE	BY	CHKD	REVISION
E	D	C	B	A	
DATE: 11-15-98		DRAWN BY: RA		SCALE: 1/1	SIZE: C
RELEASE		S		001-158	

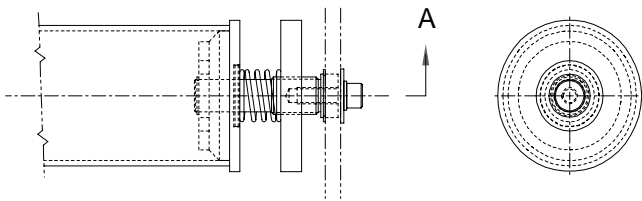


REQ'D	DESCRIPTION	PART NO.	ITEM
1	PLUG, CLUTCH, ORCA I	X92-0112	1
1	SHAFT, REWIND, STANDOFF	X92-0113	2
1	KNOB, CLUTCH, KNURLED	625-007	3
1	3/8-16 X 1 LG SHCS	-	4
1	3/8 FLATWASHWER	-	5
1	3/8 LOCKWASHER	-	6
1	SPRING CLIP, 5100-100	090-140	7
1	COMPRESSION SPRING, C1225-105-1500M	089-200	8
2	WASHER, THRUST, .030 THK	032-242	9
1	BEARING, THRUST	032-390	10
1	SNAP RING, 3/4 SHAFT, EXTERNAL	090-135	11



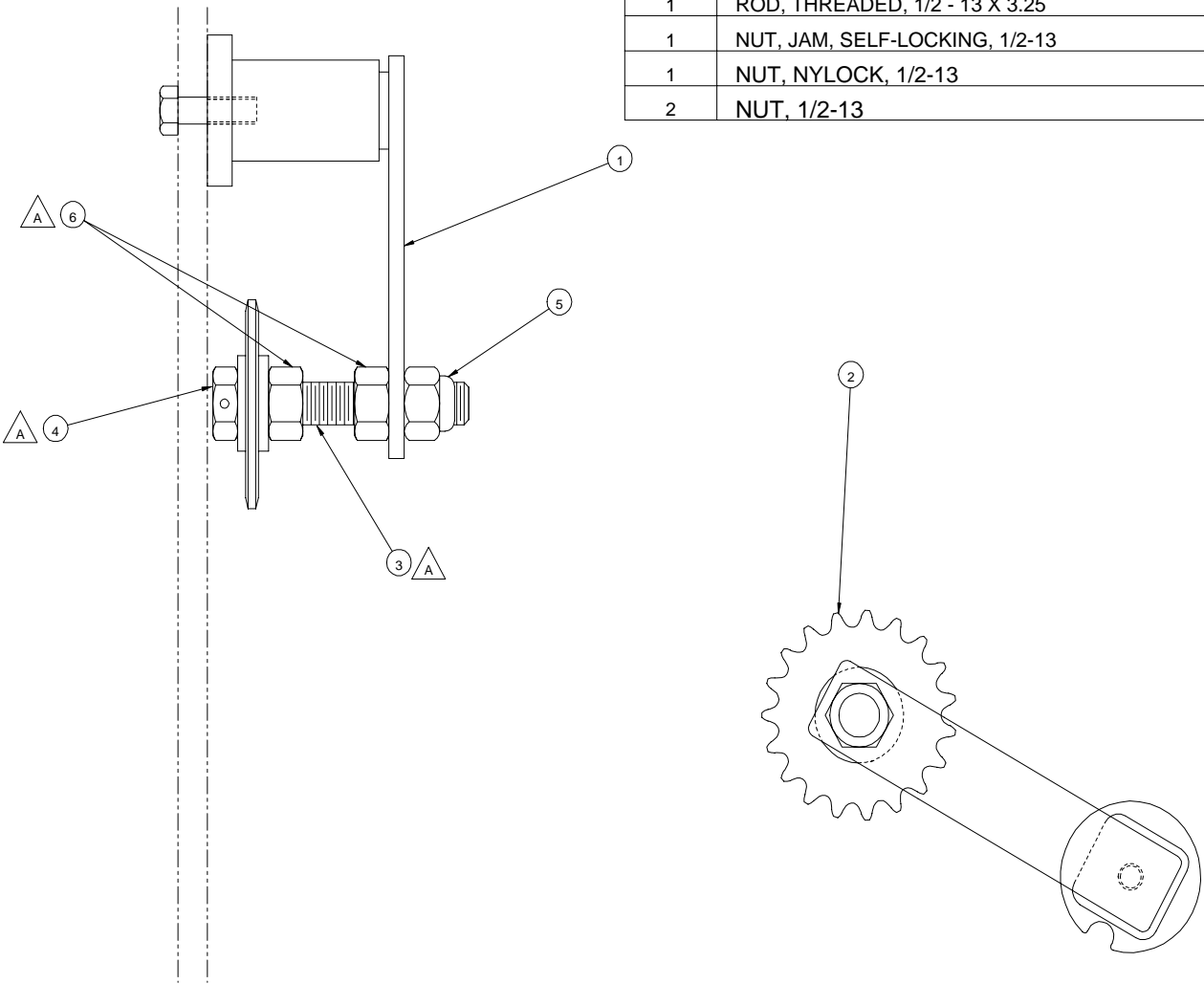
SECTION A-A

SCALE: 1/1



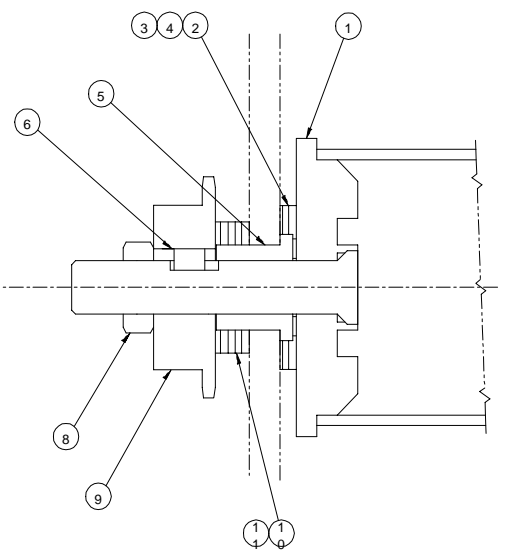
SHEET 1 1			UNLESS OTHERWISE SPECIFIED		 4151 Anderson Road, DePue, Wisconsin Phone (800) 248-5884 / Fax (800) 248-8846
DIM SDRBY X X X X X X	TOL P 11 .04 .05 .05 .05 .05 .05	FINIS 7B SE SE SE SE SE SE	TITLE : ASSY, REWIND, ORCA BRAKE		
DATE X.XX X.XX X.XX	TIME SE SE SE	ANGLE B ID	DRAWN BY RAS	SCALE 1:2	SHEET C
			001-181		181

REQ'D	DESCRIPTION	PART NO.	ITEM
1	TENSIONER, CHAIN	440-150	1
1	SPROCKET, 19T	440-130	2
1	ROD, THREADED, 1/2 - 13 X 3.25	645-018	3
1	NUT, JAM, SELF-LOCKING, 1/2-13	-	4
1	NUT, NYLOCK, 1/2-13	-	5
2	NUT, 1/2-13	-	6

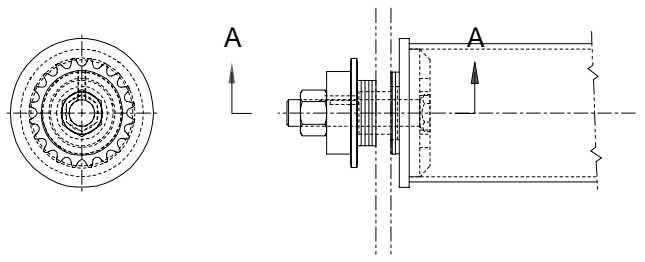


UNLESS OTHERWISE SPECIFIED:		TOL.		FINIS.		PRO.		DATE		DRAWN BY		DWG. NO.		REV.	
QTY	DESCRIPTION	IN.	FRA.	ASSEMBLY	REVISION	DATE	BY	NO.	DATE	BY	NO.	NO.	NO.	NO.	NO.
1	ASSY, TENSIONER, CHAIN								11-16-	K.L.		C		001-184	

REQ'D	DESCRIPTION	PART NO.	ITEM
1	PLUG, CLUTCH DRIVE	001-261	1
1	WASHER, THRUST, .090 THK	032-420	2
1	WASHER, THRUST .030 THK	032-410	3
1	BEARING, THRUST	032-400	4
1	BUSHING, BOST-BRONZE	500-003	5
1	KEY, 1/4 X 1/4 X 3/8 LG	-	6
-	-	-	7
1	LOCK NUT, 5/8-11	-	8
1	SPROCKET, 35BS20x5/8	435-175	9
4	WASHER, THRUST, .090 THK	032-205	10
1	BEARING, THRUST	032-190	11

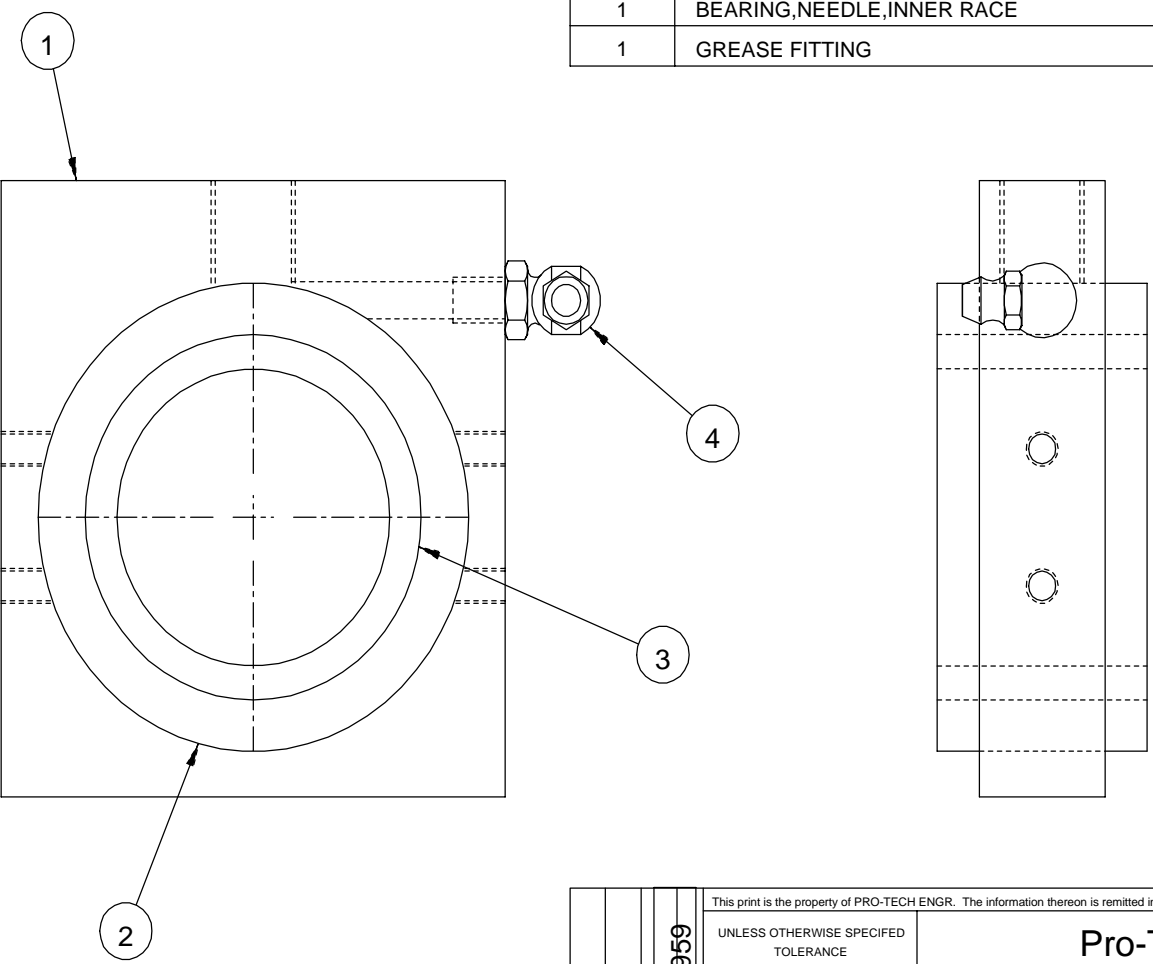


SECTION A-A  
SCALE: 2/1



SHEET 1		PRO-TECH		4151 Jackson Road, Detroit, Michigan Phone (800) 246-8862 Fax (800) 246-8864	
UNLESS OTHERWISE SPECIFIED		TITLE			
Q.M.	TOL.	FINIS	ASSY, REWIND, ORCA DRIVE		
SM	P. 1/2	HO	1		
X	BE	12	DATE 11-95		
X	P	5	DRAWN BY RAS		
X	P	5	SCALE 1:2		
X	P	5	SIZE C		
X.X	P	ANGLE	Deg 001-		
X.XX	P	RELEAS	185		
X	P	ID			

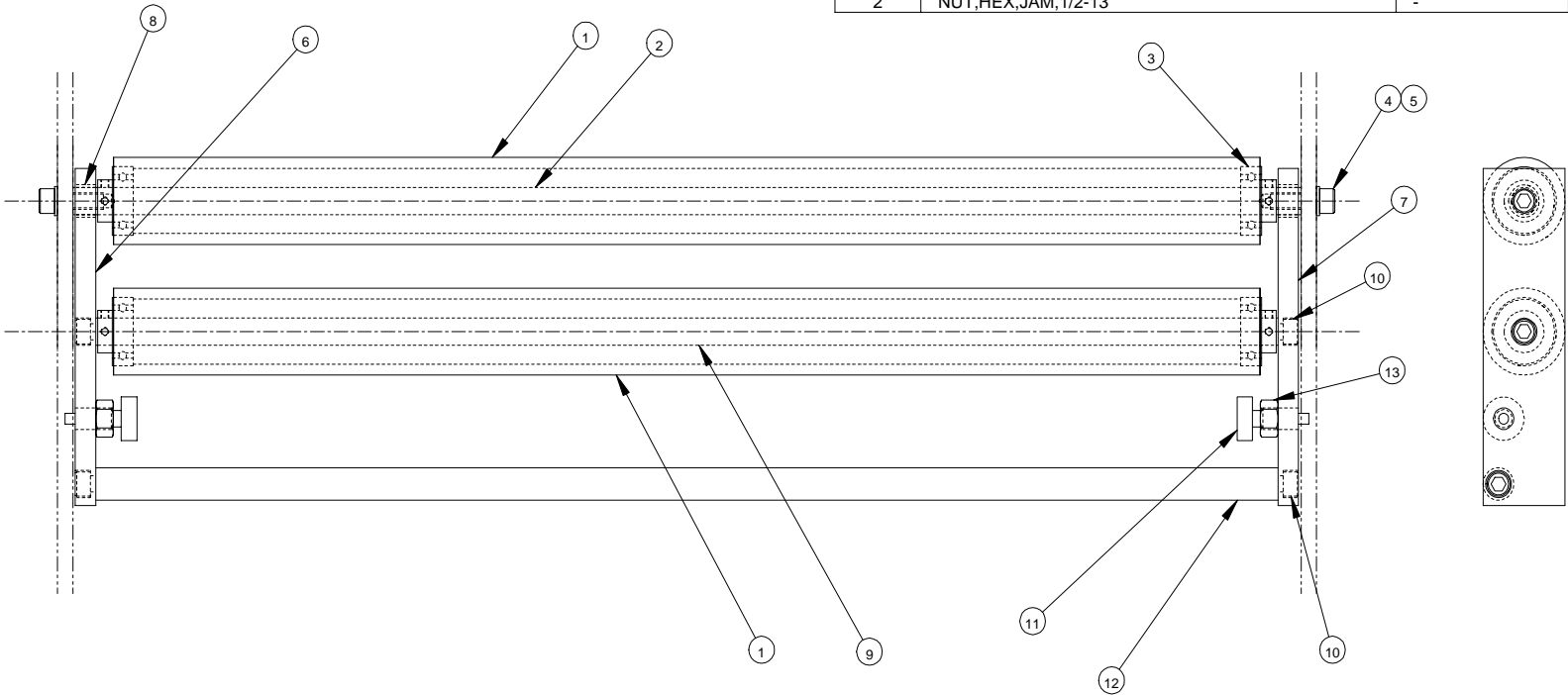
REQ'D	DESCRIPTION	PART NO.	ITEM
1	BLOCK,BEARING,MAIN ROLL,ORCA I	501-009	1
1	BEARING,NEEDLE,OUTTER RACE	028-000	2
1	BEARING,NEEDLE,INNER RACE	028-001	3
1	GREASE FITTING	060-005	4



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UNLESS OTHERWISE SPECIFIED TOLERANCE			<b>Pro-Tech Engineering</b> 2117 N. Stoughton Rd. Madison, Wisconsin 53704 Phone (608) 246-8844 Fax (608) 246-8645	
DIM. AS SHOWN	TOL.	FINISH TO BE		
X/X	P 1/64	$125\sqrt{\quad}$	TITLE: <b>BLK,BRG,LEFT,MAIN ROLL ORCA I</b>	
X.	P .050			
X.X	P .020			
X.XX	P .010	ANGLES P 1D		DATE: 11-17-94
X.XXX	P .005			DRAWN BY: K.L.
		DWG SCALE: A1	Dwg: 001-187	



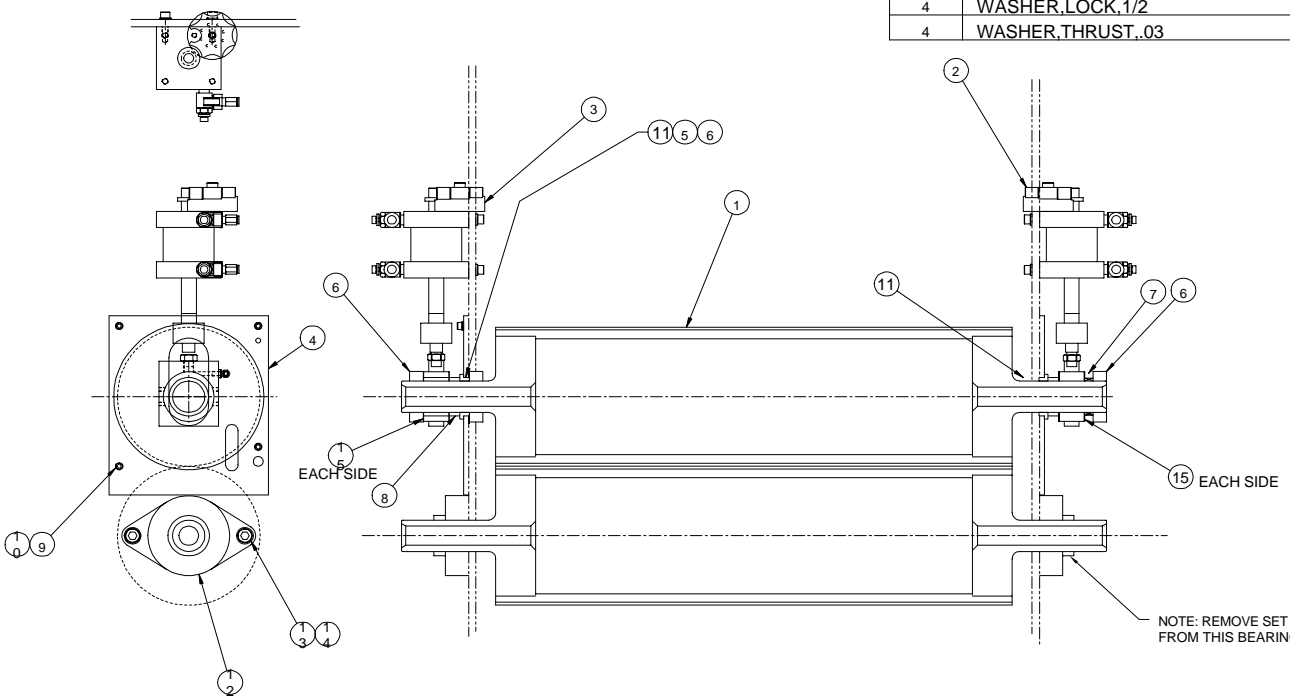
REQ'D	DESCRIPTION	PART NO.	ITEM
2	IDLER, OUPUT, ORCA I	620-012	1
1	SHAFT, IDLER, OUPUT, ORCA I	710-039	2
4	BEARING	020-100	3
2	SHCS, 3/8-16 X 1	-	4
2	WASHER, LOCK, 3/8	-	5
1	BRACKET, ARM, IDLER, RT, ORCA I	510-111	6
1	BRACKET, ARM, IDLER, LF, ORCA I	510-113	7
2	BUSHING, BRONZ, .62 X .5	040-021	8
1	SHAFT, IDLER, OUTPUT, ORCA I	710-040	9
4	SHCS, 3/8-16 X .5	-	10
2	PLUNGER, RETRACTABLE, 1/4	098-002	11
1	SHAFT, LIFTER, IDLER, ORCA I	710-038	12
2	NUT, HEX, JAM, 1/2-13	-	13



UNLESS OTHERWISE SPECIFIED, TOLERANCE:				Pro-Tech Engineering			
2117 North 24th Street, Suite 100, Phoenix, AZ 85016				2117 North 24th Street, Suite 100, Phoenix, AZ 85016			
TITLE: ASSEMBLY, IDLER, OUTFEED				DATE: 11-28-94			
DRAWN BY: RA				DWG SCALE: C			
CHECKED BY: S				DWG NO: 001-191			

REQD	DESCRIPTION	PART NO.	ITEM
2	ROLL, MAIN, IF-60	690-054	1
1	ASSEMBLY,CYLINDER,MAIN ROLL,RT	001-206	2
1	ASSEMBLY,CYLINDER,MAIN ROLL,LF	001-195	3
2	PLATE,BEARING,MAIN ROLL	672-007	4
1	WASHER,THRUST,.03	032-230	5
3	COLLAR,LOCK,1.62	290-001	6
1	SPRING,WAVE,1.625ID	089-006	7
2	SPACER,BUSHING	500-004	8
8	SHCS,1/4-20 X .625	-	9
8	WASHER,LOCK,1/4	-	10
2	BUSHING,MODIFIED,1.625X1.25	500-001	11
2	BEARING,FLANGED	026-000	12
4	SHCS,1/2-13 X 1.25	-	13
4	WASHER,LOCK,1/2	-	14
4	WASHER,THRUST,.03	032-009	15

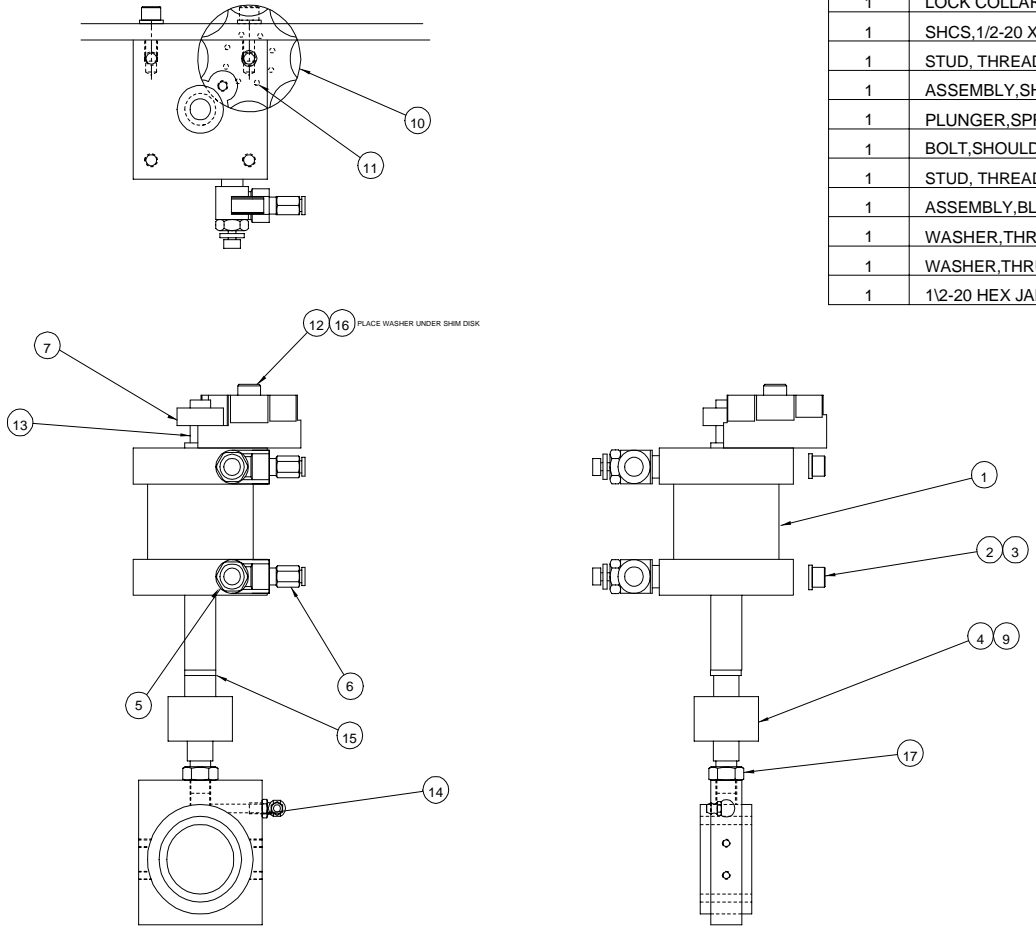
**PROPRIETARY**  
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NOTE: REMOVE SET SCREWS FROM THIS BEARING

SHEET 1 OF 1		UNLESS OTHERWISE SPECIFIED TOLERANCE		GBC PRO-TECH	
DM. AS SHOWN	TOL.	FINISH TO BE	4151 Anderson Road, DeForest, Wisconsin 53532 Phone (800) 246-8844 Fax (800) 246-8845		
XX	F.154	✓	TITLE		
X	F.050		ASSEMBLY,ROLL,MAIN		
X-X	F.050		DATE 11-29-94		
XXX	F.010	ANGLES P ID	DATE RELEASED	DRAWN RAS	SC# 1
XXXX	F.005			SIZE C	Dep: 001-194

REQ'D	DESCRIPTION	PART NO.	ITEM
1	CYLINDER,2.5 X 1.75	320-320	1
4	SHCS,5/16-18 X .75	-	2
4	WASHER,LOCK,5/16	-	3
1	COUPLING,ROD END,1/2-20	325-000	4
2	CONTROL,FLOW	330-130	5
2	FITTING,STRAIGHT,1/4NPT X 1/4	330-600	6
1	LOCK COLLAR,1/2-20	290-260	7
1	SHCS,1/2-20 X .5	-	8
1	STUD, THREADED, 1/2 - 20 x 1"	645-007	9
1	ASSEMBLY,SHIM DISK,LEFT	001-249	10
1	PLUNGER,SPRING,1/4-20	098-120	11
1	BOLT,SHOULDER,3/8,1.0,5/16-18	-	12
1	STUD, THREADED, 1/2 - 20 x 1-3/4"	645-006	13
1	ASSEMBLY,BLOCK,BEARING,LEFT,MAIN ROLL	001-187	14
1	WASHER,THRUST,.060	068-100	15
1	WASHER,THRUST,.312 X .06	032-360	16
1	1/2-20 HEX JAM NUT	-	17



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REV	DATE	BY	CHKD	DESCRIPTION
F	2745			
E	2539			
D	0984			
C	0968			
B	0943			
A	0892			

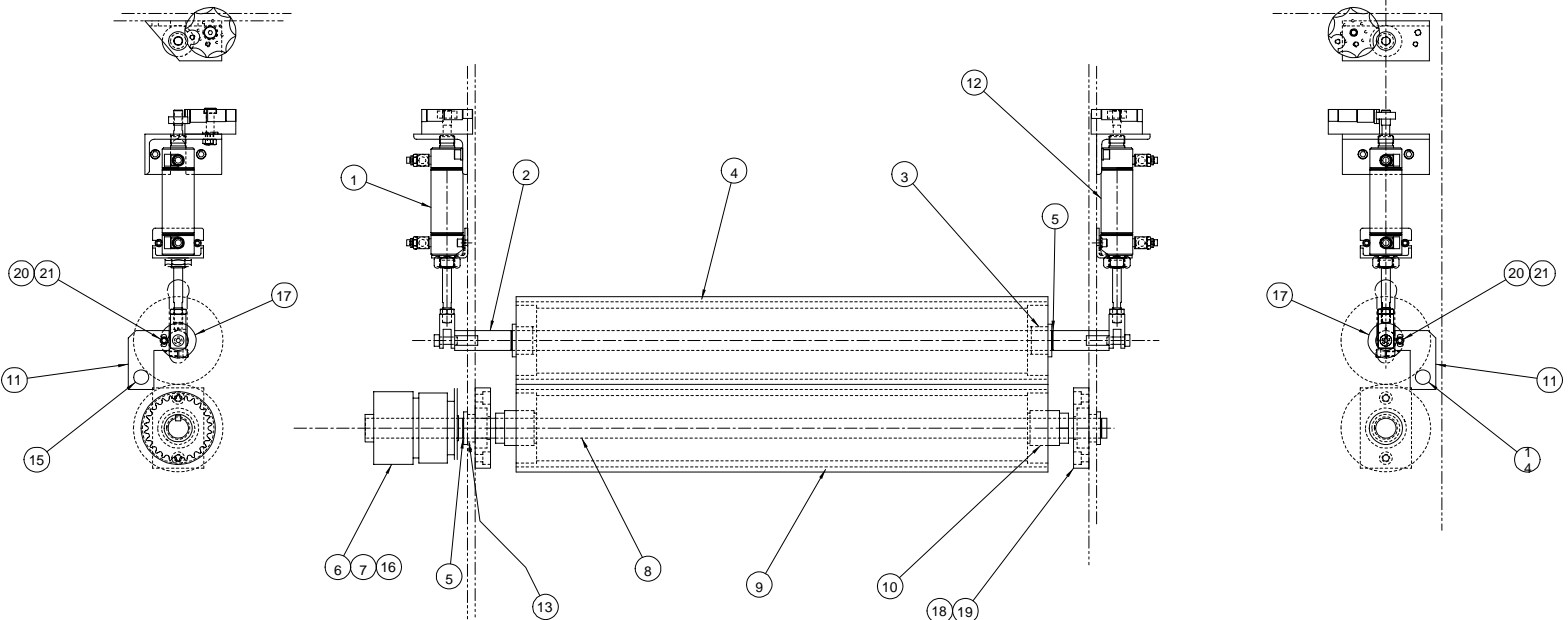
UNLESS OTHERWISE SPECIFIED:	TOL.	FINISH
SMALL	1/2	P-17
MED	3/4	P-17
LG	1	P-17
XX	P-.005	12 FT
XXX	P-.003	
XXXX	P-.002	
XXXXX	P-.001	
XXXXXX	P-.0005	
XXXXXXX	P-.0002	
XXXXXXXX	P-.0001	

Pro-Tech Engineering  
 2117 N. Shoghton Rd. Madison, Wisconsin 53704  
 Phone (608) 248-8044 Fax (608) 248-4550

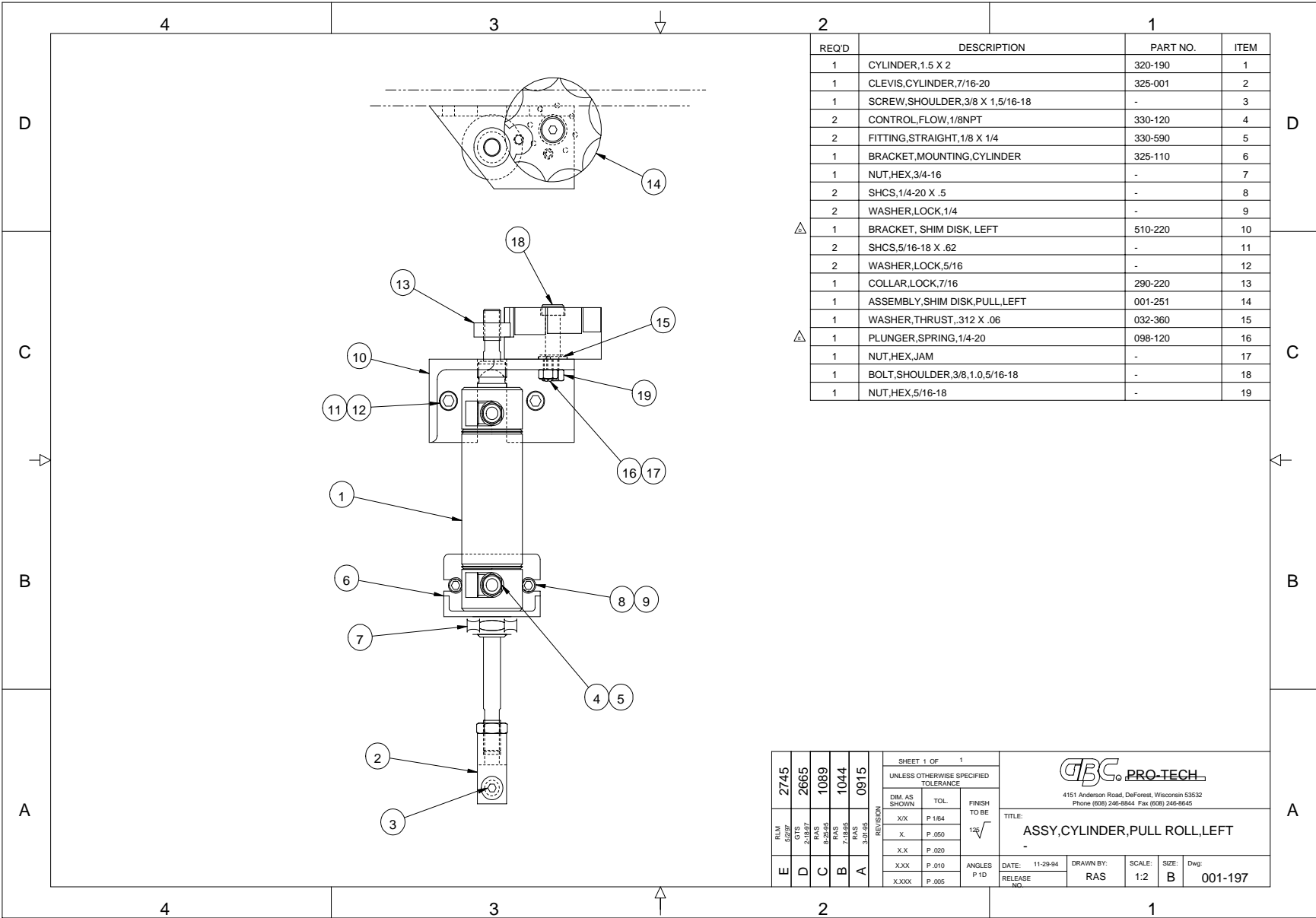
TITLE: ASSEMBLY,CYLINDER,MAIN LEFT

DATE: 11-29-94 DRAWN BY: RAS DWG SCALE: C2 DWG NO: 001-195

REQ'D	DESCRIPTION	PART NO.	ITEM
1	ASSEMBLY,CYLINDER,PULL,ROLL,LF	001-197	1
1	SHAFT,PULL,ROLL,UPPER	710-041	2
2	BUSHING,BRONZE,1.1,38.1	040-015	3
1	ROLL,PULL,UPPER,ORCA I	690-027	4
4	RING,SNAP,1.0	090-140	5
1	CLUTCH	375-170	6
1	FITTING,STRAIGHT,1/8 X 1/4	330-590	7
1	SHAFT,ROLL,PULL,LOWER	710-042	8
1	ROLL,PULL,LOWER	690-028	9
2	BUSHING,KEYLESS,1.1,75	040-017	10
2	BRACKET,MOUNTING,PHOTOEYE,PULL,ROLL	510-107	11
1	ASSEMBLY,CYLINDER,PULL,ROLL,RT	001-207	12
2	WASHER,THRUST,1.0 X .06	032-250	13
1	SWITCH,PHOTOEYE,EMITTER	250-002	14
1	SWITCH,PHOTOEYE,RECEIVER	250-001	15
1	EYEBOLT,1/4-20	-	16
2	LOCK COLLAR, MODIFIED	640-001	17
2	ASSEMBLY BEARING	001-288	18
4	SHCS,3/8-16 X .75	-	19
2	SHCS,1/4-20 X 3/8	-	20
2	WASHER,LOCK,1/4	-	21



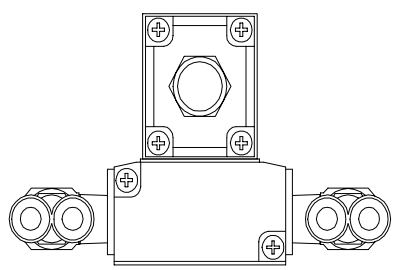
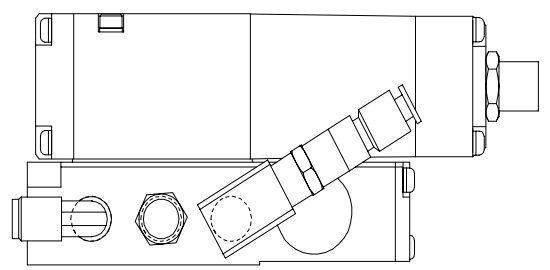
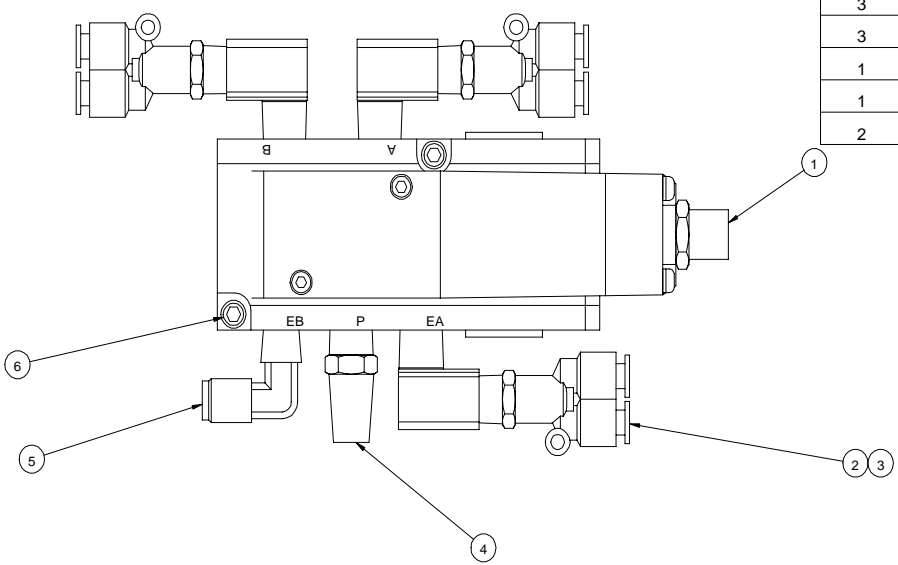
UNLESS OTHERWISE SPECIFIED TOLERANCES:		FINISH		PRO-TECH ENGINEERING	
SIZE	TOL.	1/16"	F 150	2175 S. Douglas St. Fresno, California 93750	
3/16"	F 150	1/8"	F 150	Phone (509) 246-8584 Fax (509) 246-4585	
1/4"	F 150	3/16"	F 150	TITLE	
5/16"	F 150	1/2"	F 150	ASSEMBLY,ROLL,PULL	
3/4"	F 150	3/4"	F 150	DATE	11-30-94
1.000"	F 150	ANGLES	P 10	DRAWN BY	RAS
				DWG. SCALE	C4
				DWG. NO.	001-196



REQD	DESCRIPTION	PART NO.	ITEM
1	CYLINDER,1.5 X 2	320-190	1
1	CLEVIS,CYLINDER,7/16-20	325-001	2
1	SCREW,SHOULDER,3/8 X 1,5/16-18	-	3
2	CONTROL,FLOW,1/8NPT	330-120	4
2	FITTING,STRAIGHT,1/8 X 1/4	330-590	5
1	BRACKET,MOUNTING,CYLINDER	325-110	6
1	NUT,HEX,3/4-16	-	7
2	SHCS,1/4-20 X .5	-	8
2	WASHER,LOCK,1/4	-	9
Δ 1	BRACKET, SHIM DISK, LEFT	510-220	10
2	SHCS,5/16-18 X .62	-	11
2	WASHER,LOCK,5/16	-	12
1	COLLAR,LOCK,7/16	290-220	13
1	ASSEMBLY, SHIM DISK,PULL,LEFT	001-251	14
1	WASHER,THRUST,.312 X .06	032-360	15
Δ 1	PLUNGER,SPRING,1/4-20	098-120	16
1	NUT,HEX,JAM	-	17
1	BOLT,SHOULDER,3/8,1.0,5/16-18	-	18
1	NUT,HEX,5/16-18	-	19

R/LM	2745	SHEET 1 OF 1		UNLESS OTHERWISE SPECIFIED TOLERANCE		 4151 Anderson Road, DeForest, Wisconsin 53532 Phone (608) 246-8844 Fax (608) 246-8645
DES	2665	DM. AS SHOWN	TOL.	FINISH TO BE	TITLE:	
RAIS	1089	XX	P .164	125√	ASSY,CYLINDER,PULL ROLL,LEFT	
RAIS	1044	X	P .050			
RAIS	0915	XX	P .020			
REVISION		X.XX	P .010	ANGLES P 1D	DATE: 11-29-94	
		X.XXX	P .005		RELEASE NO.	
					DRAWN BY: RAS	
					SCALE: 1:2	
					SIZE: B	
					Dwg: 001-197	

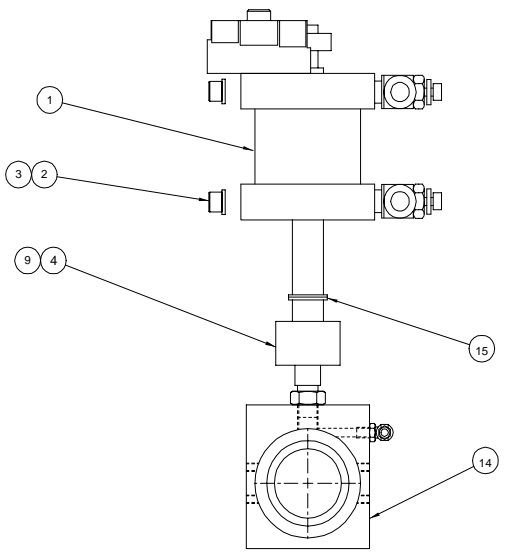
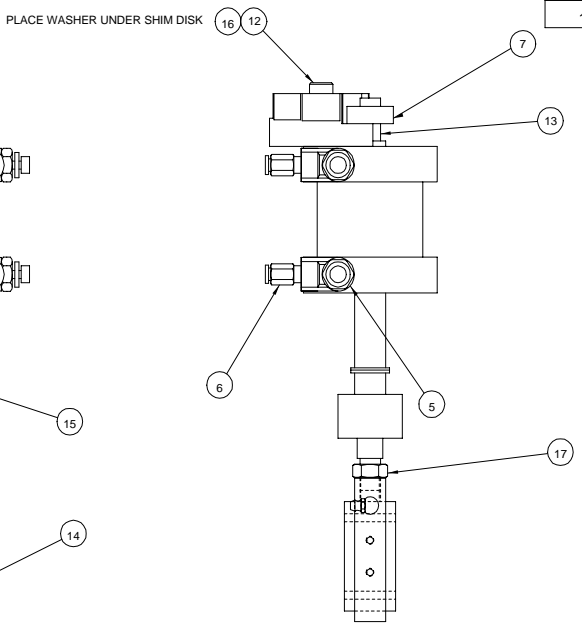
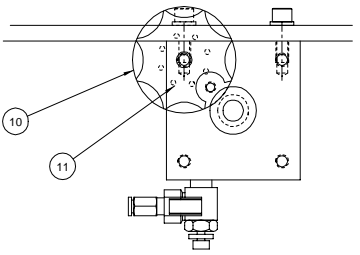
REQD	DESCRIPTION	PART NO.	ITEM
1	VALVE, AIR, SOLENOID	350-115	1
3	FITTING,AIR,ELBOW,1/4NPT	330-760	2
3	Y-FITTING,1/4NPT	330-310	3
1	MUFFLER, AIR	330-280	4
1	FITTING, AIR, ELBOW, MALE 1/4 NPT	330-730	5
2	CAP SCREWS, SOCKET, #10-32 X 1-1/4 LG	-	6



ROTATE FITTINGS AS REQUIRED FOR BEST ASSEMBLY

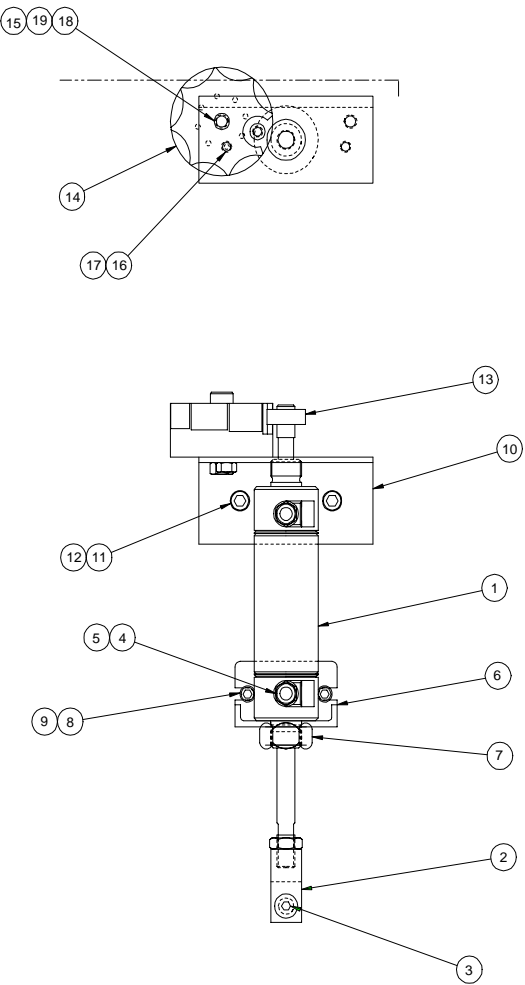
UNLESS OTHERWISE SPECIFIED:											
DWG	TOL	FRGS	Pro-Tech Engineering								
SPRNG		FS	2115 Pro-Tech Engineering, Inc. 10000 2nd St. 94024								
PL	P.154	RE	TITLE								
A	P.250	1/4	ASSEMBLY, VALVE CONTROL								
XL	P.250		DATE	DESIGN	DWG	DRG	001-205				
XL	P.250	ANGLE	12-9-	BY:	SCALE	1					
XL	P.250	B	94	KL	1						
XL	P.250	10									

REQD	DESCRIPTION	PART NO.	ITEM
1	CYLINDER,2.5 X 1.75	320-320	1
4	SHCS,5/16-18 X .75	-	2
4	WASHER,LOCK,5/16	-	3
1	COUPLING,ROD END,1/2-20	325-000	4
2	CONTROL,FLOW	330-130	5
2	FITTING,STRAIGHT,1/4NPT X 1/4	330-600	6
1	LOCK COLLAR,1/2-20	290-260	7
1	SHCS,1/2-20 X .5		8
1	STUD, THREADED, 1/2 - 20 x 1"	645-007	9
1	ASSEMBLY,SHIM DISK,MAIN,RIGHT	001-250	10
1	PLUNGER,SPRING,1/4-20	098-120	11
1	BOLT,SHOULDER,3/8,1.0,5/16-18	-	12
1	STUD, THREADED, 1/2 - 20 x 1-3/4"	645-006	13
1	ASSEMBLY,BLOCK,BEARING	001-187	14
2	WASHER,THRUST,.06	032-140	15
1	WASHER,THRUST,.312 X .06	032-360	16
1	1/2-20 HEX JAM NUT	-	17



UNLESS OTHERWISE SPECIFIED		TOLERANCE		FINISH TO BE		DATE		DRAWN		DWG SCALE	
DIM	TOL	SHOWN				DATE	DRAWN	DWG SCALE	DWG		
FRA	±	XXX	P.164	12	11-29-94	S	C2	001-206			
DEC		XXX	P.050	12							
ANG		XXX	P.020	12							
PLA		XXX	P.010	12							
ALL		XXX	P.005	12							

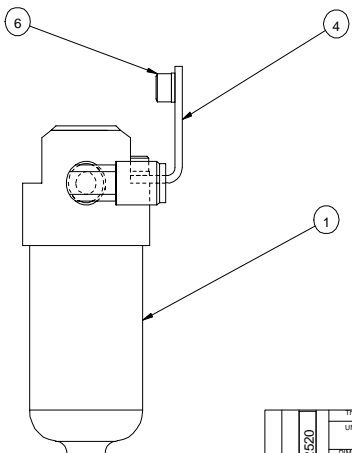
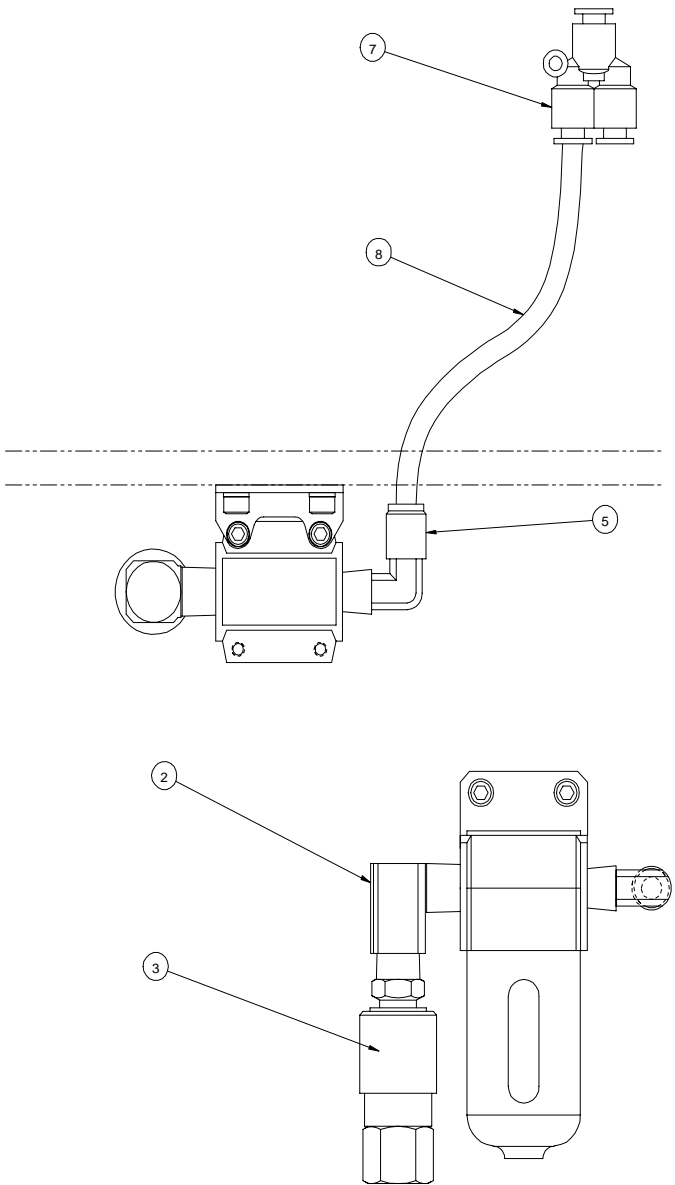
REQD	DESCRIPTION	PART NO.	ITEM
1	CYLINDER,1.5 X 2	320-190	1
1	CLEVIS,CYLINDER,7/16-20	325-001	2
1	SCREW,SHOULDER,3/8 X 1,5/16-18	-	3
2	CONTROL,FLOW,1/8NPT	330-120	4
2	FITTING,STRAIGHT,1/8 X 1/4	330-590	5
1	BRACKET,MOUNTING,CYLINDER	325-110	6
1	NUT,HEX,3/4-16	-	7
2	SHCS,1/4-20 X .5	-	8
2	WASHER,LOCK,1/4	-	9
1	BRACKET,MOUNTING,SHIM,CYLINDER	510-132	10
2	SHCS,5/16-18 X .62	-	11
2	WASHER,LOCK,5/16	-	12
1	COLLAR,LOCK,7/16	290-220	13
1	ASSEMBLY,SHIM DISK,PULL,RIGHT	001-252	14
1	WASHER,THRUST,.312 X .06	032-360	15
1	PLUNGER,SPRING,1/4-20	098-120	16
1	NUT,HEX,JAM	-	17
1	BOLT,SHOULDER,3/8,1.0,5/16-18	-	18
1	NUT,HEX,5/16-18	-	19



D	C	B	A	UNLESS OTHERWISE SPECIFIED			Pro-Tech Engineering		
				TOLERANCES			2117 N. Soughton Rd., Madison, Wisconsin 53704 Phone (608) 265-8344 Fax (608) 245-6061		
7.45 10.90 10.45 10.45 10.45 10.45 10.45 10.45	10.90 10.45 10.45 10.45 10.45 10.45 10.45 10.45	10.45 10.45 10.45 10.45 10.45 10.45 10.45 10.45	10.45 10.45 10.45 10.45 10.45 10.45 10.45 10.45	TITLE		DRAWN BY	DATE	DWG SCALE	001-207
				ASSY,CYLINDER,PULL ROLL,RIGHT					
				FINES 1/16" 1/32"		TOL.		ANGLES	

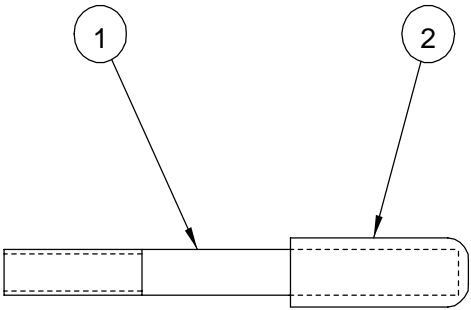


REQ'D	DESCRIPTION	PART NO.	ITEM
1	FILTER,NAF-2000-N02-C	340-250	1
1	FITTING,AIR,ELBOW,1/4NPT	330-760	2
1	COUPLE,KWIK 711	330-260	3
1	BRKT.,FILTER,B-240	100-220	4
1	FITTING, AIR, ELBOW, MALE 1/4 NPT	330-730	5
2	SHCS,10-32 x .5	-	6
1	AIR,FITTING,UNION-Y	330-305	7
13'	TUBE , PNEUMATIC, 1/4" FLAME RETARDENT	360-001	8



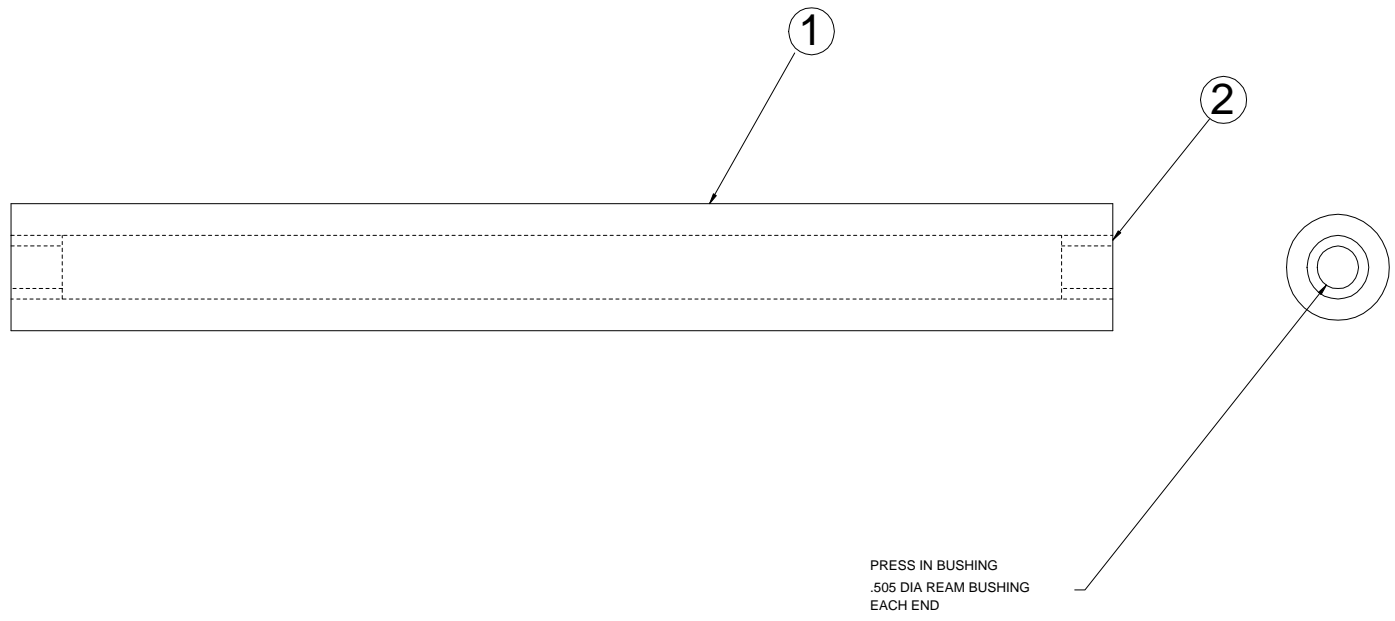
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ALL	AS SHOWN	ALL	AS SHOWN	ALL	AS SHOWN	12-9-94	K.L.	C1	001-210				
TITLE: ASSEMBLY, FILTER, AIR													001-210

REQ'D	DESCRIPTION	PART NO.	ITEM
1	HEXHEAD BOLT, MOD, 1/4-20 X 2.5	505-001	1
1	CAP,VINYL	465-014	2



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DIM. AS SHOWN		TOL.								FINISH TO BE			
X/X		P 1/64		$125\sqrt{\quad}$									
X.		P .050											
X.X		P .020											
X.XX		P .010		ANGLES P 1D		DATE:		DRAWN BY:		DWG SCALE:		Dwg:	
X.XXX		P .005				12-19-94		RAS		A1		001-217	
REVISION				TITLE: <b>ASSEMBLY,HANDLE,CAM ORCA I</b>									

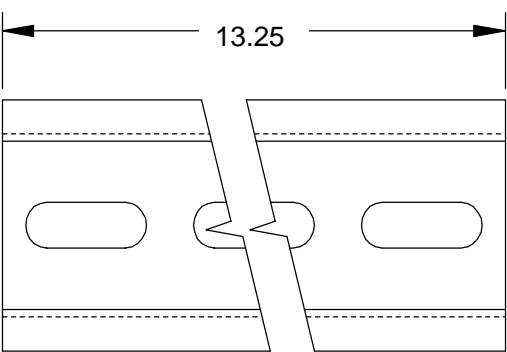
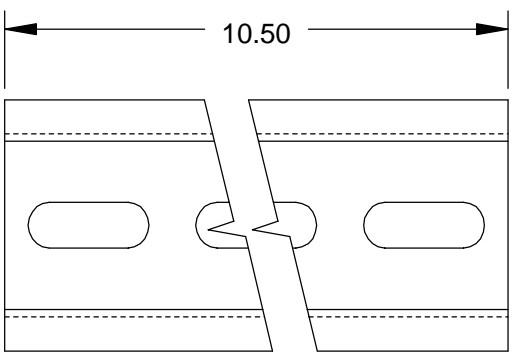
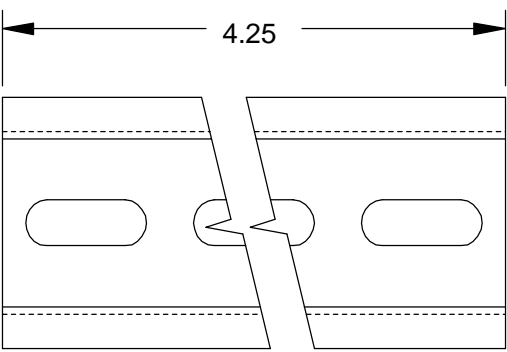
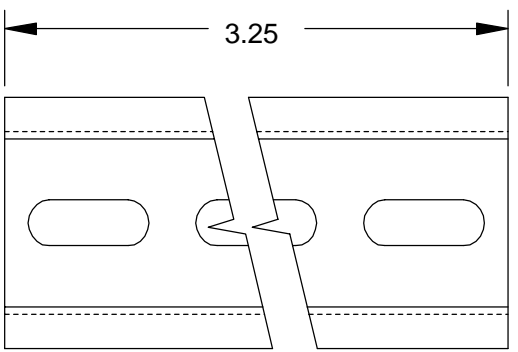
REQ'D	DESCRIPTION	PART NO.	ITEM
1	IDLER,INFEED,PAPER	620-013	1
2	BUSHING,BRONZ,.5 X .75 X .625	040-026	2




UNLESS OTHERWISE SPECIFIED TOLERANCE				Pro-Tech Engineering			
2117 N. Slaughter Rd. Madison, Wisconsin 53704 Phone (608) 248-8844 Fax (608) 248-8845				TITLE: ASSEMBLY, IDLER, INFEED, PAPER ORCA 1			
DATE: 12-15-94		DRAWN BY: RAS		DWG SCALE: C1		Dwg: 001-218	

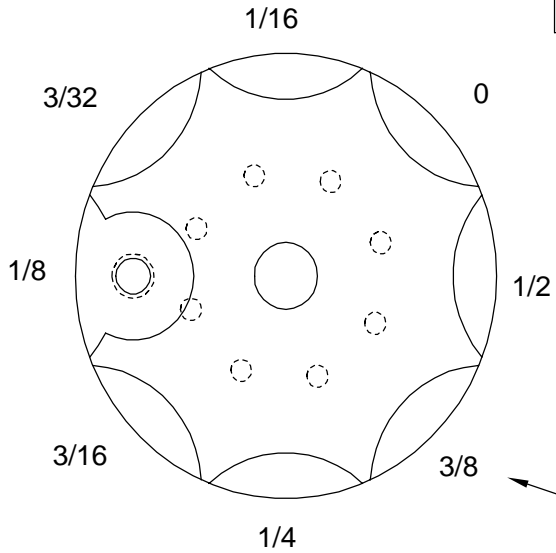
REQ'D	DESCRIPTION	PART NO.	ITEM
-	DIN RAIL	217-200	-

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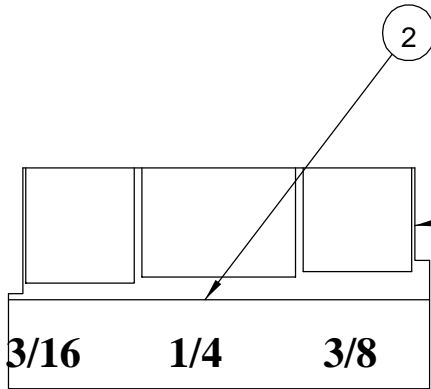


SHEET 1 OF 1			 4151 Anderson Road, DeForest, Wisconsin 53532 Phone (608) 246-8844 Fax (608) 246-8645				
UNLESS OTHERWISE SPECIFIED TOLERANCE							
REVISION	DIM. AS SHOWN	TOL.	FINISH TO BE	TITLE: <b>SET, DIN RAIL ORCA I</b>			
	X/X	P 1/64	125√				
	X.	P .050					
	X.X	P .020					
	X.XX	P .010	ANGLES P 1D	DATE: 7-19-96	DRAWN BY: RLM	SCALE: 1/1	SIZE: A
X.XXX	P .005		RELEASE NO.				

REQ'D	DESCRIPTION	PART NO.	ITEM
1	SHIM DISK	720-019	1
1	OVERLAY,SHIM DISK,MAIN ROLL	450-021	2

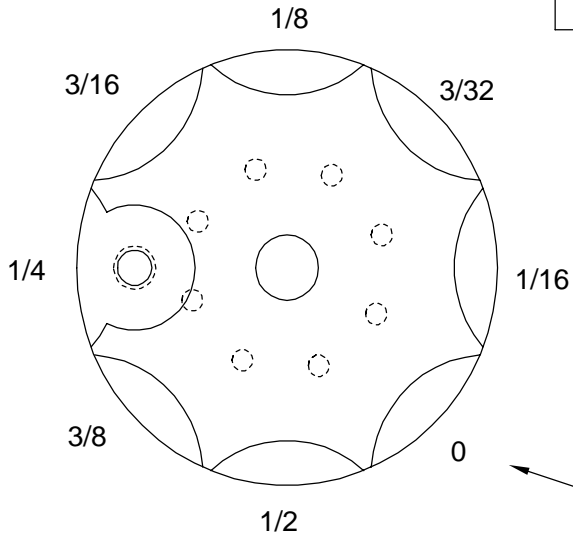


INDICATES POSITION OF LABEL  
AROUND CIRCUMFERENCE

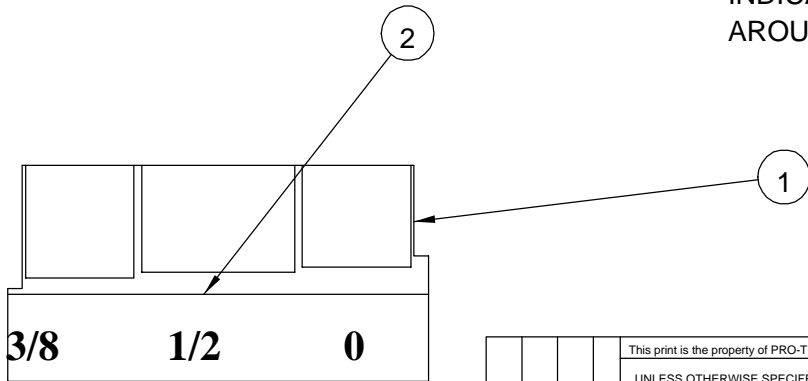


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DIM. AS SHOWN		TOL.							
X/X		P .1/64		$125\sqrt{\quad}$					
X.		P .050							
X.X		P .020							
X.XX		P .010		ANGLES P 1D		DATE: 3-01-95		DRAWN BY: RAS	
X.XXX		P .005				DWG SCALE: A1		Dwg: 001-249	
REVISION				TITLE: <b>ASSEMBLY,SHIM DISK,MAIN LEFT</b> <b>ORCA I</b>					

REQ'D	DESCRIPTION	PART NO.	ITEM
1	SHIM DISK	720-019	1
1	OVERLAY,SHIM DISK,MAIN ROLL	450-021	2

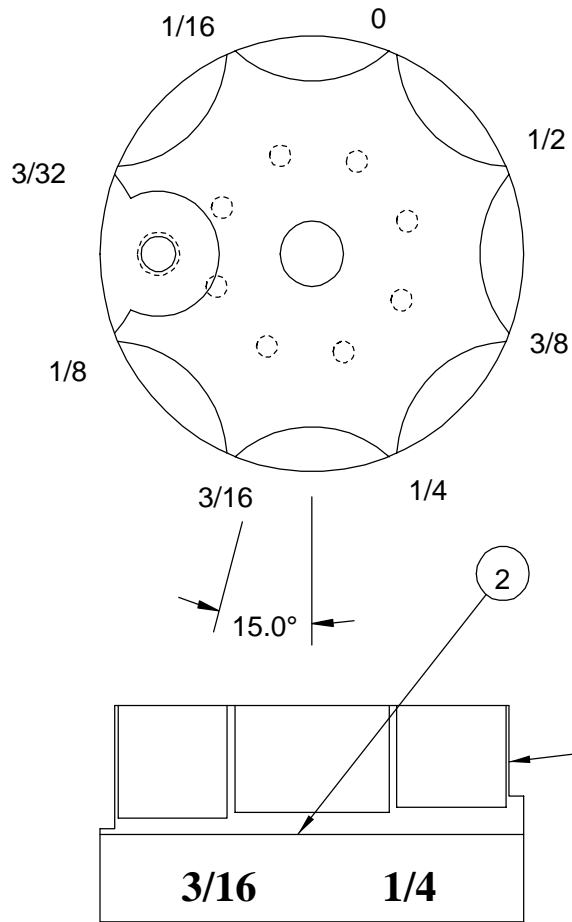


INDICATES POSITION OF LABEL  
AROUND CIRCUMFERENCE



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DIM. AS SHOWN	TOL.	FINISH TO BE				
X/X	P 1/64	125√				
X.	P .050					
X.X	P .020					
X.XX	P .010	ANGLES P 1D	DATE:	DRAWN BY:	DWG SCALE:	Dwg:
X.XXX	P .005		3-01-95	RAS	A1	001-250

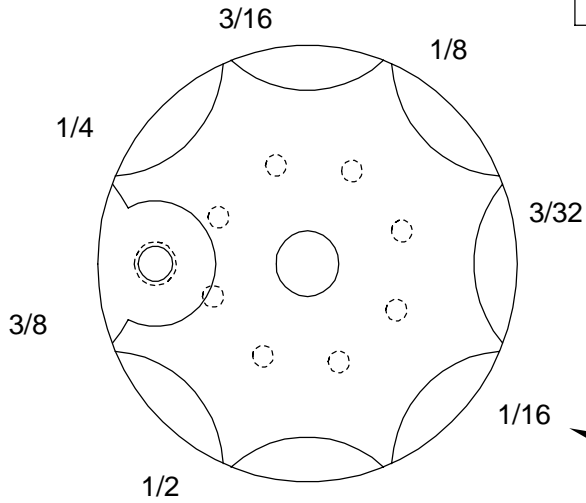
REQ'D	DESCRIPTION	PART NO.	ITEM
1	SHIM DISK	720-019	1
1	OVERLAY,SHIM DISK,MAIN ROLL	450-021	2



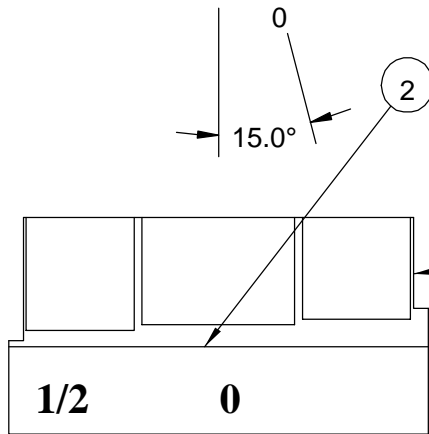
INDICATES POSITION OF LABEL AROUND CIRCUMFERENCE

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UNLESS OTHERWISE SPECIFIED TOLERANCE			<b>Pro-Tech Engineering</b> 2117 N. Stoughton Rd. Madison, Wisconsin 53704 Phone (608) 246-8844 Fax (608) 246-8645
DIM. AS SHOWN	TOL.	FINISH TO BE	
X/X	P .1/64	125√	TITLE: <b>ASSEMBLY,SHIM DISK,PULL,LEFT ORCA I</b>
X.	P .050		
X.X	P .020	ANGLES P 1D	DATE: 3-01-95 DRAWN BY: RAS DWG SCALE: A1 Dwg: 001-251
X.XX	P .010		
X.XXX	P .005		

REQ'D	DESCRIPTION	PART NO.	ITEM
1	SHIM DISK	720-019	1
1	OVERLAY,SHIM DISK,MAIN ROLL	450-021	2



INDICATES POSITION OF LABEL AROUND CIRCUMFERENCE



UNLESS OTHERWISE SPECIFIED TOLERANCE				Pro-Tech Engineering			
DIM. AS SHOWN	TOL.	FINISH TO BE	125√	2117 N. Stoughton Rd. Madison, Wisconsin 53704 Phone (608) 246-8844 Fax (608) 246-8645			
X/X	P .1/64	125√		TITLE: ASSEMBLY,SHIM DISK,PULL,RIGHT ORCA I			
X.	P .050						
X.X	P .020	ANGLES P 1D	DATE:	DRAWN BY:	DWG SCALE:	Dwg:	001-252
X.XX	P .010		3-01-95	RAS	A1		
X.XXX	P .005						



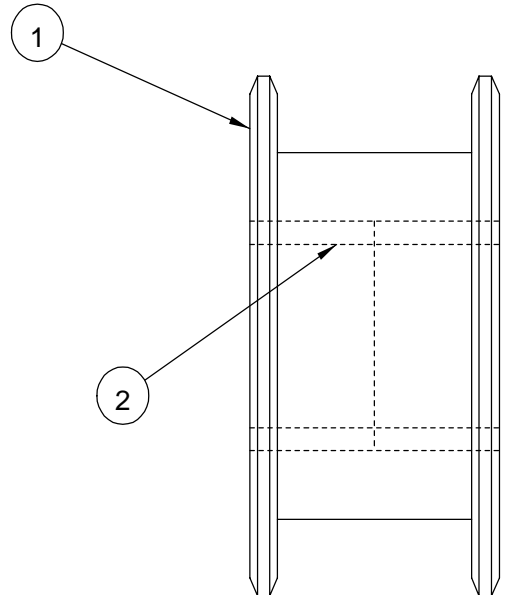
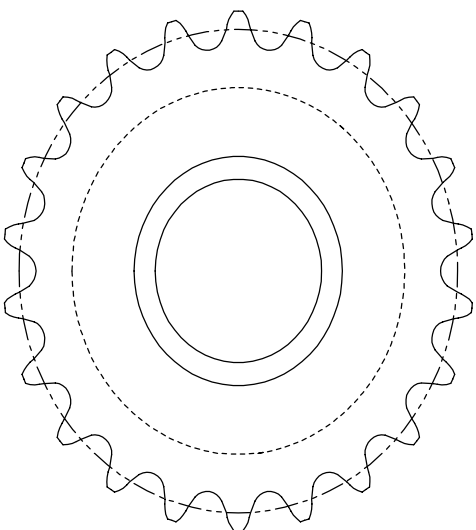
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REQ'D	DESCRIPTION	PART NO.	ITEM
1	TOWEL,WHITE	475-950	1
			2
1	ZIPPY KNIFE	475-620	3
1	ALLEN WRENCH SET	475-230	4
4	LEVELING PAD	470-101	5
3	FUSE 3A,250	186-200	6
1	TAPE MEASURE	475-100	7
			8
1	RUBBER CEMENT	930320	9
1	MASKING TAPE	475-000	10
1	BOX ACCESSORY	475-010	11
1	MANUAL	930404	12
2	'O'-RING	480-005	13
1	PAD,FELT	375-000	14
1	UW/RW MOUNTED BRAKE	625-006	15

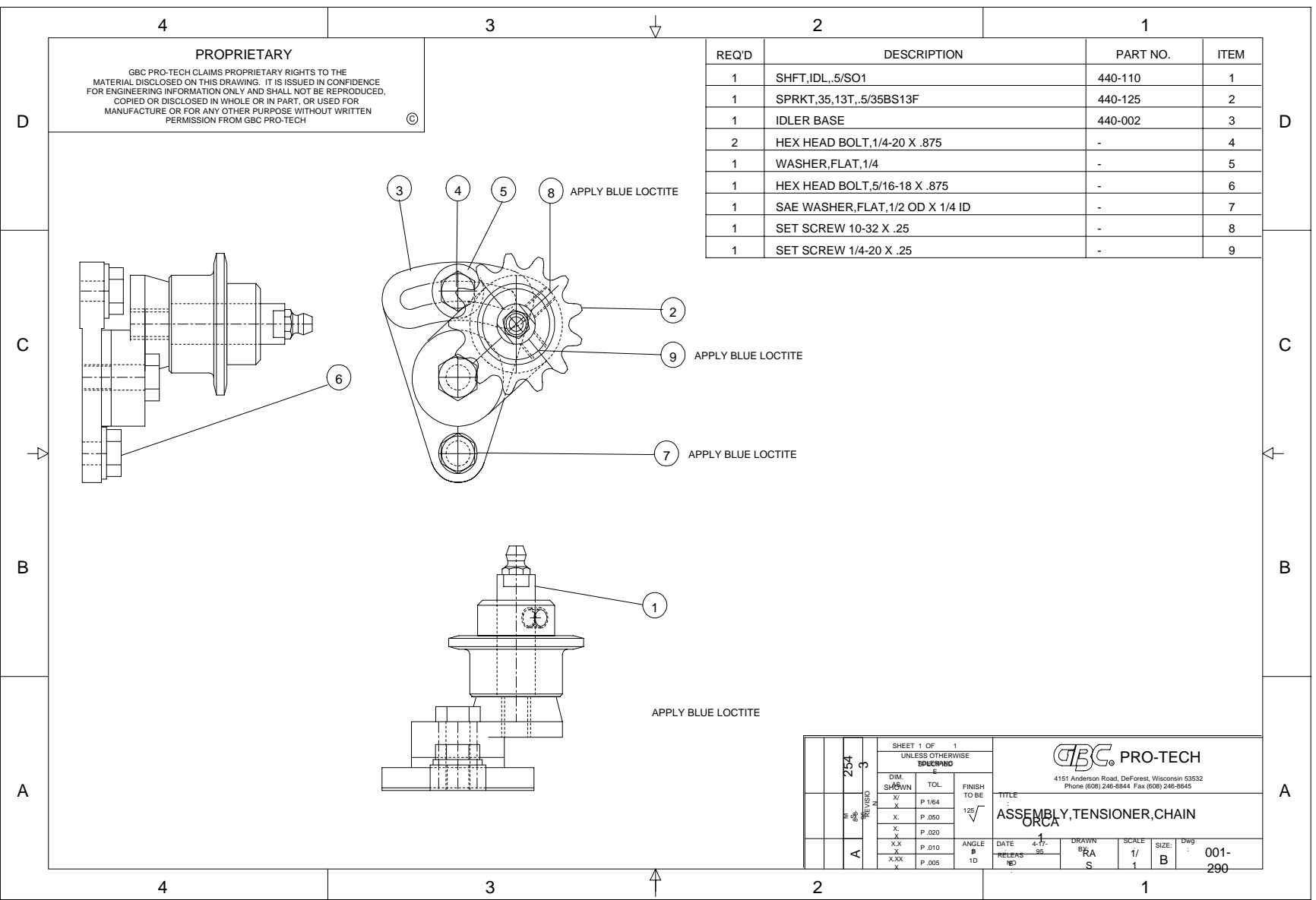


SHEET 1 OF 1		UNLESS OTHERWISE SPECIFIED TOLERANCE		 4151 Anderson Road, DeForest, Wisconsin 53532 Phone (608) 246-8844 Fax (608) 246-8645	
DIM. AS SHOWN	TOL.	FINISH TO BE	TITLE:		
X/X	P 1/64	125√	ACCESSORY KIT ORCA 1		
X.	P .050				
X.X	P .020	ANGLES P 1 D	DATE: 3-06-95	DRAWN BY: RAS	SCALE: 1/1
X.XX	P .010		RELEASE NO.	SIZE: A1	Dwg: 001-271
X.XXX	P .005				

REQ'D	DESCRIPTION	PART NO.	ITEM
1	SPROCKET,DRIVE,MODIFIED	750-000	1
2	BEARING,NEEDLE	028-002	2



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DIM. AS SHOWN	TOL.	FINISH TO BE							
X/X	P 1/64	125√							
X.	P .050								
X.X	P .020								
X.XX	P .010	ANGLES P 1D			DATE:	DRAWN BY:	DWG SCALE:	Dwg:	
X.XXX	P .005				4-13-95	RAS	A1	001-289	
REVISION					TITLE:				
					ASSEMBLY,SPROCKET,DRIVE				

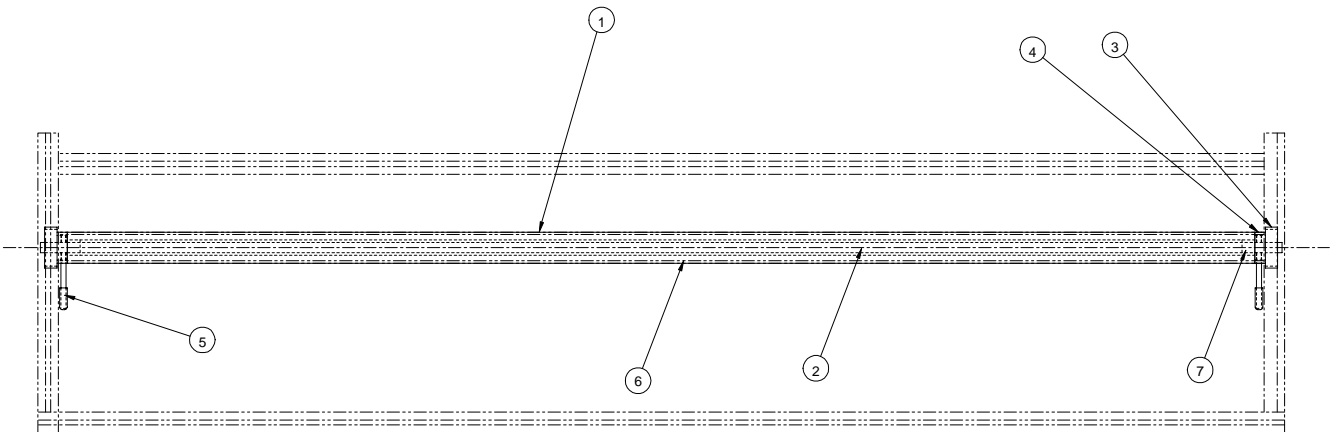


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REQD	DESCRIPTION	PART NO.	ITEM
1	SHFT,IDL.,5/SO1	440-110	1
1	SPRKT,35,13T,.5/35BS13F	440-125	2
1	IDLER BASE	440-002	3
2	HEX HEAD BOLT,1/4-20 X .875	-	4
1	WASHER,FLAT,1/4	-	5
1	HEX HEAD BOLT,5/16-18 X .875	-	6
1	SAE WASHER,FLAT,1/2 OD X 1/4 ID	-	7
1	SET SCREW 10-32 X .25	-	8
1	SET SCREW 1/4-20 X .25	-	9

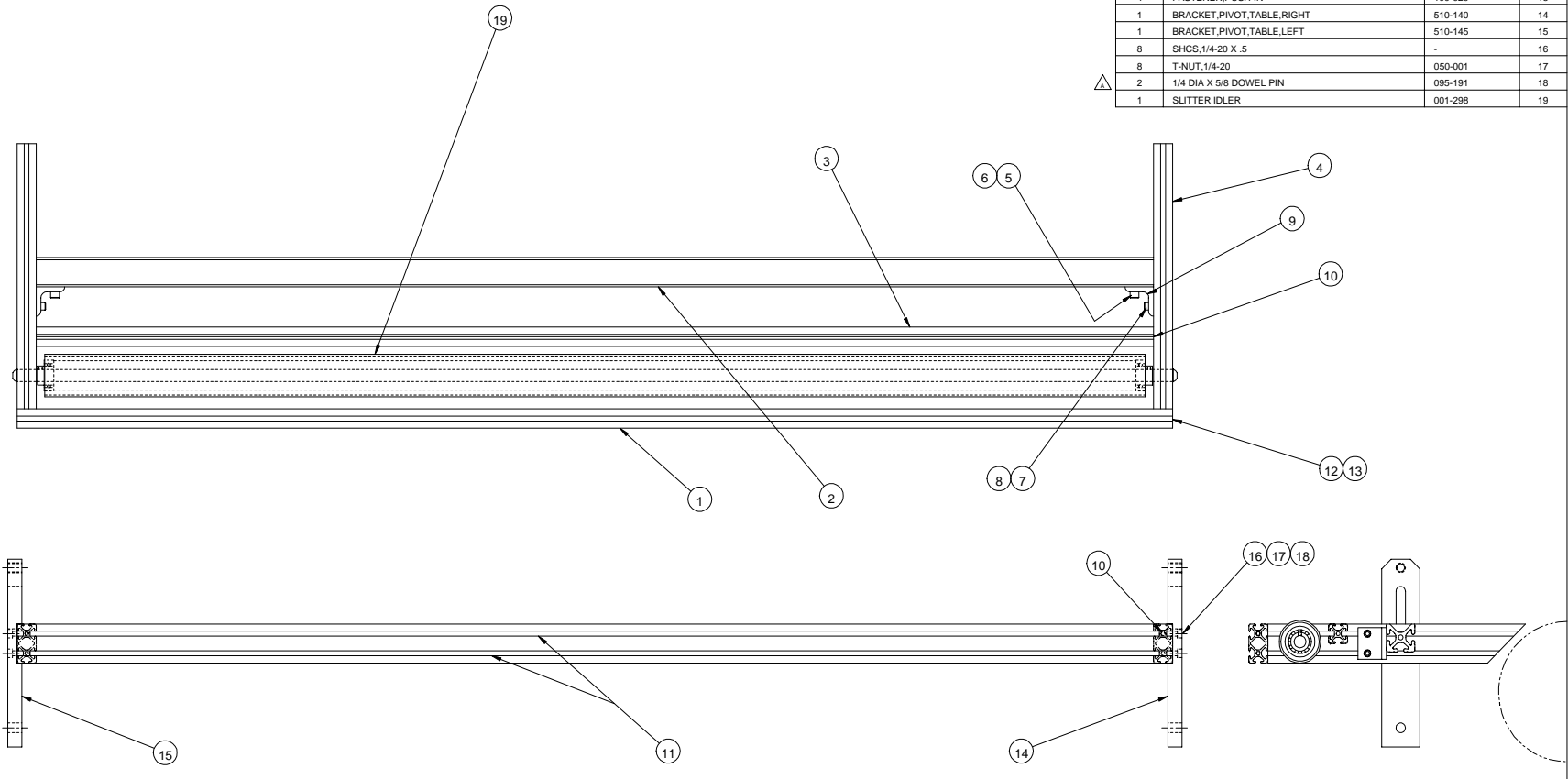
SHEET 1 OF 1 UNLESS OTHERWISE SPECIFIED		GBC PRO-TECH 4151 Anderson Road, DeForest, Wisconsin 53532 Phone (608) 246-8844 Fax (608) 246-8845	
DIM. SHOWN	TOL.	FINISH TO BE	TITLE
X	P.1/64	125	ASSEMBLY, TENSIONER, CHAIN
X	P.050		ORCA
X	P.020		
XX	P.010	ANGLE	DATE 4-17-95
XXX	P.005	# 1D	RELEASE NO
		DRAWN	SCALE
		RA S	1/1
		SIZE	DWG
		B	001-290

REQ'D	DESCRIPTION	PART NO.	ITEM
1	ASSEMBLY,IDLER,INFEED,PAPER	001-218	1
1	SHAFT,IDLER,INFEED,PAPER	710-054	2
2	CAM,LIFTING,IDLER	525-005	3
2	SET SCREW,1/4-20 X .375	-	4
2	ASSEMBLY,HANDLE,CAM	001-217	5
1	IDLER, INFEED, PAPER	620 - 013	6
2	BUSHING, BRONZE, .5 X .75 X .625	040 - 026	7



SHEET 1 OF 1		UNLESS OTHERWISE SPECIFIED TOLERANCE		 4151 Anderson Road, DeForest, Wisconsin Phone (608) 246-8844, Fax (608) 246-8845	
FINISH	TOL.	FINISH TO BE	TITLE: ASSEMBLY,IDLER,INFEED,PAPER		
XX	P 17	12	ORCA 1		
X	1/16		DATE: 5-8-95	DRAWN BY: RAS	SCALE: 1:4
X	1/32		RELEASE: 10/11	SIZE: C	Dwg: 001-294
XXX	1/64				
	1/32				
	1/64				
	1/128				
	1/256				

REQ'D	DESCRIPTION	PART NO.	ITEM
1	EXTRUSION,MOD	110-017	1
1	EXTRUSION,MOD	110-019	2
1	EXTRUSION,MOD	110-018	3
2	EXTRUSION,MOD	110-024	4
2	SHCS,5/16-18 X 5/8	-	5
2	5/16-18 ECONOMY T-NUT	050-003	6
4	SHCS,1/4-20 X 1/2	-	7
4	1/4-20 ECONOMY T-NUT	050-001	8
2	BRACKET,MOUNTING,EXTRUSION	510-128	9
6	END FASTENER,1/4-20	100-018	10
2	COVER,T-SLOT	465-013	11
2	END CAP	465-012	12
4	FASTENER,PUSH-IN	100-020	13
1	BRACKET,PIVOT,TABLE,RIGHT	510-140	14
1	BRACKET,PIVOT,TABLE,LEFT	510-145	15
8	SHCS,1/4-20 X .5	-	16
8	T-NUT,1/4-20	050-001	17
2	1/4 DIA X 5/8 DOWEL PIN	095-191	18
1	SLITTER IDLER	001-298	19

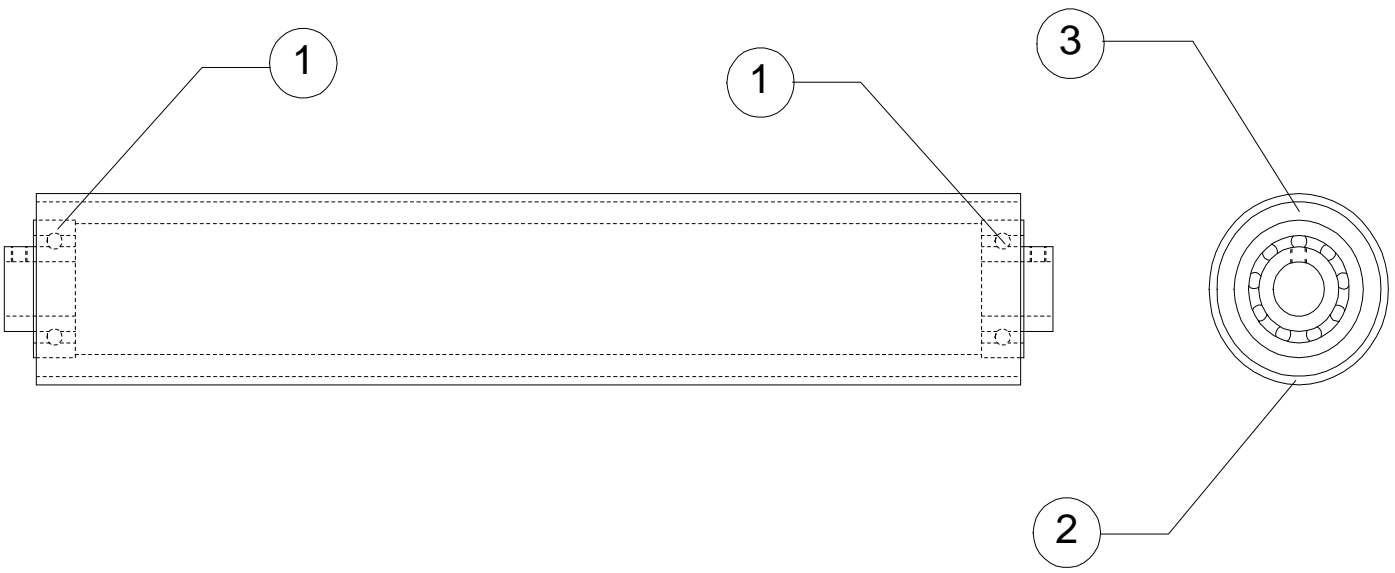


UNLESS OTHERWISE SPECIFIED		TOLERANCE		FINISH TO BE		DATE		DRAWN BY		DWG SCALE		DWG NO	
ANGLES	1:1	ANGLES	P ID	DATE	5-8-95	DRAWN BY	RAS	DWG SCALE	C4	DWG NO	001-295		
AS	±.001	AS	±.001										
CS	±.002	CS	±.002										
SS	±.003	SS	±.003										
AL	±.004	AL	±.004										
ST	±.005	ST	±.005										
BR	±.006	BR	±.006										
IN	±.007	IN	±.007										
2699	±.008	2699	±.008										
1102	±.009	1102	±.009										

Pro-Tech Engineering  
2177 N. Douglas Rd. Tempe, Arizona 85284  
Phone (602) 245-6944 Fax (602) 245-6945

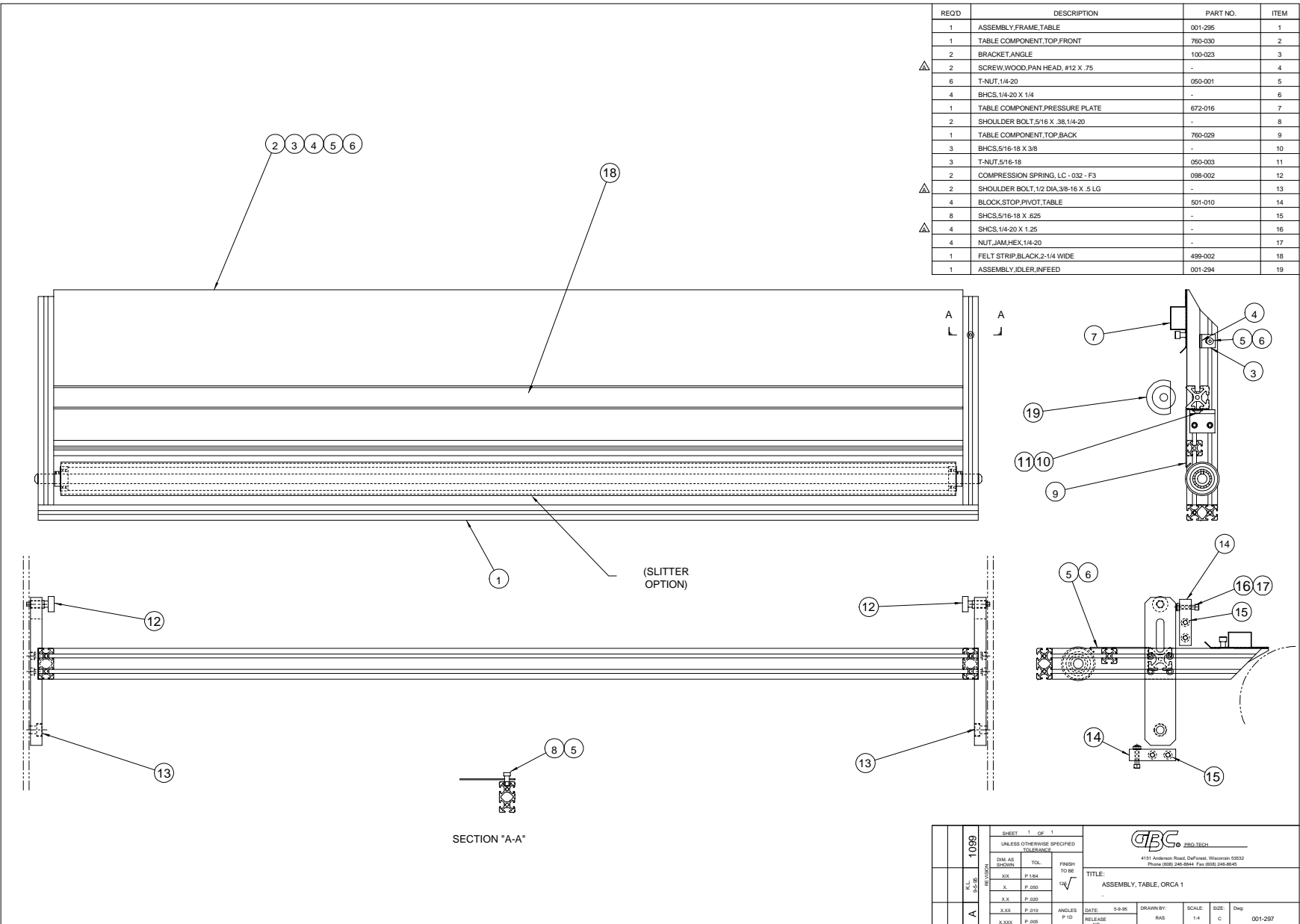
TITLE: ASSEMBLY,FRAME,TABLE,ORCA I  
ORCA I

REQ'D	DESCRIPTION	PART NO.	ITEM
2	BEARING, IDLER	020-100	1
1	TUBE, SLITTER, PVC	490-001	2
1	ROLL, IDLER	620-016	3



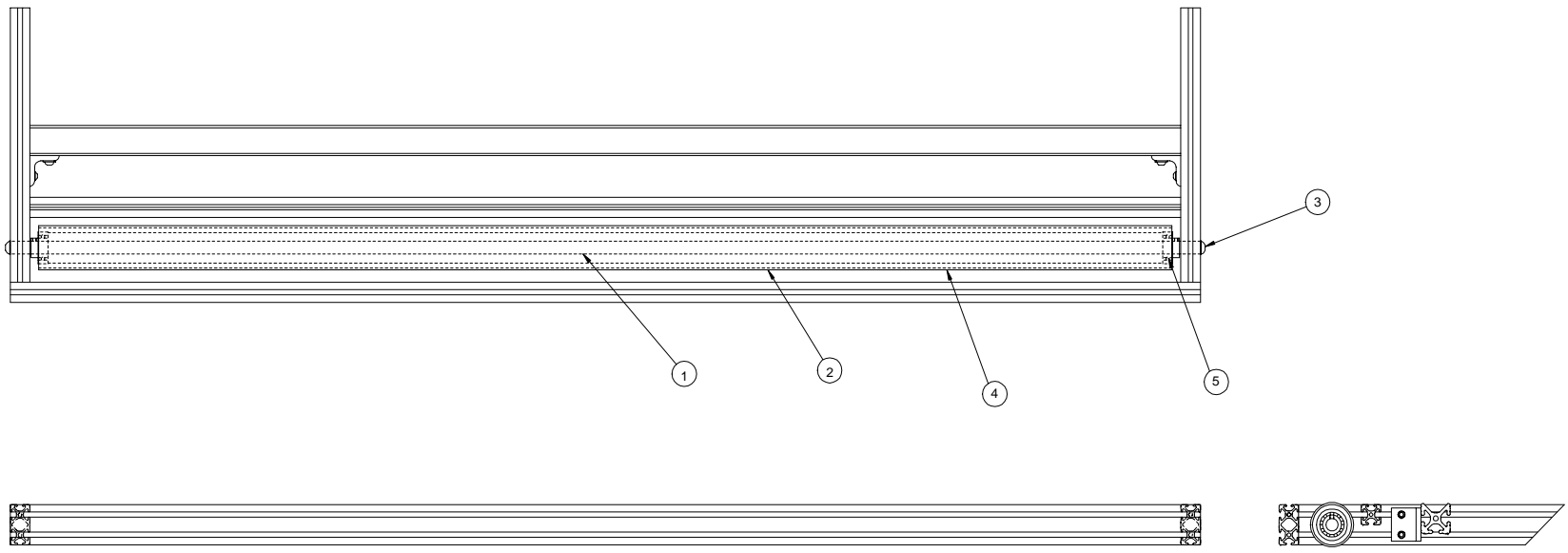
UNLESS OTHERWISE SPECIFIED TOLERANCE				Pro-Tech Engineering 2117 N. Sengstacken Rd., Madison, Wisconsin 53704 Phone (608) 246-8844 Fax (608) 246-8843			
DM, AS	TOL.	FINISH	TO BE	TITLE: ASSEMBLY, IDLER, SLITTER, PAPER ORCA I DATE: 5-08-95 DRAWN BY: RAS DWG SCALE: C1 Dwg 001-296			
.001	F .004		√				
.01	F .010						
.05	F .020						
.10	F .030						
ANGLES	F .010	DATE:	5-08-95	RAS	C1	001-296	
	F .005	P 10					

REQD	DESCRIPTION	PART NO.	ITEM
1	ASSEMBLY,FRAME,TABLE	001-295	1
1	TABLE COMPONENT, TOP,FRONT	760-030	2
2	BRACKET,ANGLE	100-023	3
Δ 2	SCREW,WOOD,PAN HEAD, #12 X .75	-	4
6	T-NUT, 1/4-20	050-001	5
4	BHCS, 1/4-20 X 1/4	-	6
1	TABLE COMPONENT,PRESSURE PLATE	672-016	7
2	SHOULDER BOLT, 5/16 X .38, 1/4-20	-	8
1	TABLE COMPONENT, TOP,BACK	760-029	9
3	BHCS, 5/16-18 X 3/8	-	10
3	T-NUT, 5/16-18	050-003	11
2	COMPRESSION SPRING, LC - 032 - F3	098-002	12
Δ 2	SHOULDER BOLT, 1/2 DIA, 3/8-16 X .5 LG	-	13
4	BLOCK,STOP,PIVOT,TABLE	501-010	14
8	SHCS, 5/16-18 X .625	-	15
Δ 4	SHCS, 1/4-20 X 1.25	-	16
4	NUT,JAM,HEX, 1/4-20	-	17
1	FELT STRIP,BLACK,2-1/4 WIDE	499-002	18
1	ASSEMBLY, IDLER, INFEED	001-294	19



SHEET 1 OF 1		UNLESS OTHERWISE SPECIFIED TOLERANCES		FINISH TO BE		DATE: 5-9-99		DRAWN BY: RAS		SCALE: 1:4		SIZE: C		Dwg: 001-297	
DIM. AS SHOWN		TOL.		TO BE		RELEASE		RAS		1:4		C		001-297	
X.X		P .154		✓											
X		P .050													
X.X		P .020													
X.XX		P .010		ANGLES											
X.XXX		P .005		P 10											

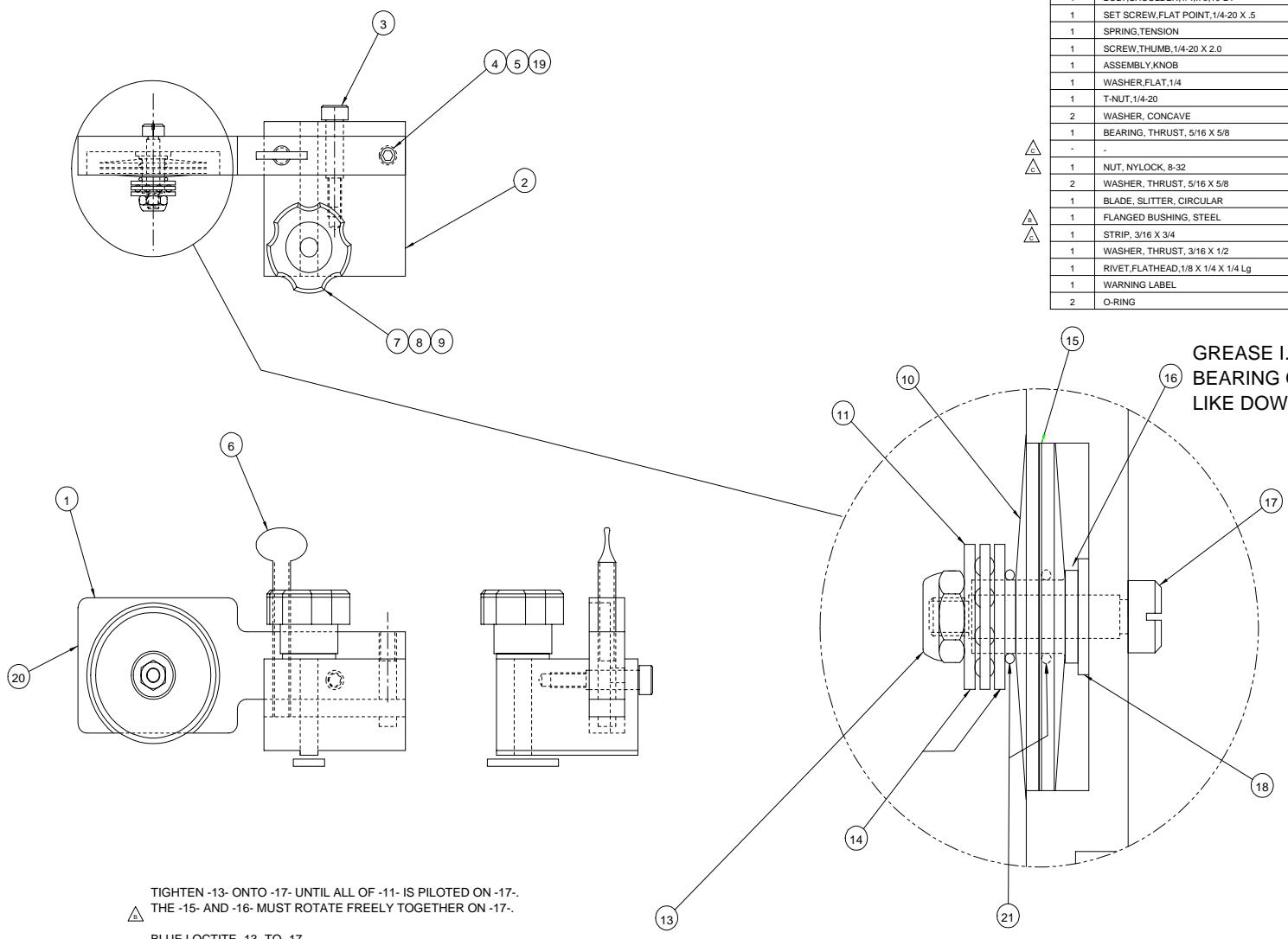
REQ'D	DESCRIPTION	PART NO.	ITEM
1	SHAFT, IDLER, SLITTER, PAPER	710-055	1
1	ASSEMBLY, IDLER, SLITTER, PAPER	001-296	2
2	BHCS, 3/8-16 X .5	-	3
1	SLITTER TUBE	490 - 001	4
2	BEARINGS IDLER	020 - 100	5



UNLESS OTHERWISE SPECIFIED									
DRG	TOL	FNIS	Pro-Tech Engineering						
ENGR	RE	RE	21000000						
APR	P.U.	LT	7100 240-3600						
X	P	V	ASSEMBLY, SLITTER, IDLER						
X	P		ORCA I						
X	P								
X.X	P	ANGLE	DAT	DRAWN	DWG	Dwg			
X.XX	P	10	5-9-95	RAS	C4	001-298			



REQ'D	DESCRIPTION	PART NO.	ITEM
1	ARM,SLITTER	740-008	1
1	BLOCK,PIVOT,SLITTER,INFEED	740-009	2
1	BOLT,SHOULDER,1/4,.75,10-24	-	3
1	SET SCREW,FLAT POINT,1/4-20 X .5	-	4
1	SPRING,TENSION	089-150	5
1	SCREW,THUMB,1/4-20 X 2.0	092-130	6
1	ASSEMBLY,KNOB	001-314	7
1	WASHER,FLAT,1/4	-	8
1	T-NUT,1/4-20	050-001	9
2	WASHER, CONCAVE	740-007	10
1	BEARING, THRUST, 5/16 X 5/8	032-003	11
-	-	-	12
1	NUT, NYLOCK, 8-32	-	13
2	WASHER, THRUST, 5/16 X 5/8	032-004	14
1	BLADE, SLITTER, CIRCULAR	475-001	15
1	FLANGED BUSHING, STEEL	040-037	16
1	STRIP, 3/16 X 3/4	050-032	17
1	WASHER, THRUST, 3/16 X 1/2	032-005	18
1	RIVET,FLATHEAD,1/8 X 1/4 X 1/4 Lg	-	19
1	WARNING LABEL	450-012	20
2	O-RING	480-030	21

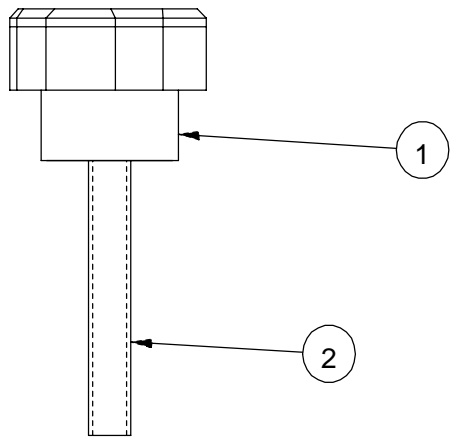


GREASE I.D. WITH BEARING GREASE LIKE DOW 44.

TIGHTEN -13- ONTO -17- UNTIL ALL OF -11- IS PILOTED ON -17-.  
 THE -15- AND -16- MUST ROTATE FREELY TOGETHER ON -17-.  
 BLUE LOCTITE -13- TO -17-.

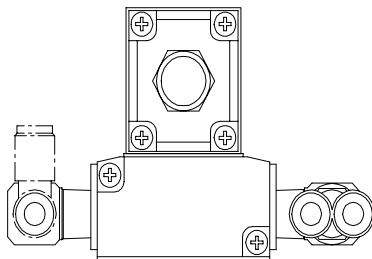
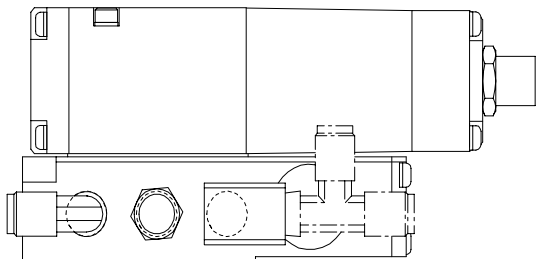
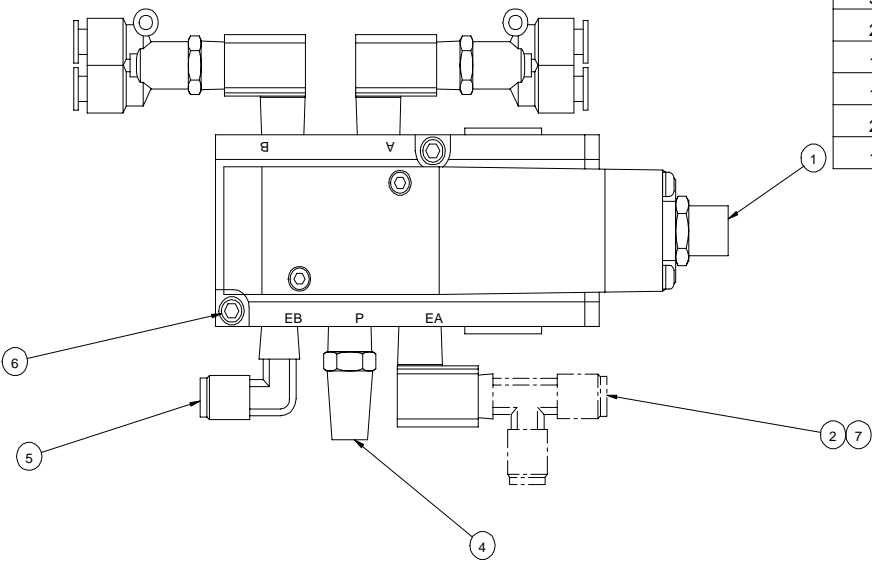
3269		3006		1123		This print is the property of PRO-TECH ENGR. The information herein is rendered in confidence.					
UNLESS OTHERWISE SPECIFIED TOLERANCE						Pro-Tech Engineering					
DRG AS SHOWN						2117 N. Douglas Rd. Melrose, MA 02126 USA Phone (617) 245-8544 Fax (617) 245-8545					
FINISH TO BE						TITLE					
.01X P.154						ASSEMBLY,SLITTER,INFEED					
.X P.050						ORCA I					
.XX P.020						DATE					
.XXX P.010						6-12-95		DRAWN BY:		DWG SCALE: Dwg	
.XXXX P.005						RAS		A1		001-299	

REQ'D	DESCRIPTION	PART NO.	ITEM
1	KNOB,KNURLED	465-007	1
1	SET SCREW,FLATPOINT,1/4-20 X 2.0	050-012	2



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UNLESS OTHERWISE SPECIFIED TOLERANCE			<p style="text-align: center;"><b>Pro-Tech Engineering</b></p> <p style="text-align: center;"><small>2117 N. Stoughton Rd. Madison, Wisconsin 53704 Phone (608) 246-8844 Fax (608) 246-8645</small></p>						
DIM. AS SHOWN	TOL.	FINISH TO BE 125√	TITLE: ASSEMBLY,KNOB,1/4-20						
X/X	P 1/64		ORCA I						
X.	P .050								
X.X	P .020			ANGLES P 1D	DATE: 7-21-95	DRAWN BY: RAS	DWG SCALE: A1	Dwg: 001-314	
X.XX	P .010								
X.XXX	P .005								
REVISION									
1065									
K.L. 8-7-95									
A									

REQ'D	DESCRIPTION	PART NO.	ITEM
1	VALVE, AIR, SOLENOID	350-115	1
3	FITTING,AIR,ELBOW,1/4NPT	330-760	2
2	Y-FITTING,1/4NPT	330-310	3
1	MUFFLER, AIR	330-280	4
1	FITTING, AIR, ELBOW, MALE 1/4 NPT	330-730	5
2	CAP SCREWS, SOCKET, #10-32 X 1-1/4 LG	-	6
1	RUN TEE T4X4	330-720	7

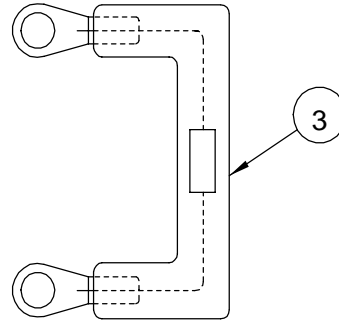
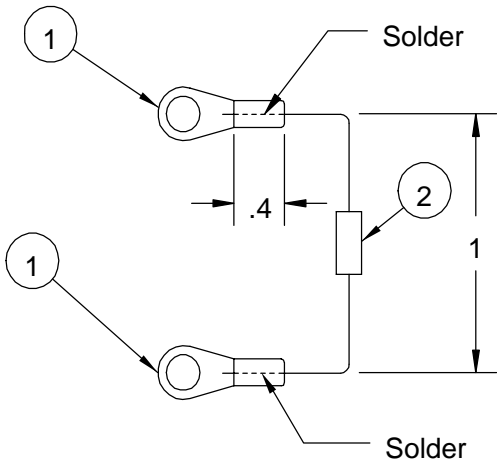


ROTATE FITTINGS AS REQUIRED FOR BEST ASSEMBLY

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UNLESS OTHERWISE SPECIFIED			<b>Pro-Tech Engineering</b> Pro-Tech Engineering Corporation Phone (800) 451-2855 Fax (800) 245-0555								
QTY	TOL	FINIS	TITLE								
Q10		PL	ASSEMBLY, VALVE, CONTROL								
Q20		PS	DATE								
Q30		1/2	10-20-95								
Q40		1/4	SECTION			BY:			DWG SCALE		
Q50		1/8	#			RAS			C 1		
Q60		1/16	ID						Dwg #		
Q70		3/32							001-329		

REQ'D	DESCRIPTION	PART NO.	ITEM
2	Connector ring	215-006	1
1	TVS 1.5KE400CA	185-004	2
1.25"	HEAT SHRINK TUBING, 1/4" X 250'	180-430	3

Apply a heat shrink tube after soldering

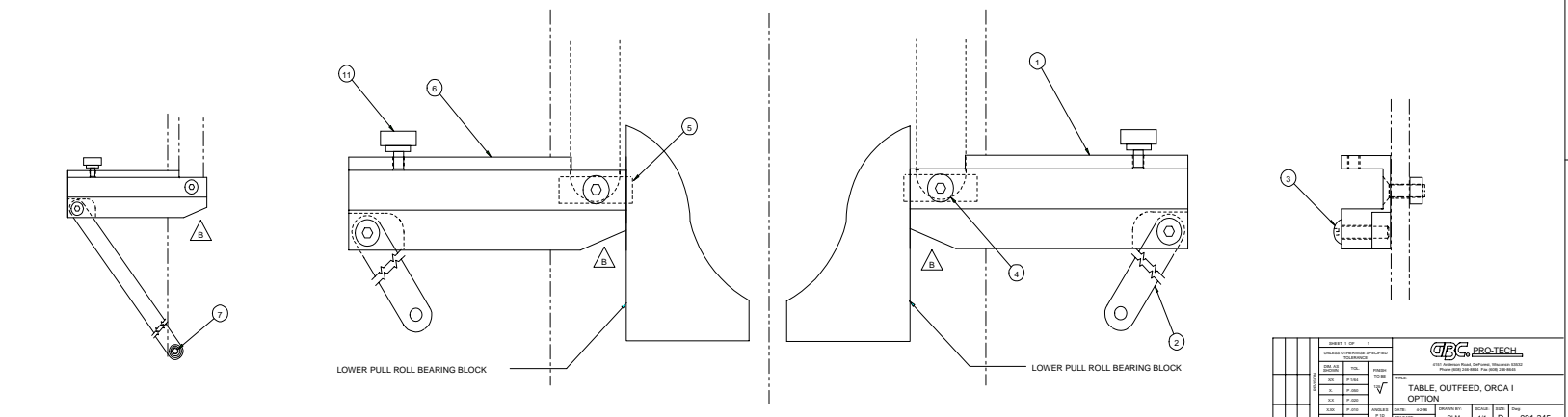
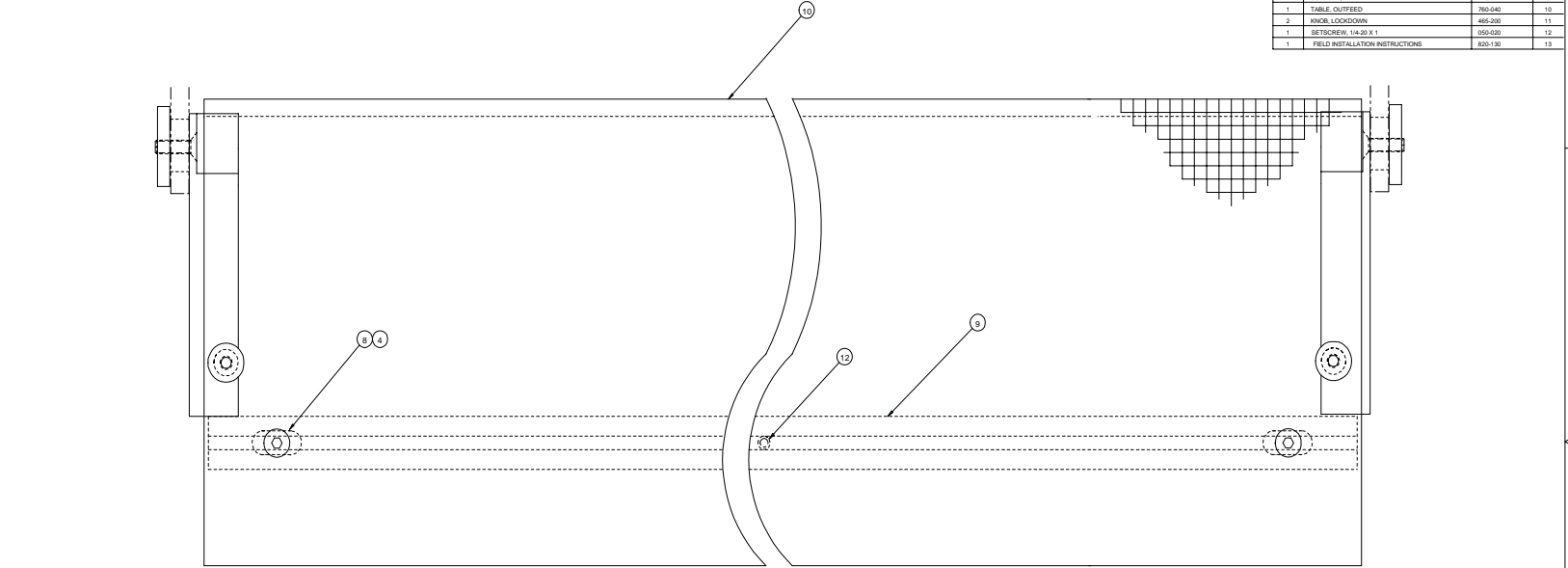


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UNLESS OTHERWISE SPECIFIED TOLERANCE				<b>Pro-Tech Engineering</b> 2117 N. Stoughton Rd. Madison, Wisconsin 53704 Phone (608) 246-8844 Fax (608) 246-8645							
DIM. AS SHOWN		TOL.								FINISH TO BE	
X.X		P .1/64		125°		TITLE: <b>ASSY, TRANS. VOLT. SUPPRESSOR ORCA I</b>					
X.		P .050									
X.X		P .020				DATE:		DRAWN BY:		DWG SCALE:	
X.XX		P .010		ANGLES P 1D		11-17-95		HZ		A1	
X.XXX		P .005								Dwg: <b>001-338</b>	

REQD	DESCRIPTION	PART NO.	ITEM
1	BRACKET TABLE REAR LEFT	510-282	1
2	SUPPORT BRACKET TABLE	787-013	2
2	BHCS 1/4-20 X 1	-	3
4	SCREW ALLEN F.T HD. 1/4-20 X 1	-	4
2	BLOCK MOUNTING CLAMP	501-014	5
1	BRACKET TABLE BR.LRT	510-283	6
2	BHCS 1/4-20 X 1	-	7
2	TIMET	350-001	8
1	SUPPORT TABLE	110-112	9
1	TABLE OUTFEED	780-040	10
2	KNOB LOCKDOWN	485-200	11
1	SCREWSH. 1/4-20 X 1	110-009	12
1	FIELD INSTALLATION INSTRUCTIONS	800-130	13

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**NOTES:**  
 1. INTERPRET DRAWING PER ASME Y14.5M-1994.



GBC PRO-TECH <small>10000 Highway 100, Houston, Texas 77036          Phone 281-280-8887 Fax 281-280-8810</small>	
TABLE OUTFEED, ORCA I OPTION	
DATE: 11/11/99	SCALE: 1/1"
DESIGNER: RLM	DWG NO: 001-345

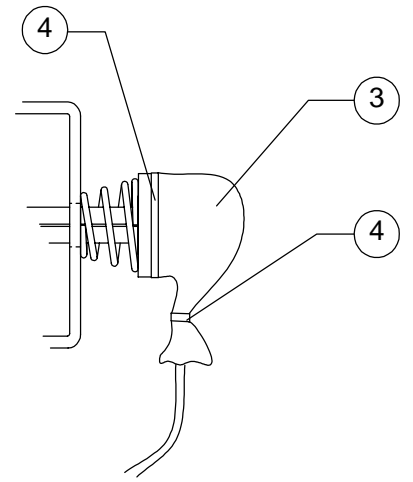
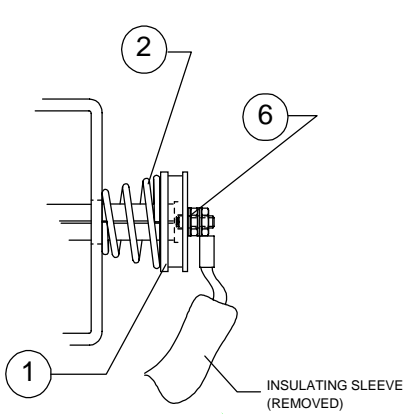
REQ'D	DESCRIPTION	PART NO.	ITEM
4	SPACER, HEATER SPRING	755-061	1
4	SPRING	089-022	2
-	SLEEVE, INSULATING	180-006	3
8	CABLE TIE, 8"	STOCK	4
1	INSTRUCTIONS, HEATER TENSION	820-063	5
4	#10 EXTERNAL LOCK WASHERS	-	6

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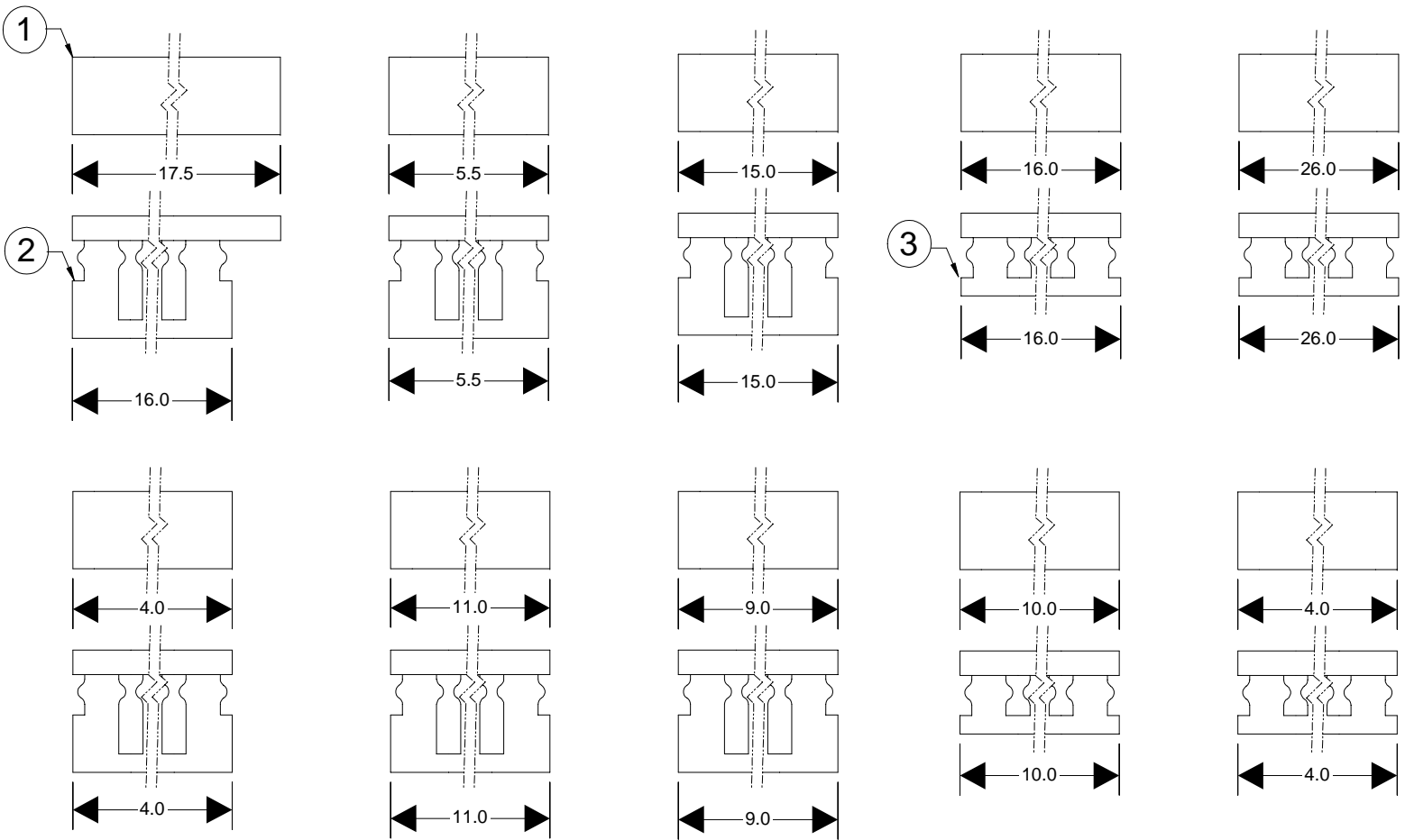
- △ A
- △ A
- △ A
- △ A
- △ A

NOTES:  
 1. PARTS ARE SHIPPED LOOSE.



		SHEET 1937 OF -		 4151 Anderson Road, DeForest, Wisconsin 53532 Phone (608) 246-8844 Fax (608) 246-8645					
		UNLESS OTHERWISE SPECIFIED TOLERANCE							
		DIM. AS SHOWN	TOL.	FINISH TO BE	TITLE: <b>KIT, HEATER TENSION                  ORCA I, ORCA I SP</b>				
		X/X	P 1/64	125					
		X.	P .050						
		X.X	P .020						
		X.XX	P .010	ANGLES P 1D		DATE: 3-21-98	DRAWN BY: BJT	SCALE: 1:1	SIZE: A
		X.XXX	P .005		RELEASE NO. 1937				

REQ'D	DESCRIPTION	PART NO.	ITEM
-	WIRE DUCT, 1" COVER, GREY	180-130	1
-	WIRE DUCT, 1" X 1.5" WITH ADHESIVE	180-140	2
-	WIRE DUCT, 1" X 1" CHANNEL WITH ADHESIVE	180-110	3



UNLESS OTHERWISE SPECIFIED TOLERANCE				<b>Pro-Tech Engineering</b> 2117 N. Slaughter Rd. Madison, Wisconsin 53754 Phone (608) 248-8844 Fax (608) 248-8845			
DIM AS SHOWN		TOL.	FINISH	TITLE			
XX	P.164			DUCT,WIRE, SET, MAIN CHASSIS			
X	P.250			ORCA I			
X.X	P.220						
.XXX	P.010			DATE	DRAWN BY:	DWG SCALE:	Dwg
X.XXX	P.205			07-10-96	RLM	C1	180-150