

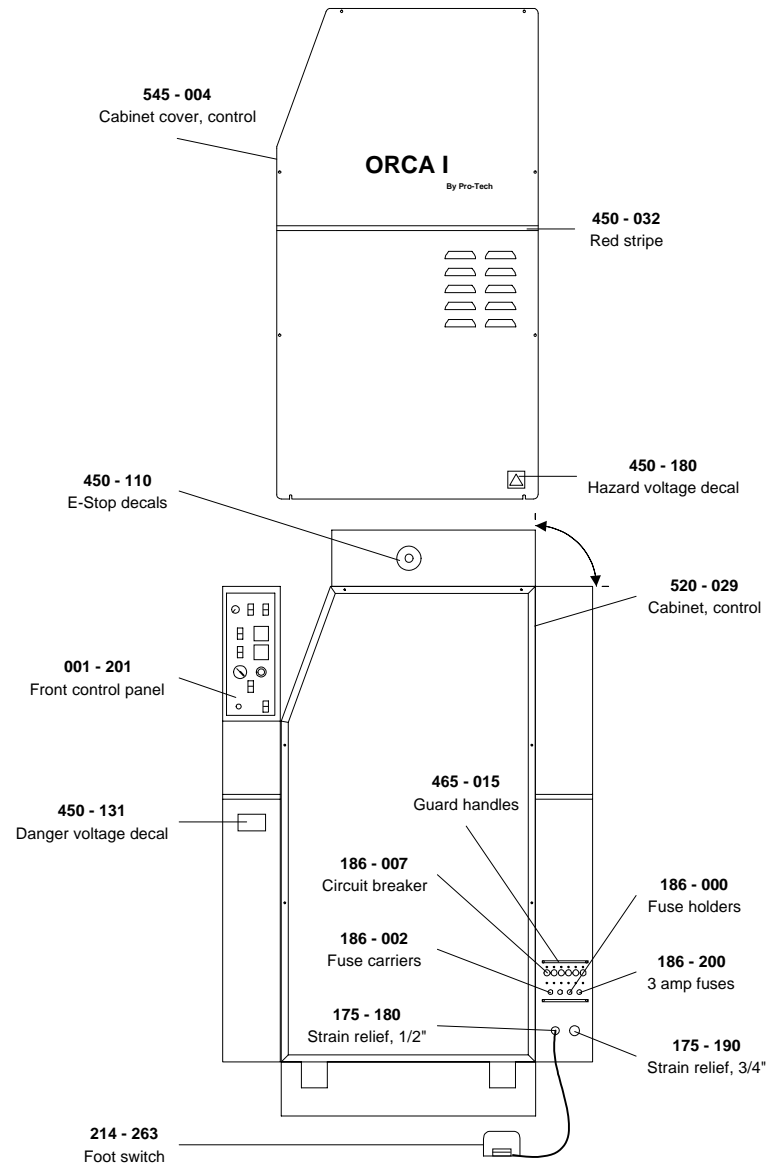
*Orca I SAE*  
*Illustrated Parts Booklet*  
*( 000 - 036 )*

*Available Options ;*

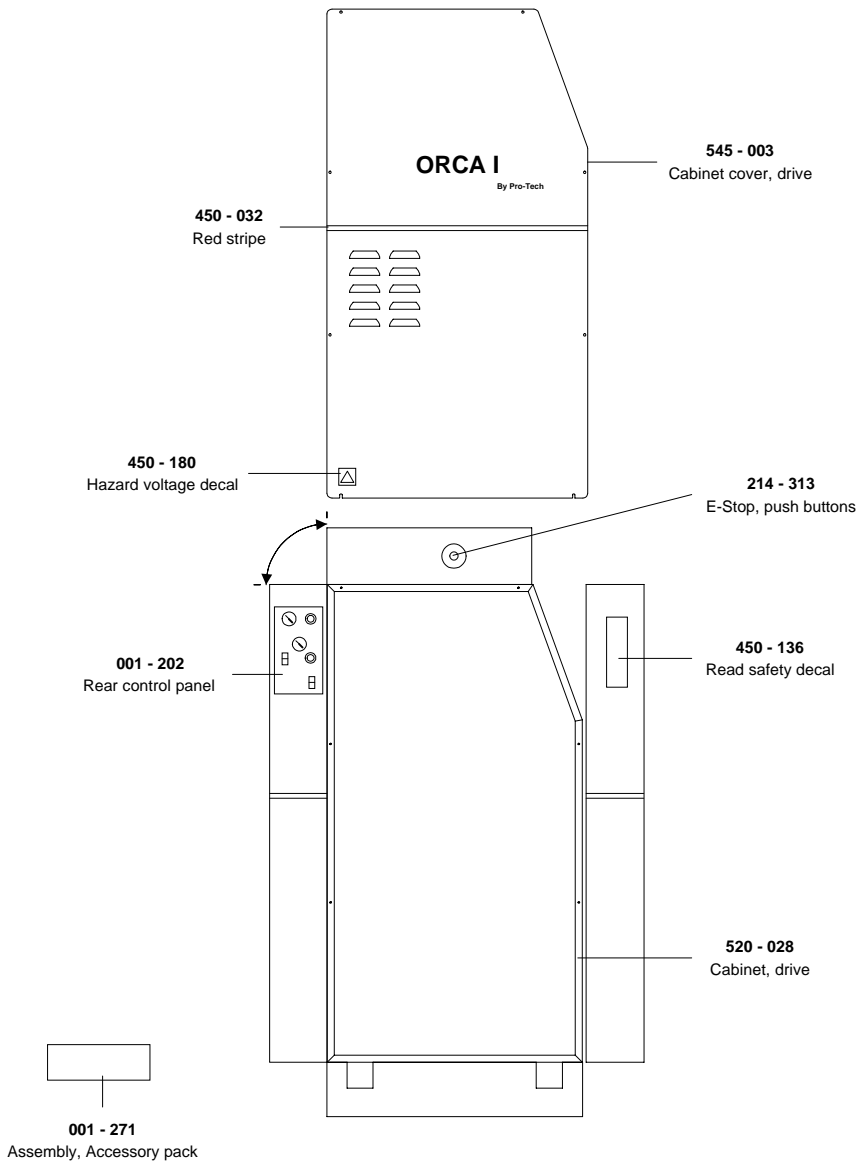
*001 - 299 ( Infeed slitters )*

*001 - 345 ( Outfeed table )*

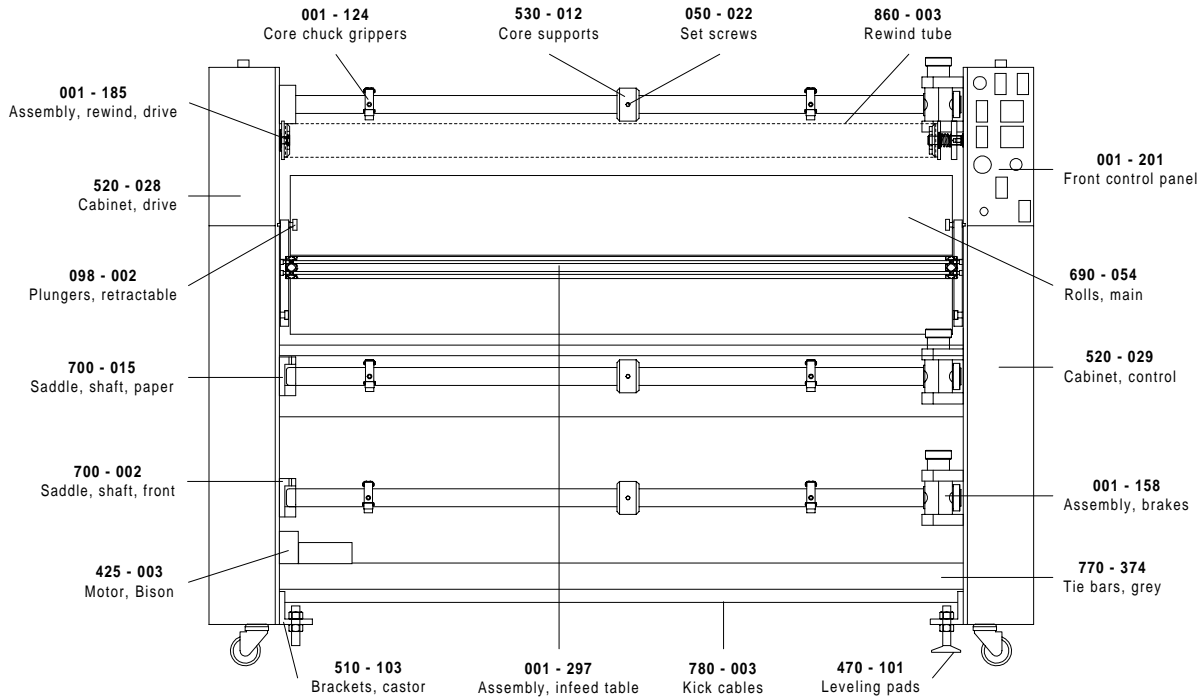
### Control Side



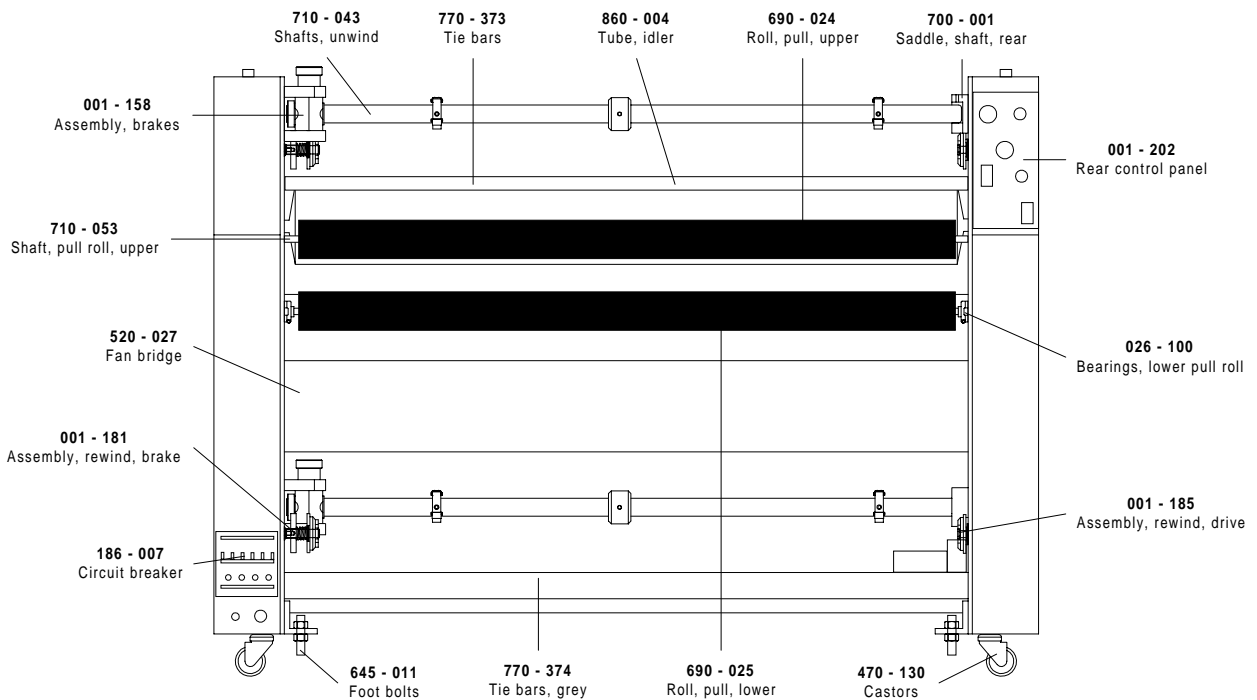
### Drive Side

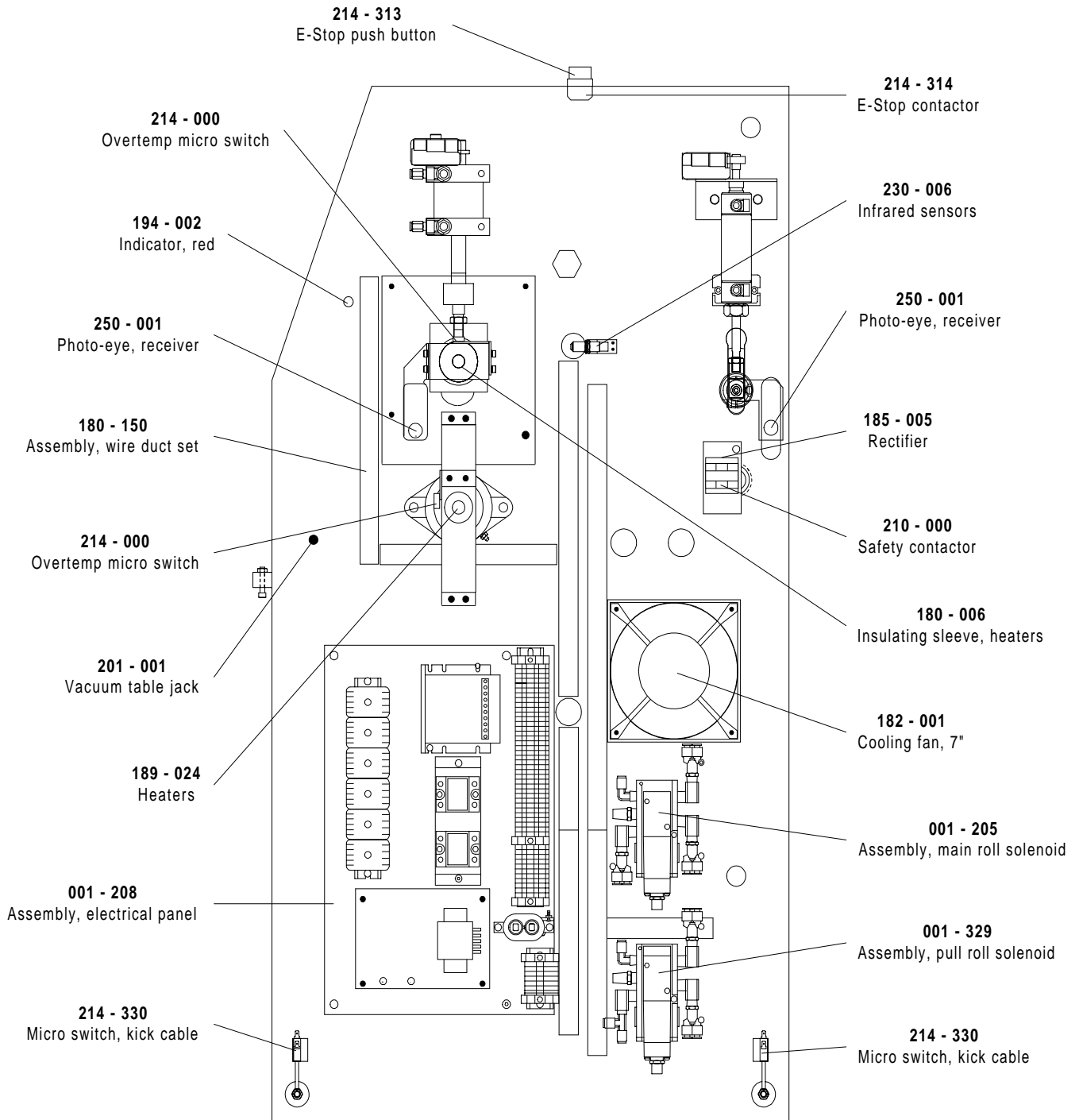


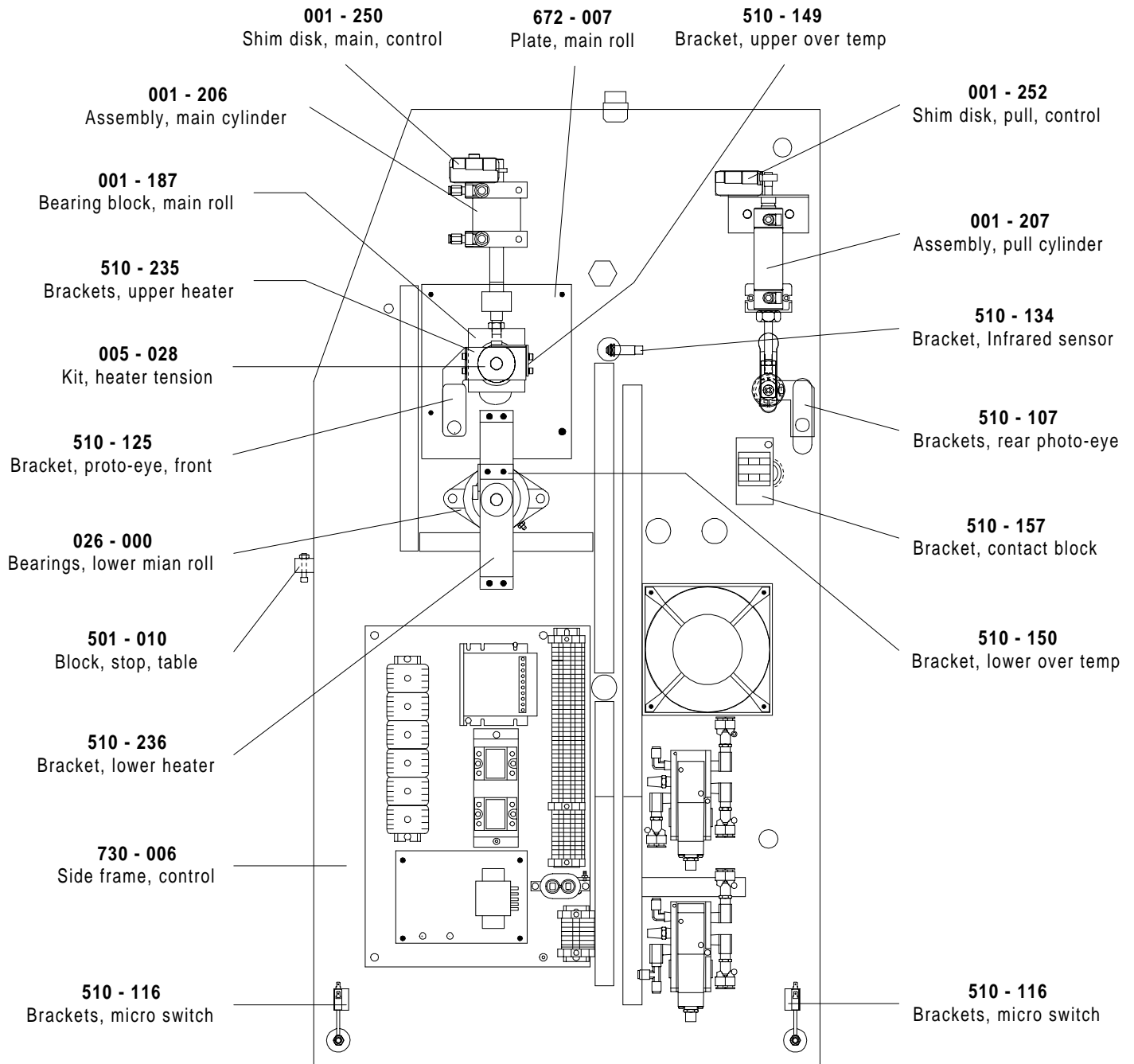
Front View

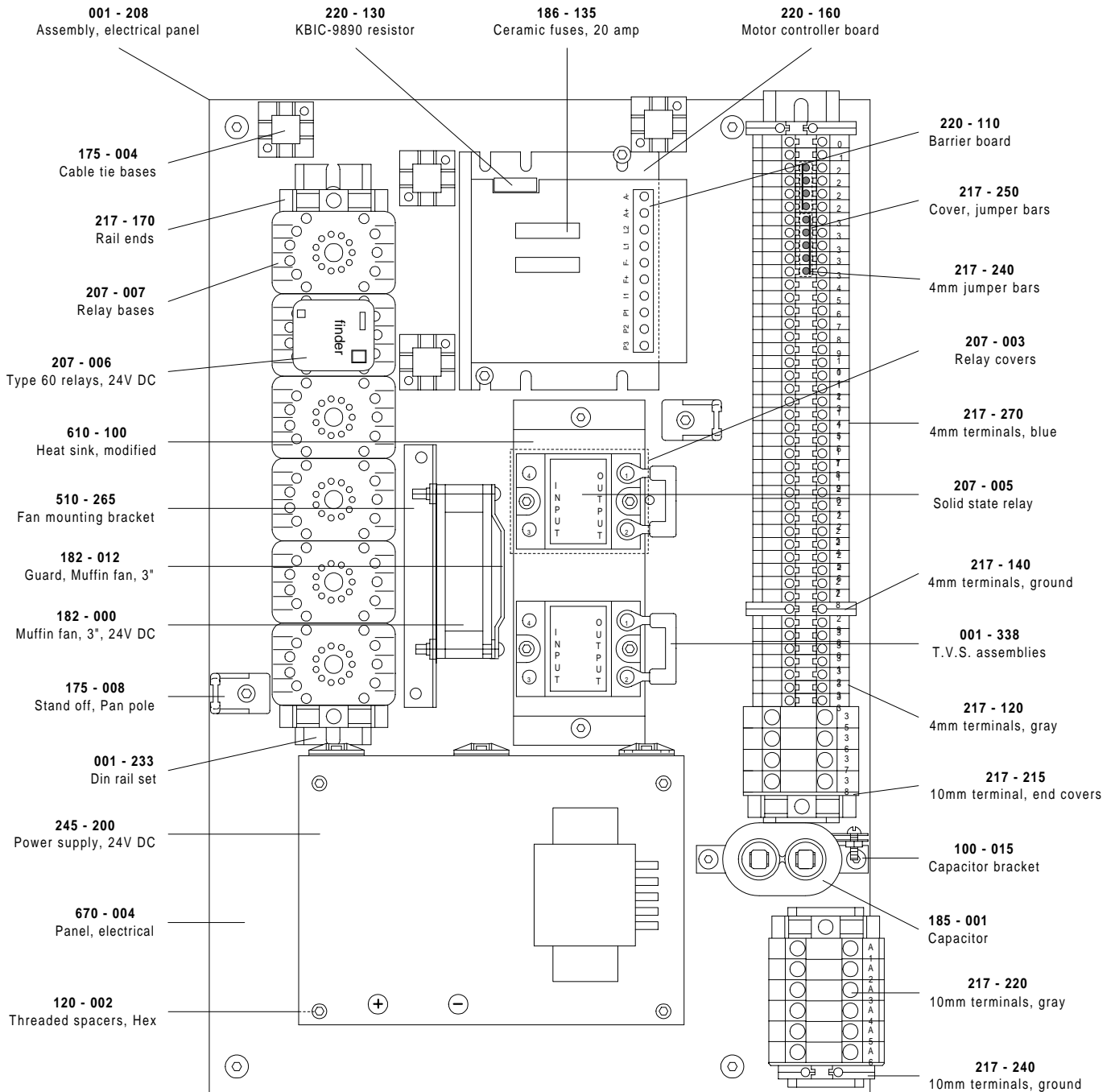


Rear View

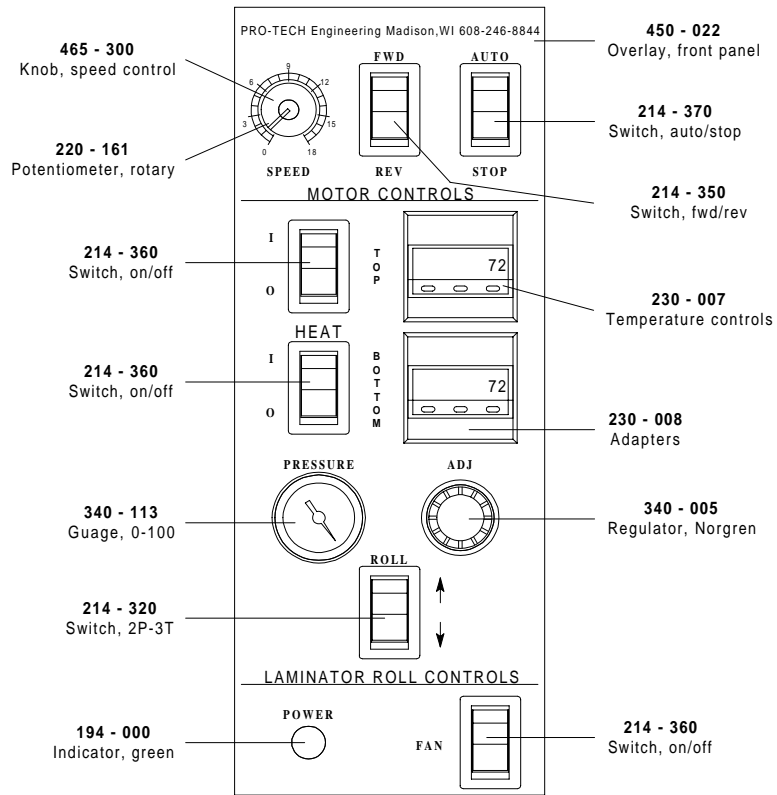




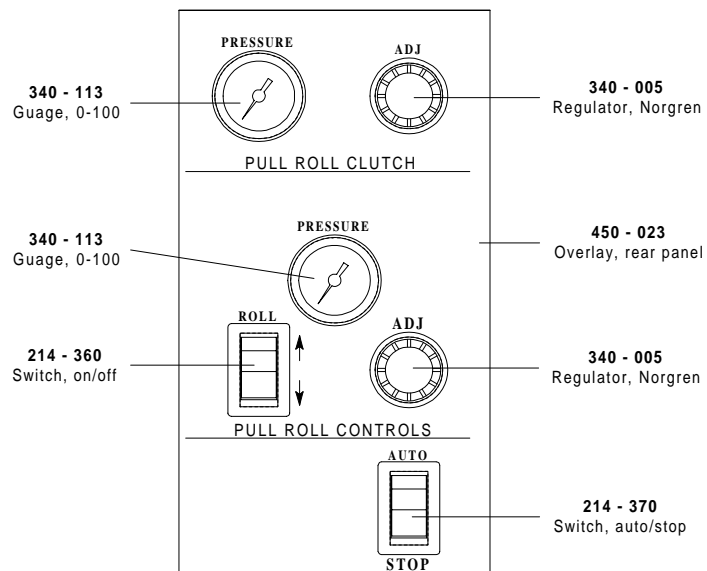


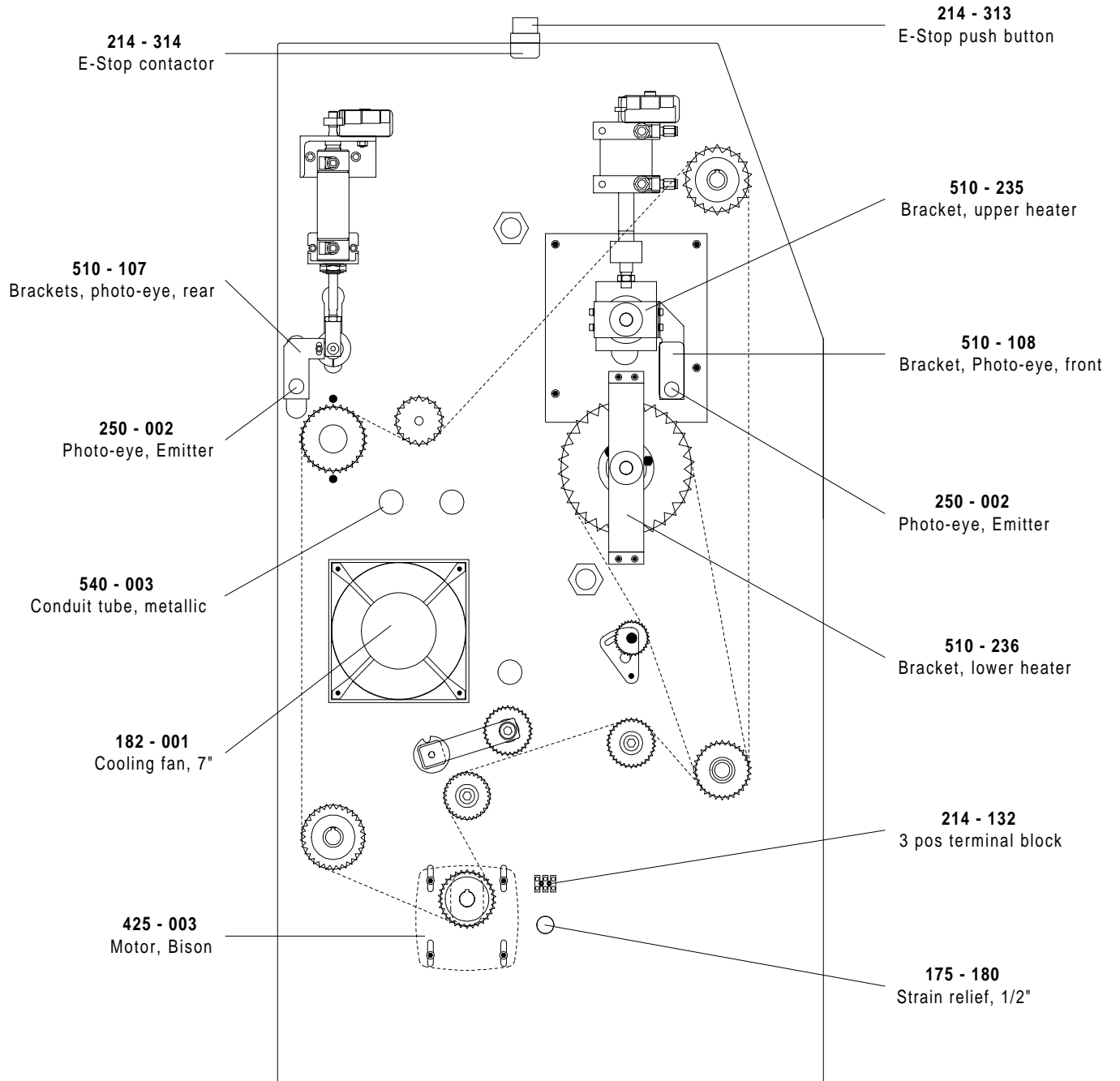


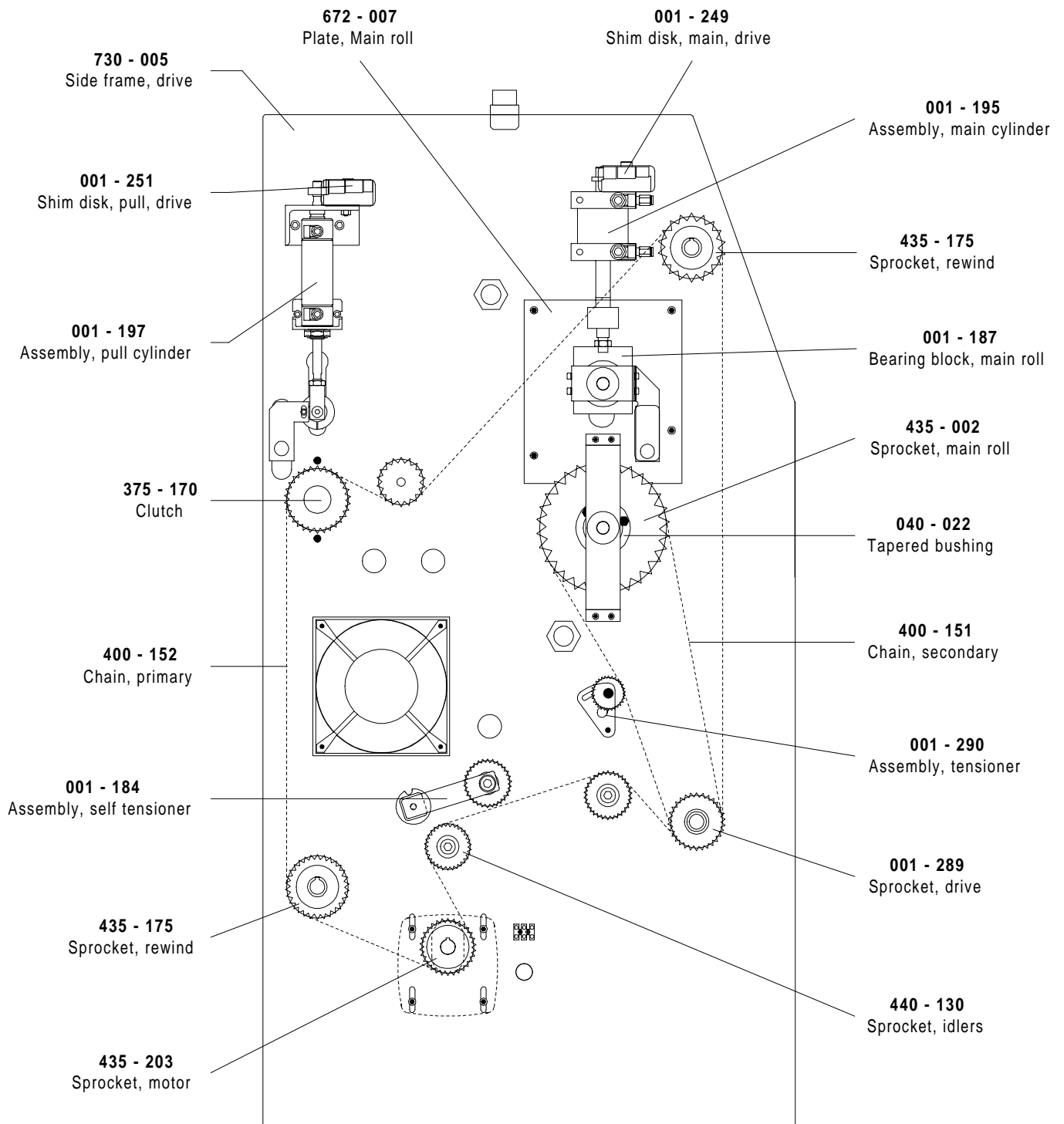
001 - 201 Front Control Panel



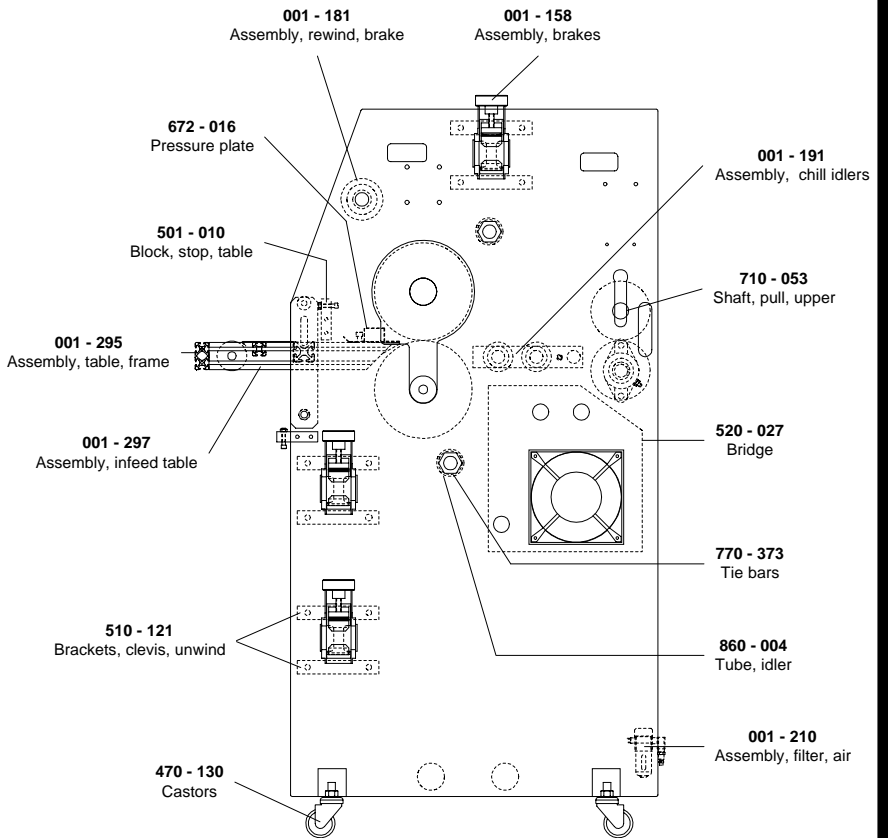
001 - 202 Rear Control Panel



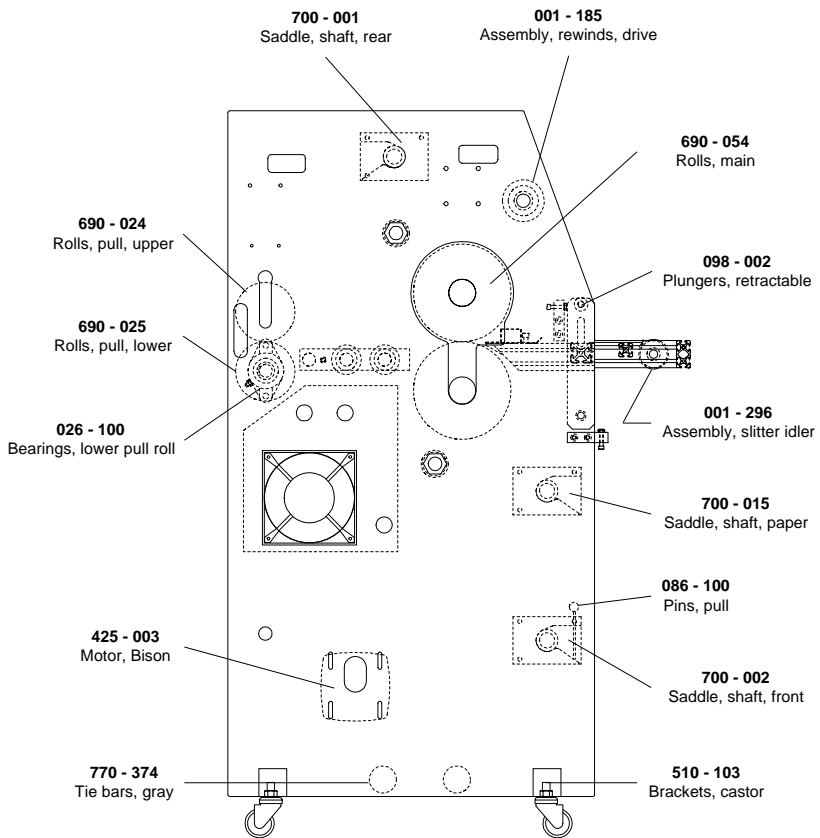




## Control Side

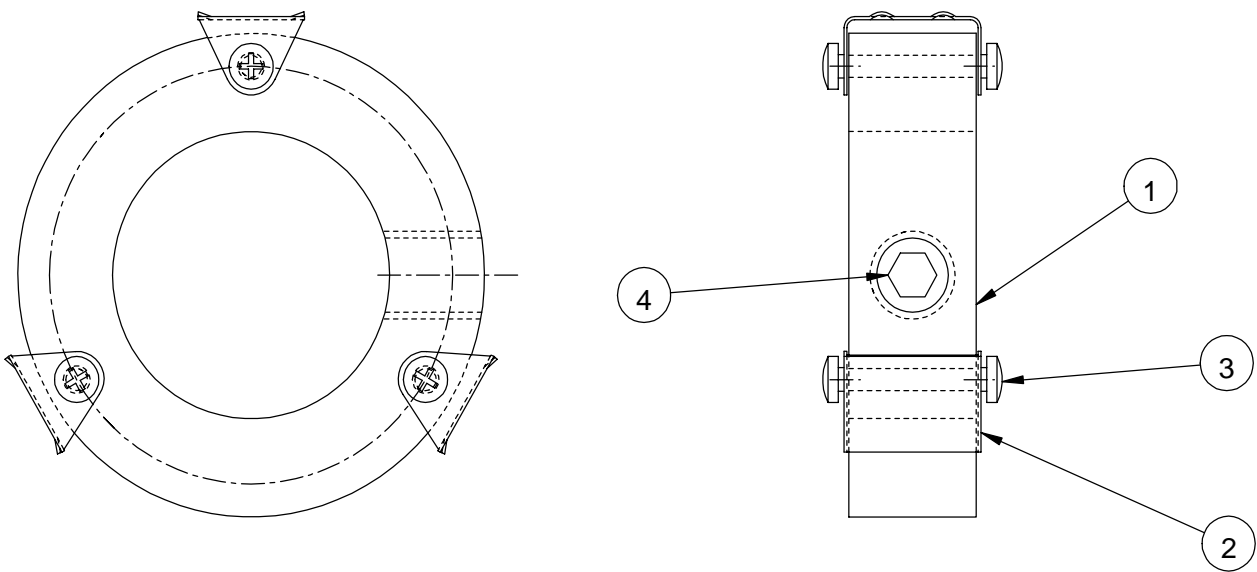


## Drive Side



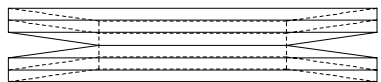
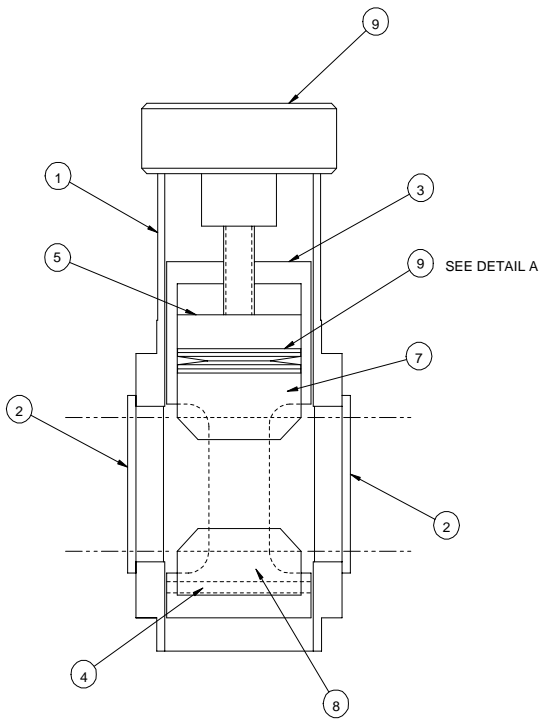
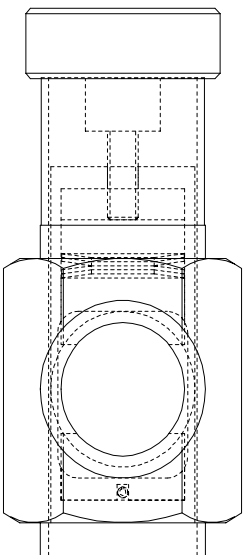
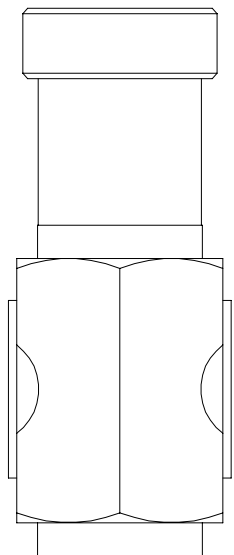
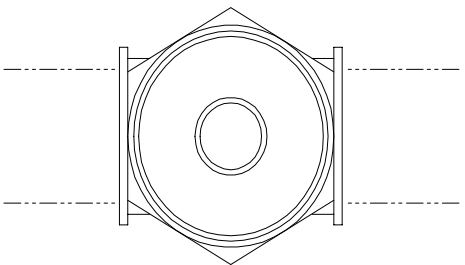
REQ'D	DESCRIPTION	PART NO.	ITEM
1	CHUCK,CORE,QUICK DISCONNECT	530-004	1
3	GRIPPER,CORE	100-032	2
6	SCREW,SELF-TAPPING,#6-32 X .375	-	3
1	SCREW,SET,BRASS TIP,1/2-13 X .5	050-007	4

△ 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		ASSEMBLY,CHUCK,CORE,1.625
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



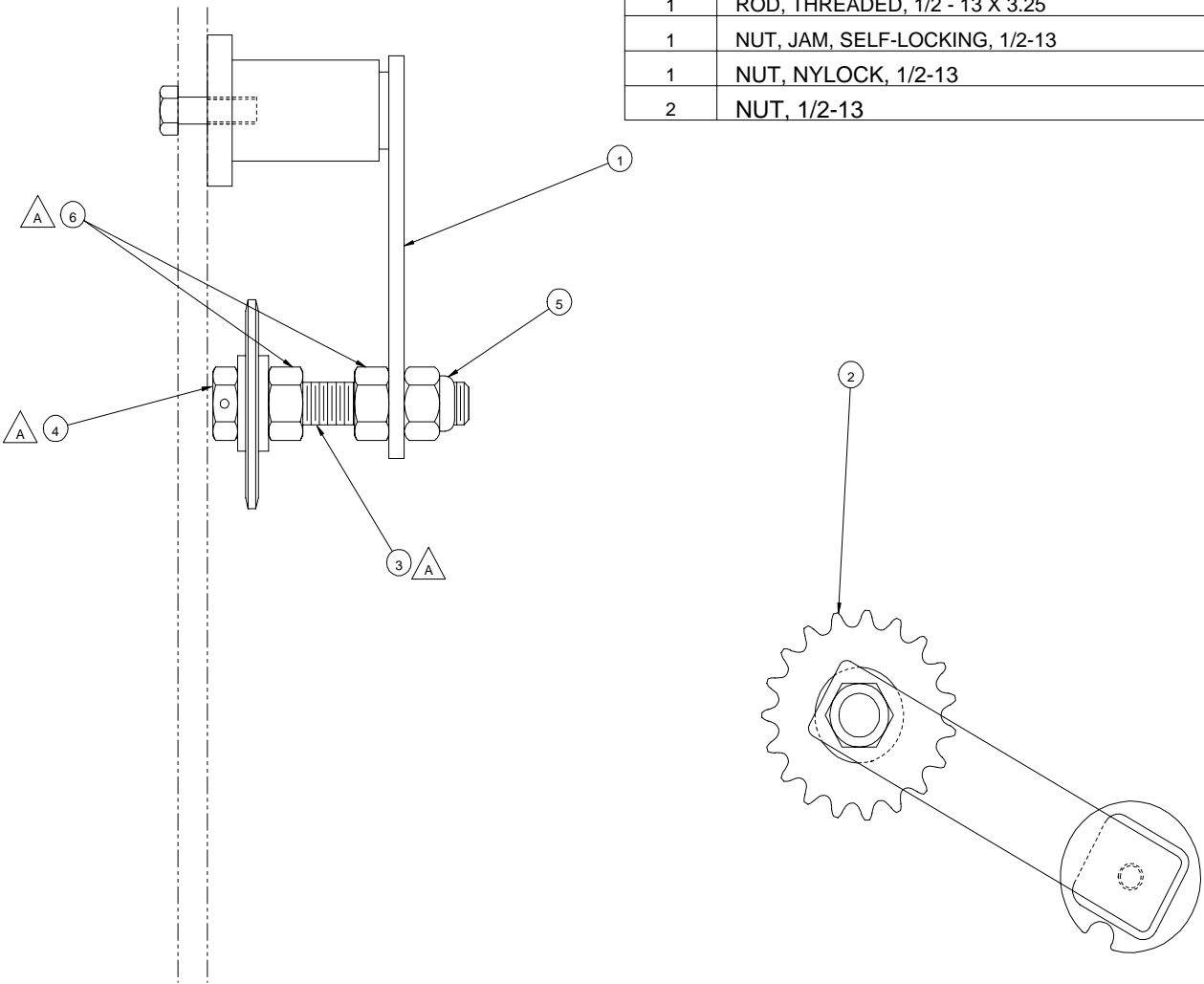
UDETAIL  
DISC SPRING  
ORIENTATION

3X SCALE

SHEET 1 OF 1		UNLESS OTHERWISE SPECIFIED		FINISH TO BE		 4151 Anderson Road, DeForest, Wisconsin Phone (808) 246-8888 Fax (808) 246-8888	
2536	2507	1166	1161	0937		TITLE: ASSEMBLY, BRAKE	
E	D	C	B	A	RELIEVED	DATE: 11-15-98	DRAWN BY: RA S
						SCALE: 1/1	SIZE: C
						RELEASE	001-158



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



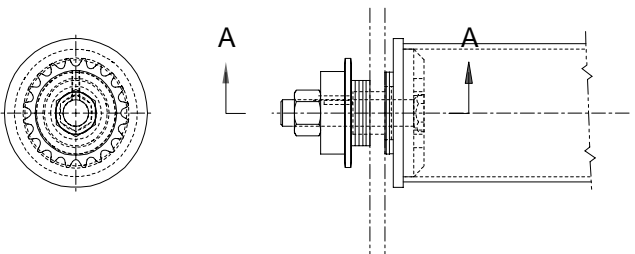
UNLESS OTHERWISE SPECIFIED:		TOL.		FINIS.		PRO.		DATE		DRAWN		DWG. NO.		C		REV.	
1	1/16"	1/32"	1/64"	1/32"	1/64"	1/32"	1/64"	1/32"	1/64"	1/32"	1/64"	1/32"	1/64"	1/32"	1/64"	1/32"	1/64"
Pro-Tech Engineering 2117 N. Douglas Rd. Madison, Wisconsin Phone (608) 245-8899 Fax (608) 245-8855										TITLE ASSY, TENSIONER, CHAIN		DATE 11-16-84		DRAWN K.L.		DWG. NO. 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



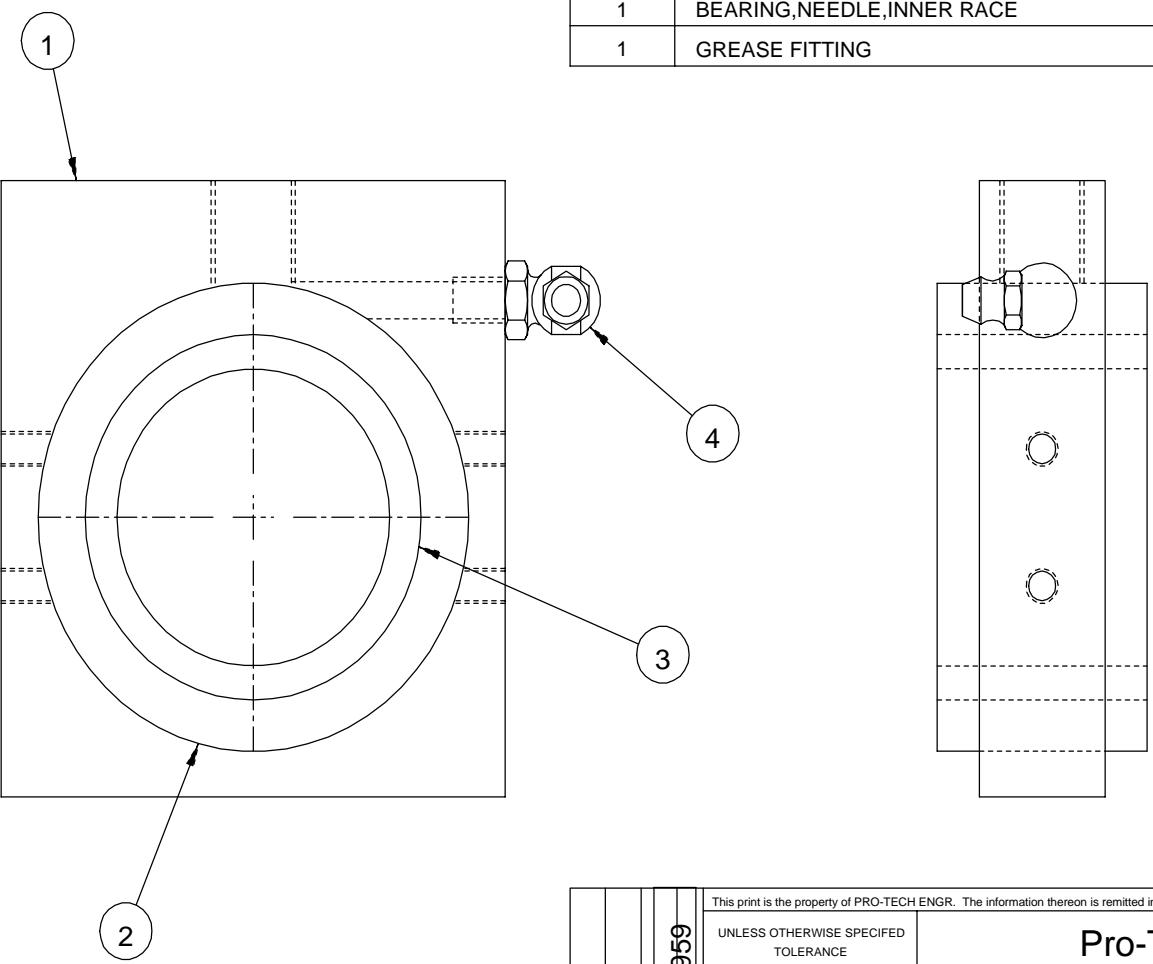
SECTION A-A

SCALE: 2/  
1



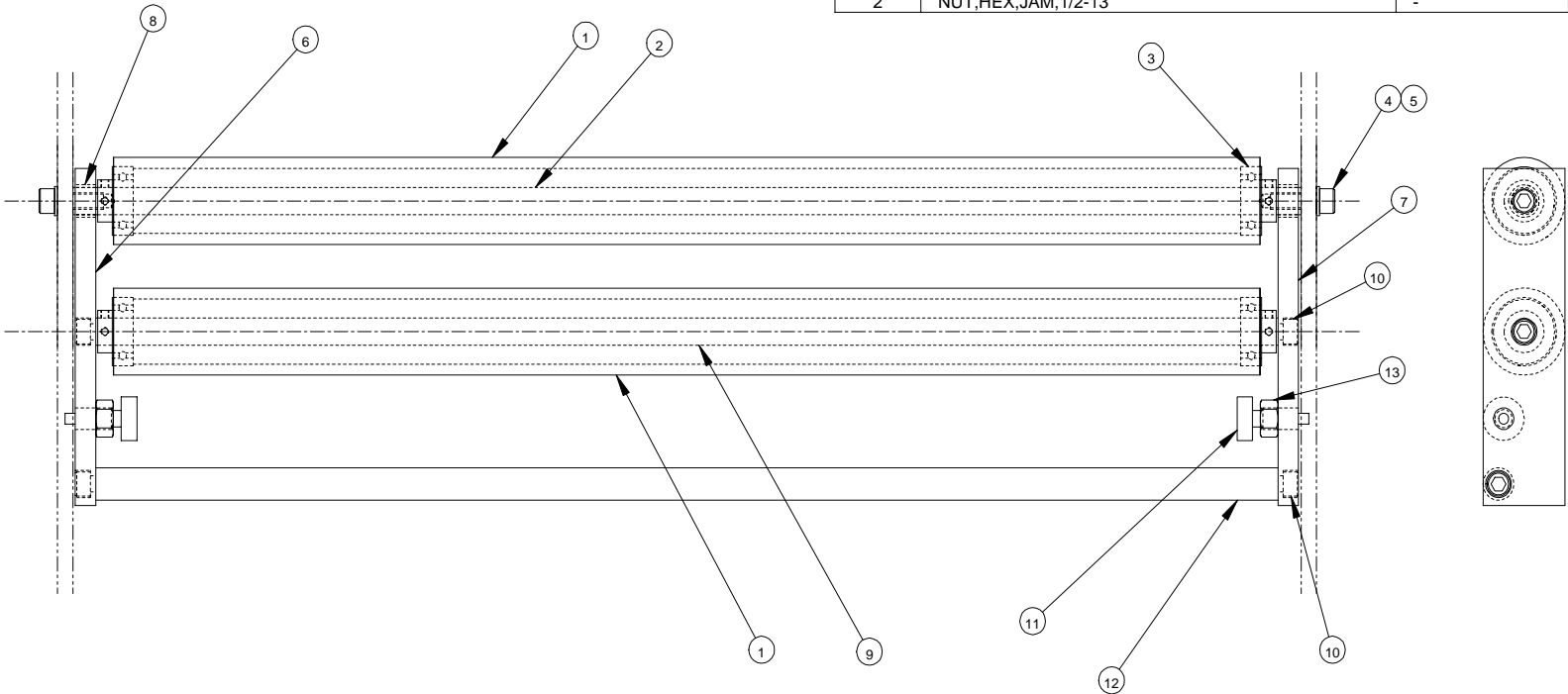
SHEET 1		PRO-TECH		4151 Jackson Road, Detroit, Michigan Phone (800) 246-8862 Fax (800) 246-8864	
UNLESS OTHERWISE SPECIFIED		TITLE			
Q.M.	TOL.	FINIS	ASSY, REWIND, ORCA DRIVE		
SIZE		NO	1		
X	P. 1/2	BE	DATE 11-15-98		
X	1/4	12.5	DRAWN BY RAS		
X	P	5	SCALE 1:2		
X	P		SIZE C		
X	P		Deg		
X.X	P	ANGLE	001-		
X.XX	P	B	185		
X.XXX	P	ID			
X	P				

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



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) 246-8645			
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	TITLE: <b>BLK,BRG,LEFT,MAIN ROLL ORCA I</b>			
X.XXX	P .005		DATE: 11-17-94	DRAWN BY: K.L.	DWG SCALE: A1	Dwg: 001-187

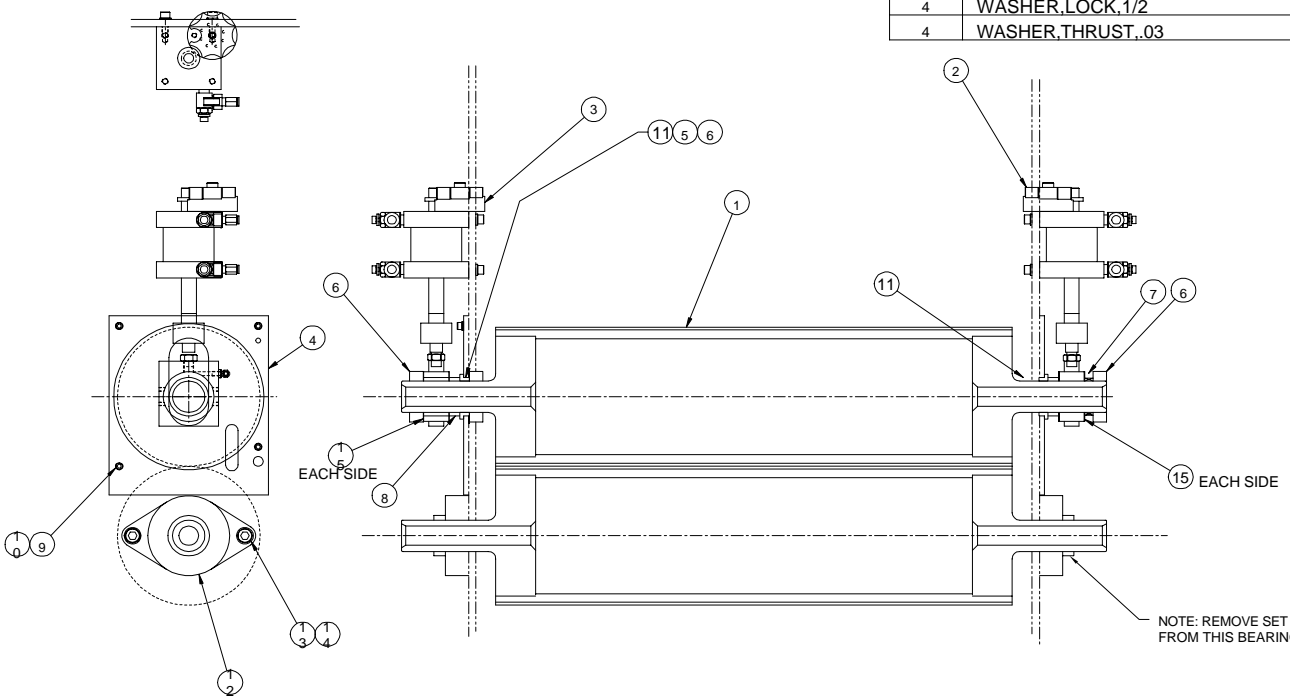
REQ'D	DESCRIPTION	PART NO.	ITEM
2	IDLER, OUPUT, ORCA I	620-012	1
1	SHAFT, IDLER, OUPUT, ORCA I	710-039	2
4	BEARING	020-100	3
2	SHCS, 3/8-16 X 1	-	4
2	WASHER, LOCK, 3/8	-	5
1	BRACKET, ARM, IDLER, RT, ORCA I	510-111	6
1	BRACKET, ARM, IDLER, LF, ORCA I	510-113	7
2	BUSHING, BRONZ, .62 X .5	040-021	8
1	SHAFT, 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 11th Street Phone: (802) 485-8888 Fax: (802) 246-5544	
Ø	±.0001	TOL.	±.0001	TITLE: ASSEMBLY, IDLER, OUTFEED	
Ø	±.0002	FINISH	BE	DATE: 11-28-94	
X	±.0005	ANGLES	10	DRAWN BY: RA S	DWG SCALE: C 2
X	±.0010				DWG NO: 001-191
X	±.0020				
X	±.0050				
X	±.0100				

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

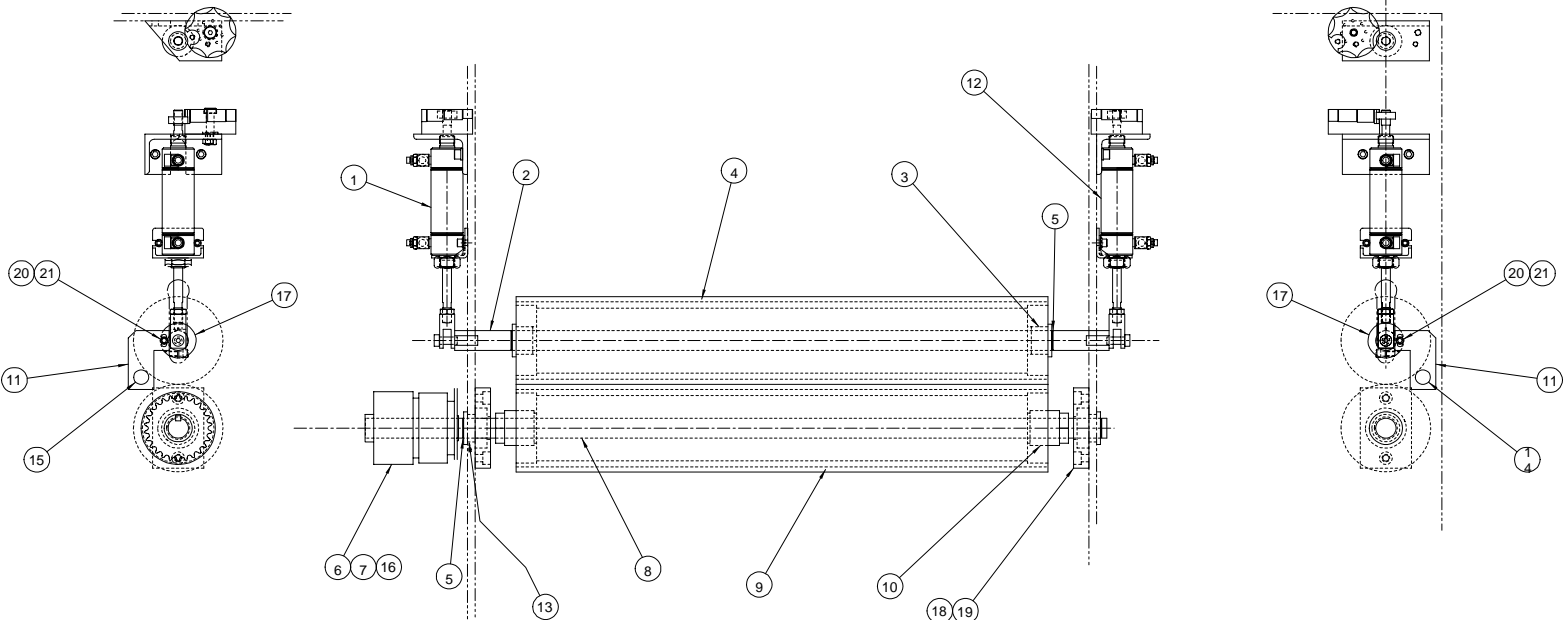
**PROPRIETARY**  
 GBC PRO-TECH CLAIMS PROPRIETARY RIGHTS TO THE MATERIAL DISCLOSED ON THIS DRAWING. IT IS ISSUED IN CONFIDENCE FOR ENGINEERING INFORMATION ONLY AND SHALL NOT BE REPRODUCED, COPIED OR DISCLOSED IN WHOLE OR IN PART, OR USED FOR MANUFACTURE OR FOR ANY OTHER PURPOSE WITHOUT WRITTEN PERMISSION FROM GBC PRO-TECH



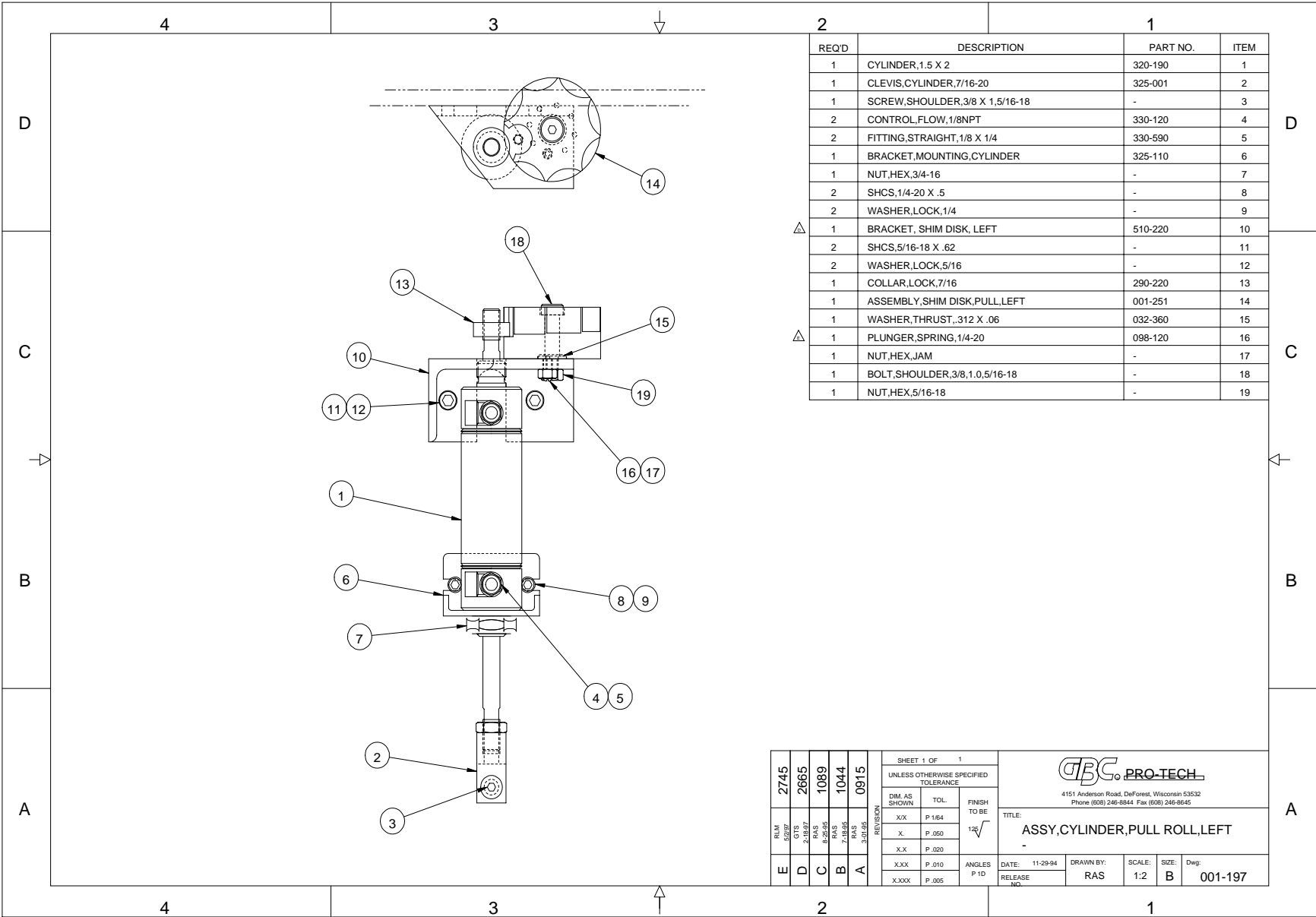
SHEET 1 OF 1		UNLESS OTHERWISE SPECIFIED TOLERANCE		GBC PRO-TECH	
DM. AS SHOWN	TOL.	FINISH TO BE	4151 Anderson Road, DeForest, Wisconsin 53532 Phone (800) 246-8844 Fax (800) 246-8845		
XX	F.154	√	TITLE		
X	F.050		ASSEMBLY,ROLL,MAIN		
X-X	F.050		DATE 11-29-94		
XXX	F.010	ANGLES P ID	DATE RELEASED	DRAWN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



REQ'D	DESCRIPTION	PART NO.	ITEM
1	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"	1/32"	21719, Douglas Rd., Houston, Missouri 63074	
3/16"	± 1/64"	1/16"	1/32"	Phone (816) 246-8584 Fax (816) 246-4545	
1/4"	± .001"	1/16"	1/32"	TITLE	
3/8"	± .001"	1/16"	1/32"	ASSEMBLY,ROLL,PULL	
1/2"	± .001"	1/16"	1/32"	DATE	DRAWN BY
3/4"	± .001"	1/16"	1/32"	11-30-94	RAS
1"	± .001"	1/16"	1/32"	UNLESS	DWG. SCALE
					C4
				DATE	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

RUM	2745
DES	2665
RAIS	1089
RAIS	1044
RAIS	0915
REVISION	
XX	P.164
X	P.050
X.X	P.020
X.XX	P.010
X.XXX	P.005

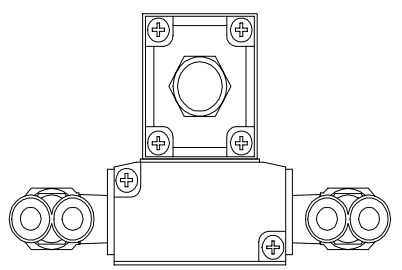
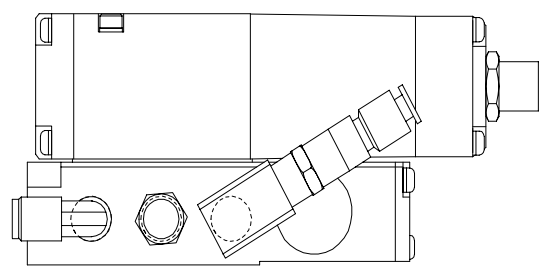
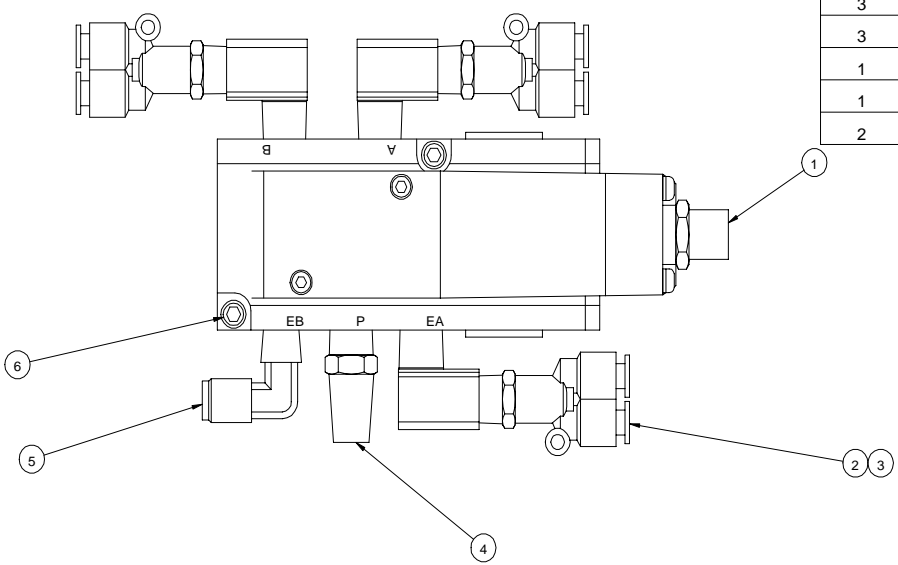
SHEET 1 OF 1	
UNLESS OTHERWISE SPECIFIED TOLERANCE	
DIM. AS SHOWN	TOL.
XX	P.164
X	P.050
X.X	P.020
X.XX	P.010
X.XXX	P.005
FINISH TO BE	125√
ANGLES P.10	
DATE: 11-29-94	DRAWN BY: RAS
RELEASE NO.	SCALE: 1:2
	SIZE: B
	Dwg: 001-197



4151 Anderson Road, DeForest, Wisconsin 53532  
Phone (608) 246-8844 Fax (608) 246-8645

TITLE: ASSY,CYLINDER,PULL ROLL,LEFT

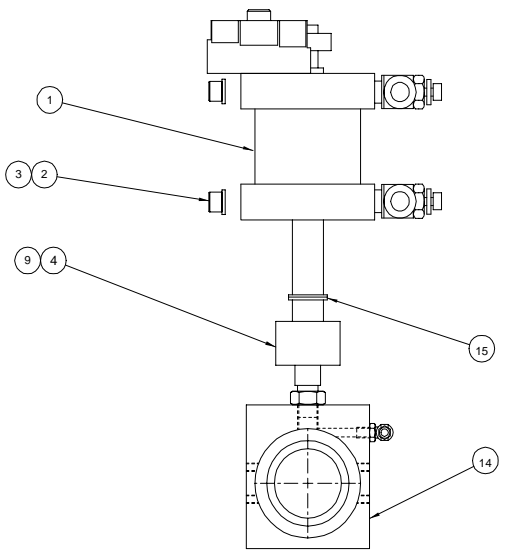
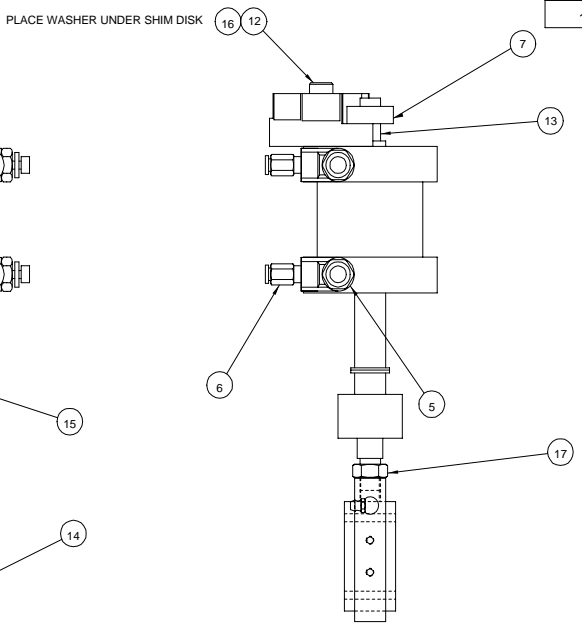
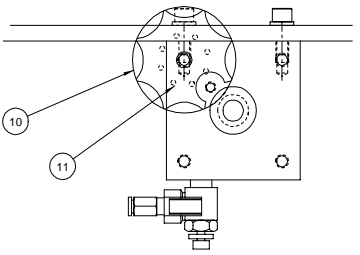
REQD	DESCRIPTION	PART NO.	ITEM
1	VALVE, AIR, SOLENOID	350-115	1
3	FITTING,AIR,ELBOW,1/4NPT	330-760	2
3	Y-FITTING,1/4NPT	330-310	3
1	MUFFLER, AIR	330-280	4
1	FITTING, AIR, ELBOW, MALE 1/4 NPT	330-730	5
2	CAP SCREWS, SOCKET, #10-32 X 1-1/4 LG	-	6



ROTATE FITTINGS AS REQUIRED FOR BEST ASSEMBLY

UNLESS OTHERWISE SPECIFIED									
DWG	TOL	FRGS	Pro-Tech Engineering						
SPRNG		FS	2115 Pro-Tech Engineering, Inc. 10000 205						
XL	P.154	RE	TITLE						
X	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	10	94	KL	1				

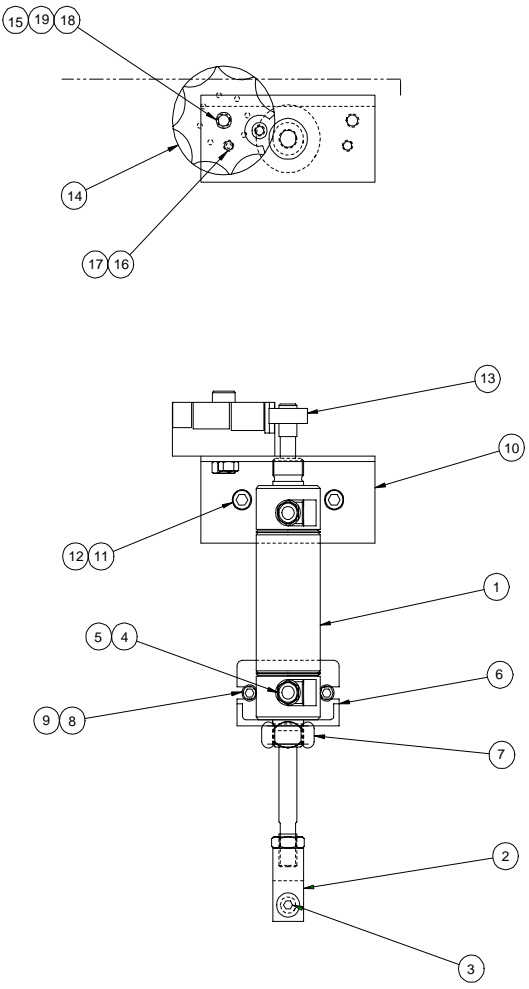
REQD	DESCRIPTION	PART NO.	ITEM
1	CYLINDER,2.5 X 1.75	320-320	1
4	SHCS,5/16-18 X .75	-	2
4	WASHER,LOCK,5/16	-	3
1	COUPLING,ROD END,1/2-20	325-000	4
2	CONTROL,FLOW	330-130	5
2	FITTING,STRAIGHT,1/4NPT X 1/4	330-600	6
1	LOCK COLLAR,1/2-20	290-260	7
1	SHCS,1/2-20 X .5		8
1	STUD, THREADED, 1/2 - 20 x 1"	645-007	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	FINISH	DATE	DRAWN	DWG SCALE	This print is the property of PRO-TECH ENGR. The information thereon is rendered in confidence. Pro-Tech Engineering 2117 N. Stoughton Rd., Madison, Wisconsin Phone (608) 246-8877 Fax (608) 246-4685 TITLE: ASSEMBLY,CYLINDER,MAIN,R T DATE: 11-29-94 DRAWN: S DWG SCALE: C2 DWG NO: 001-206				
27.5	±.010	X	P.164	11-29-94	S	C2					
14.0	±.010	X	P.050								
0.00	±.010	X	P.020								
0.00	±.010	X	P.010								
0.00	±.010	X	P.005								

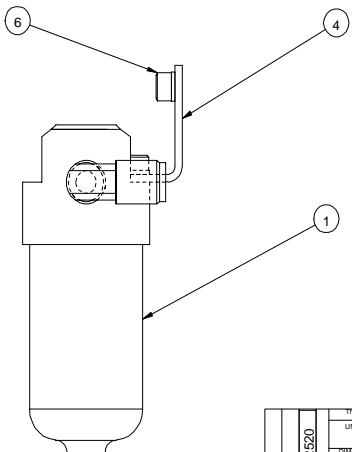
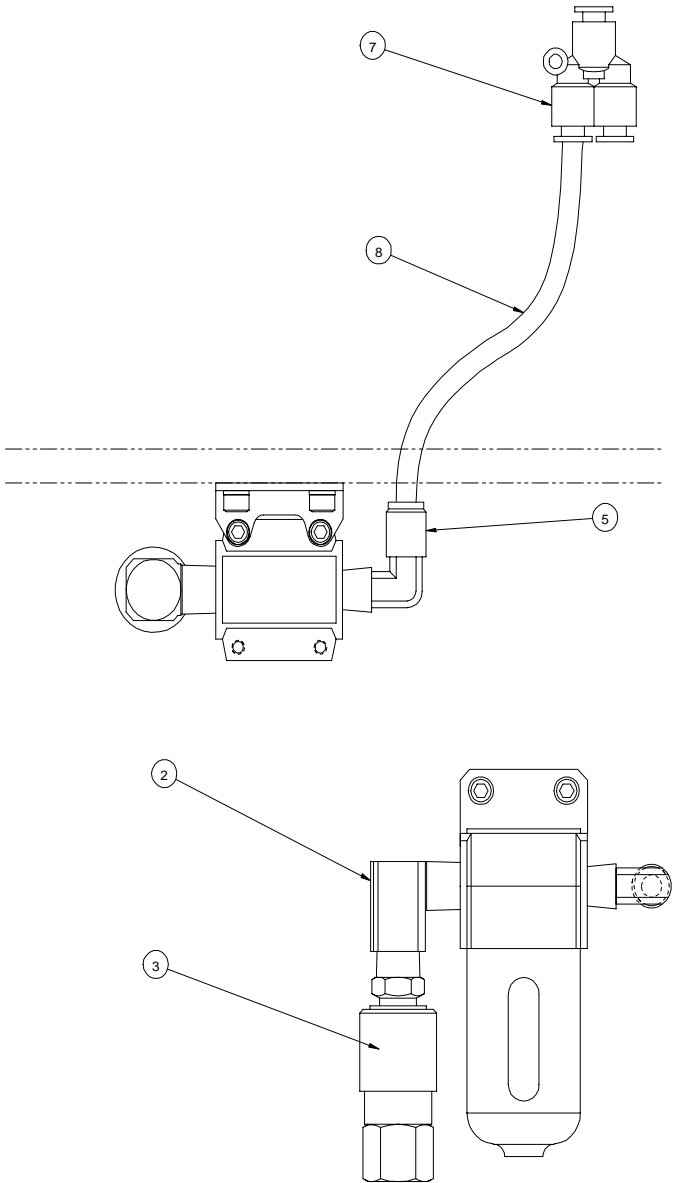
REQD	DESCRIPTION	PART NO.	ITEM
1	CYLINDER,1.5 X 2	320-190	1
1	CLEVIS,CYLINDER,7/16-20	325-001	2
1	SCREW,SHOULDER,3/8 X 1,5/16-18	-	3
2	CONTROL,FLOW,1/8NPT	330-120	4
2	FITTING,STRAIGHT,1/8 X 1/4	330-590	5
1	BRACKET,MOUNTING,CYLINDER	325-110	6
1	NUT,HEX,3/4-16	-	7
2	SHCS,1/4-20 X .5	-	8
2	WASHER,LOCK,1/4	-	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

PLACE WASHER UNDER SHIM DISK



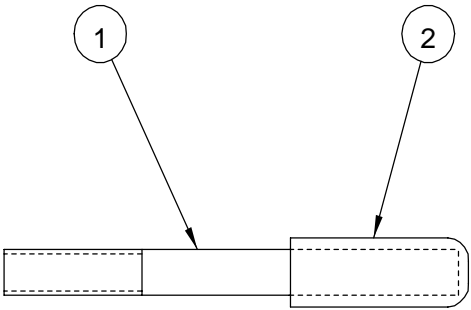
745		1050		1045		1910		UNLESS OTHERWISE SPECIFIED TOLERANCES:		Pro-Tech Engineering 2117 N. Slaughter Rd. Madison, Wisconsin 53704 Phone (608) 263-8244 Fax (608) 245-6501	
D	C	B	A	±.005	±.002	±.001	±.0005	±.0002	±.0001	±.00005	TITLE ASSY,CYLINDER,PULL ROLL,RIGHT
DATE		DRAWN BY		DWG SCALE		Part		001-		207	
11-29-94		RA S		C2							

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



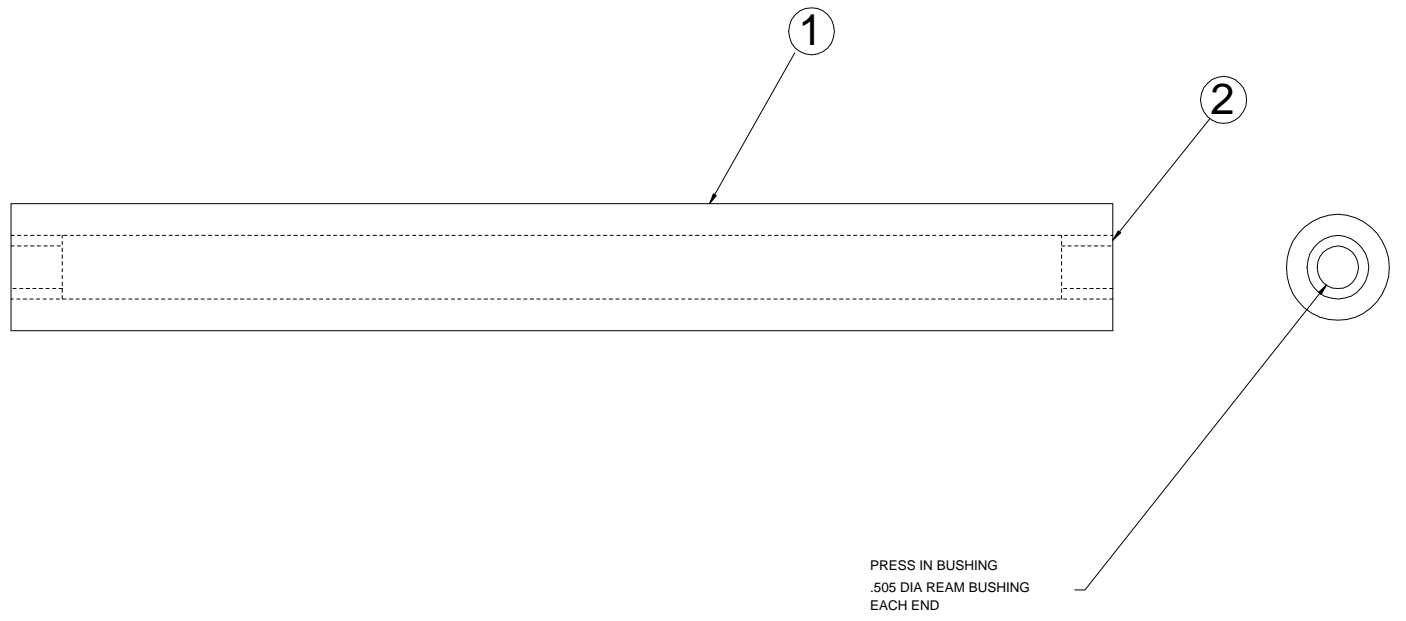
UNLESS OTHERWISE SPECIFIED		FINISH		TOLERANCE		DATE		DRAWN BY		DWG SCALE		DWG NO		
ALL	AS SHOWN	ALL	AS SHOWN	ALL	AS SHOWN	12-9-94	K.L.	C1	001-210					
TITLE: ASSEMBLY, FILTER, AIR Pro-Tech Engineering 2117 N. Douglas St. Madison, Wisconsin Phone (608) 246-8884 Fax (608) 246-8885													001-210	

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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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		$125^{\sqrt{\quad}}$									
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	
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



PRESS IN BUSHING  
 .505 DIA REAM BUSHING  
 EACH END

UNLESS OTHERWISE SPECIFIED		TOLERANCE		FINISH		DATE		DRAWN BY:		DWG SCALE:		Dwg:	
SUR AS	TOL.	P 1/64		TO BE		12-15-94		RAS		C1		001-218	
CHOSN		X		P .005									
		X		P .005									
		X,X		P .010									
		X,X,X		P .005									

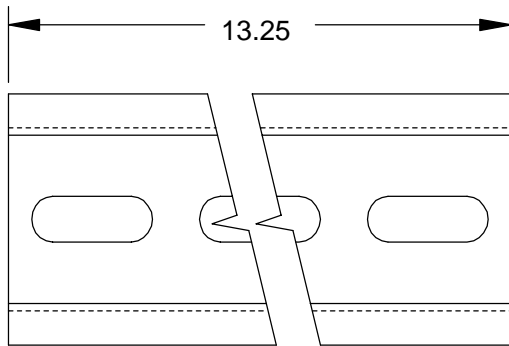
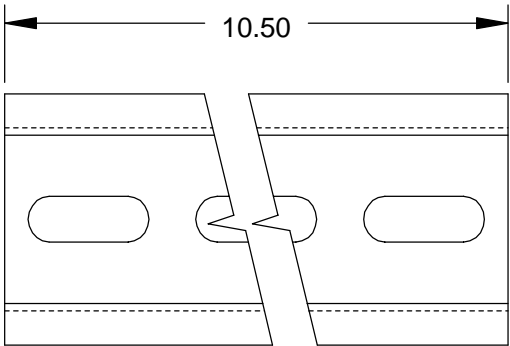
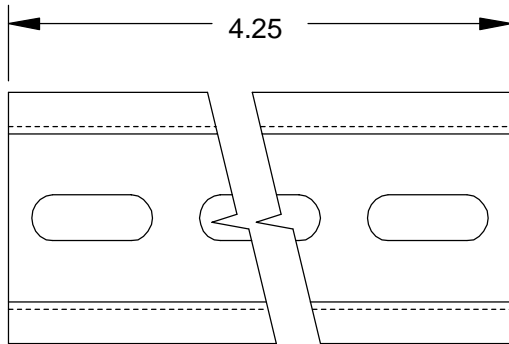
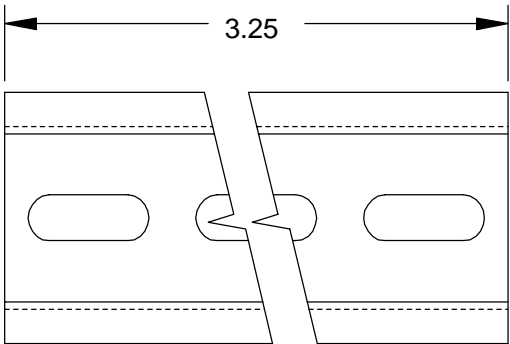
Pro-Tech Engineering


2117 N. Slaughter Rd. Madison, Wisconsin 53704  
 Phone (608) 246-8844 Fax (608) 246-8845

TITLE: ASSEMBLY, IDLER, INFEED, PAPER  
 ORCA 1

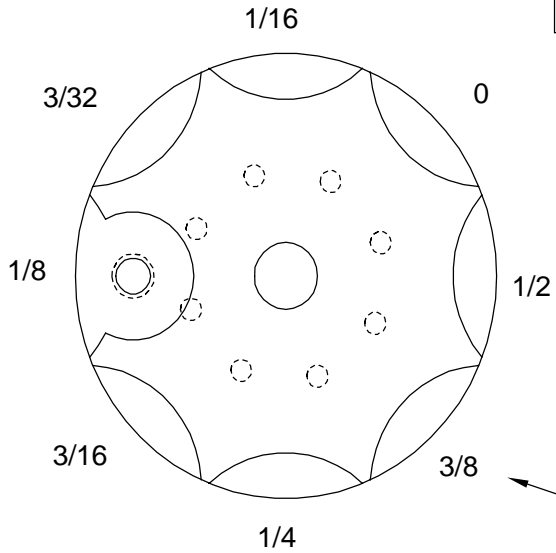
REQ'D	DESCRIPTION	PART NO.	ITEM
-	DIN RAIL	217-200	-

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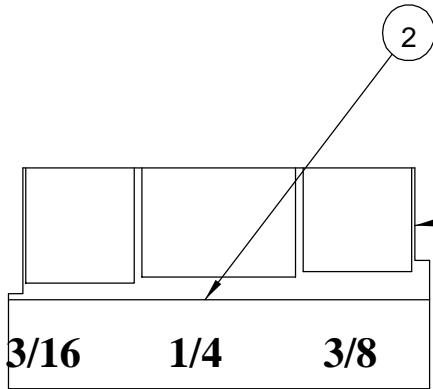


SHEET 1 OF 1			 4151 Anderson Road, DeForest, Wisconsin 53532 Phone (608) 246-8844 Fax (608) 246-8645			
UNLESS OTHERWISE SPECIFIED TOLERANCE						
REVISION	DIM. AS SHOWN	TOL.	FINISH TO BE	TITLE: <b>SET, DIN RAIL ORCA I</b>		
	X/X	P 1/64	125√			
	X.	P .050				
	X.X	P .020				
	X.XX	P .010	ANGLES P 1D	DATE: 7-19-96	DRAWN BY: RLM	SCALE: 1/1
X.XXX	P .005		RELEASE NO.		SIZE: A	Dwg: 001-233

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

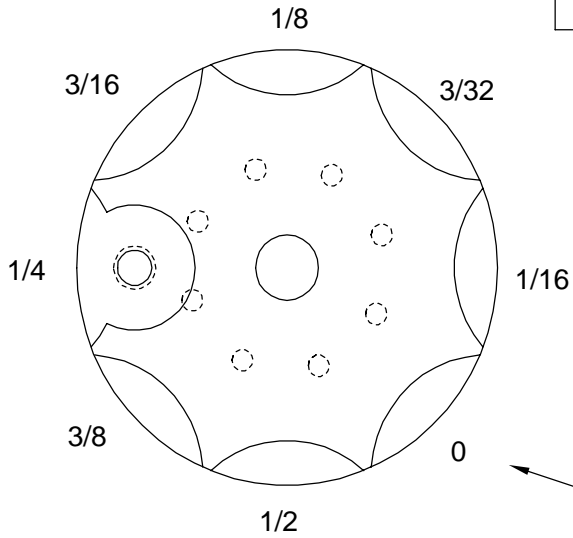


INDICATES POSITION OF LABEL  
AROUND CIRCUMFERANCE

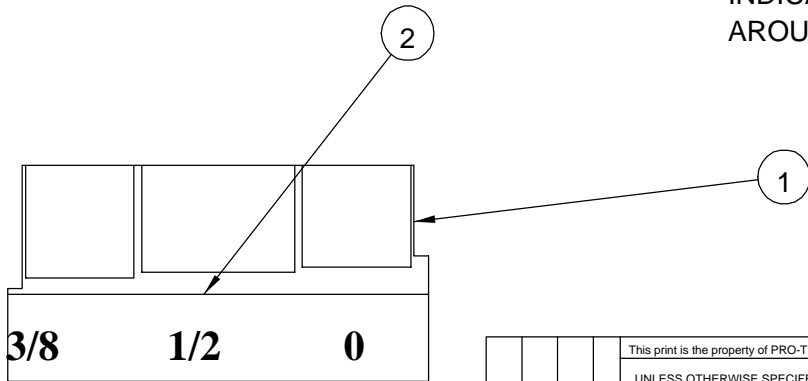


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UNLESS OTHERWISE SPECIFIED TOLERANCE			<b>Pro-Tech Engineering</b> 2117 N. Stoughton Rd. Madison, Wisconsin 53704 Phone (608) 246-8844 Fax (608) 246-8645			
DIM. AS SHOWN	TOL.	FINISH TO BE				
X/X	P .1/64	125√	TITLE: ASSEMBLY,SHIM DISK,MAIN LEFT			
X.	P .050		ORCA I			
X.X	P .020		DATE: 3-01-95	DRAWN BY: RAS	DWG SCALE: A1	Dwg: 001-249
X.XX	P .010	ANGLES P 1D				
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

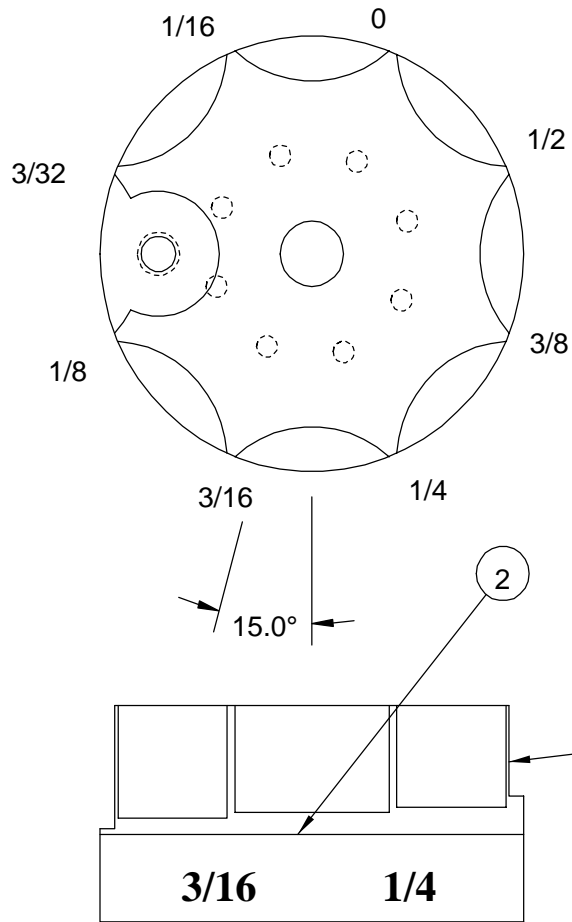


INDICATES POSITION OF LABEL  
AROUND CIRCUMFERENCE



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DIM. AS SHOWN	TOL.			FINISH TO BE		
X/X	P 1/64	125√	TITLE: <b>ASSEMBLY,SHIM DISK,MAIN RIGHT ORCA I</b>			
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	<b>001-250</b>

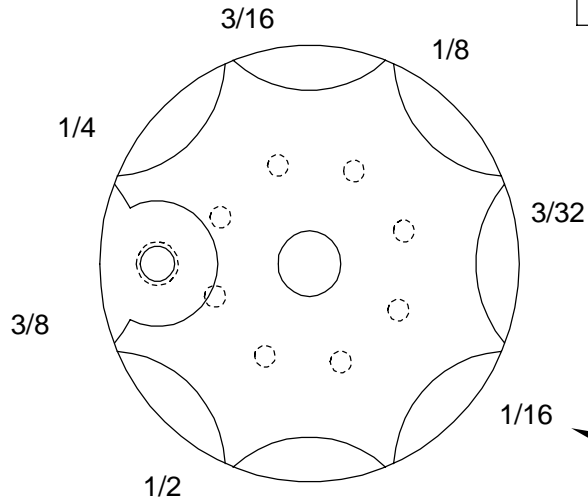
REQ'D	DESCRIPTION	PART NO.	ITEM
1	SHIM DISK	720-019	1
1	OVERLAY,SHIM DISK,MAIN ROLL	450-021	2



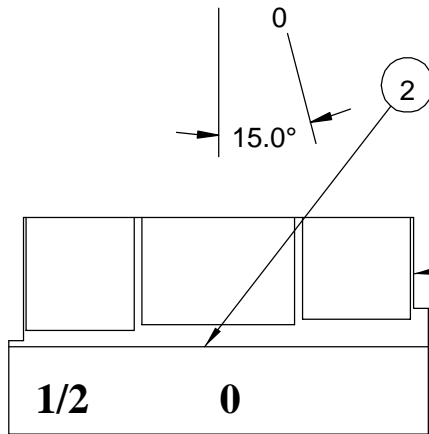
INDICATES POSITION OF LABEL AROUND CIRCUMFERENCE

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DIM. AS SHOWN	TOL.	FINISH TO BE	
X/X	P .1/64	125√	TITLE: <b>ASSEMBLY,SHIM DISK,PULL,LEFT ORCA I</b>
X.	P .050		
X.X	P .020	ANGLS P 1D	DATE: 3-01-95
X.XX	P .010		
X.XXX	P .005	DRAWN BY: RAS	DWG SCALE: A1
			Dwg: <b>001-251</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.							
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	001-252

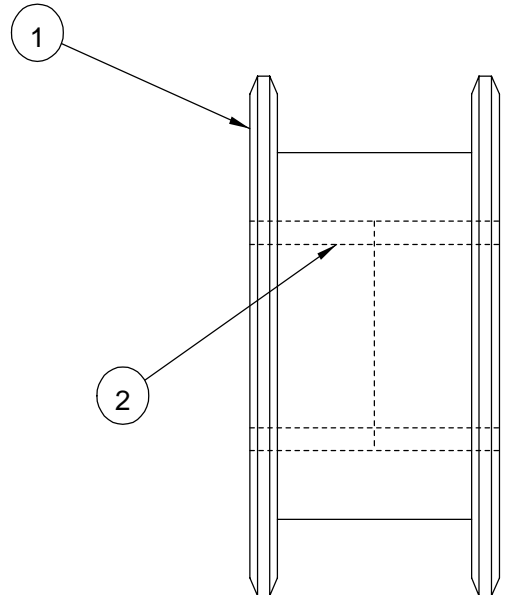
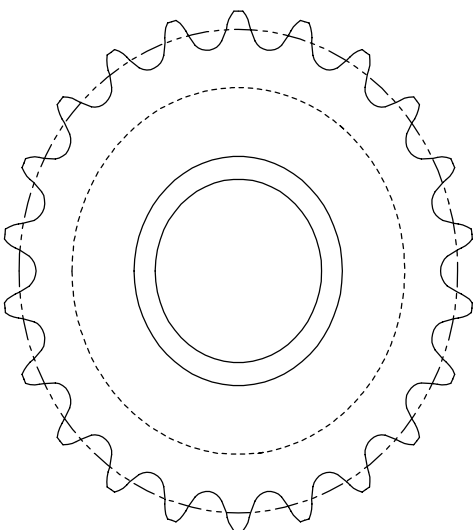
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REQ'D	DESCRIPTION	PART NO.	ITEM
1	TOWEL,WHITE	475-950	1
			2
1	ZIPPY KNIFE	475-620	3
1	ALLEN WRENCH SET	475-230	4
4	LEVELING PAD	470-101	5
3	FUSE 3A,250	186-200	6
1	TAPE MEASURE	475-100	7
			8
1	RUBBER CEMENT	930320	9
1	MASKING TAPE	475-000	10
1	BOX 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

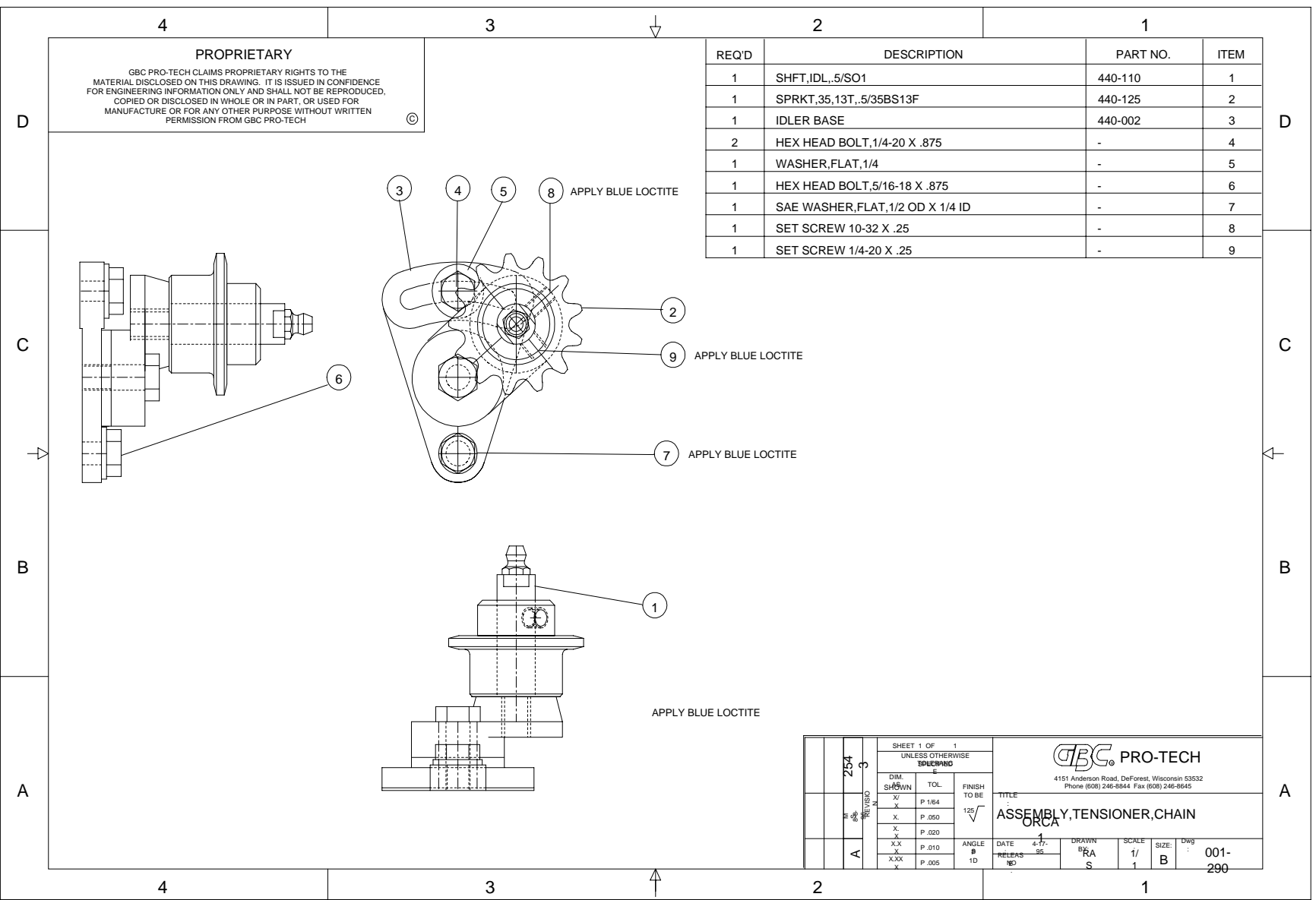


SHEET 1 OF 1		UNLESS OTHERWISE SPECIFIED TOLERANCE		 4151 Anderson Road, DeForest, Wisconsin 53532 Phone (608) 246-8844 Fax (608) 246-8645	
DIM. AS SHOWN	TOL.	FINISH TO BE	TITLE:		
X/X	P 1/64	125√	ACCESSORY KIT ORCA 1		
X.	P .050				
X.X	P .020	ANGLES P 1 D	DATE: 3-06-95	DRAWN BY: RAS	SCALE: 1/1
X.XX	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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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√				
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	RELEASED
			DRAWN RA S
			SCALE 1/1
			SIZE B
			DWG NO 001-290

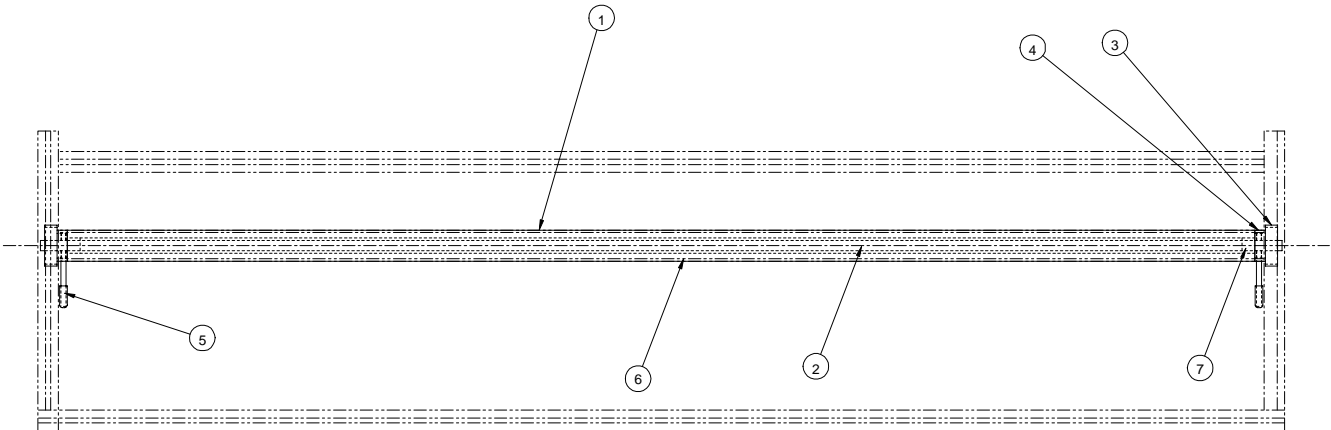
D  
C  
B  
A

D  
C  
B  
A

4 3 2 1

4 3 2 1

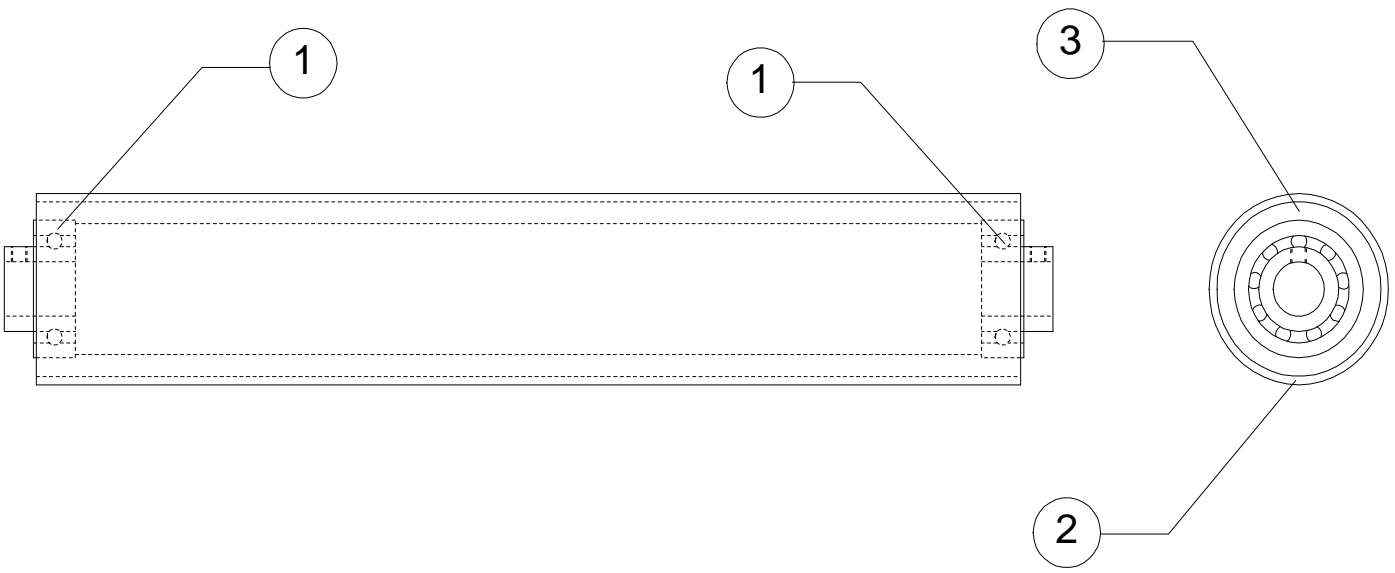
REQ'D	DESCRIPTION	PART NO.	ITEM
1	ASSEMBLY,IDLER,INFEED,PAPER	001-218	1
1	SHAFT,IDLER,INFEED,PAPER	710-054	2
2	CAM,LIFTING,IDLER	525-005	3
2	SET SCREW,1/4-20 X .375	-	4
2	ASSEMBLY,HANDLE,CAM	001-217	5
1	IDLER, INFEED, PAPER	620 - 013	6
2	BUSHING, BRONZE, .5 X .75 X .625	040 - 026	7



SHEET 1 1		UNLESS OTHERWISE SPECIFIED TOLERANCE		 4151 Anderson Road, DeForest, Wisconsin Phone (608) 246-8844, Fax (608) 246-8845	
FINISH	TO BE	TITLE:		ASSEMBLY,IDLER,INFEED,PAPER	
OR	12/	ORCA 1		DRAWN BY: SCALE: SIZE: Dwg:	
XX	110	DATE: 5-8-95	RAS	1:4	C 001-294
XXX	110	RELEASE: 10/			

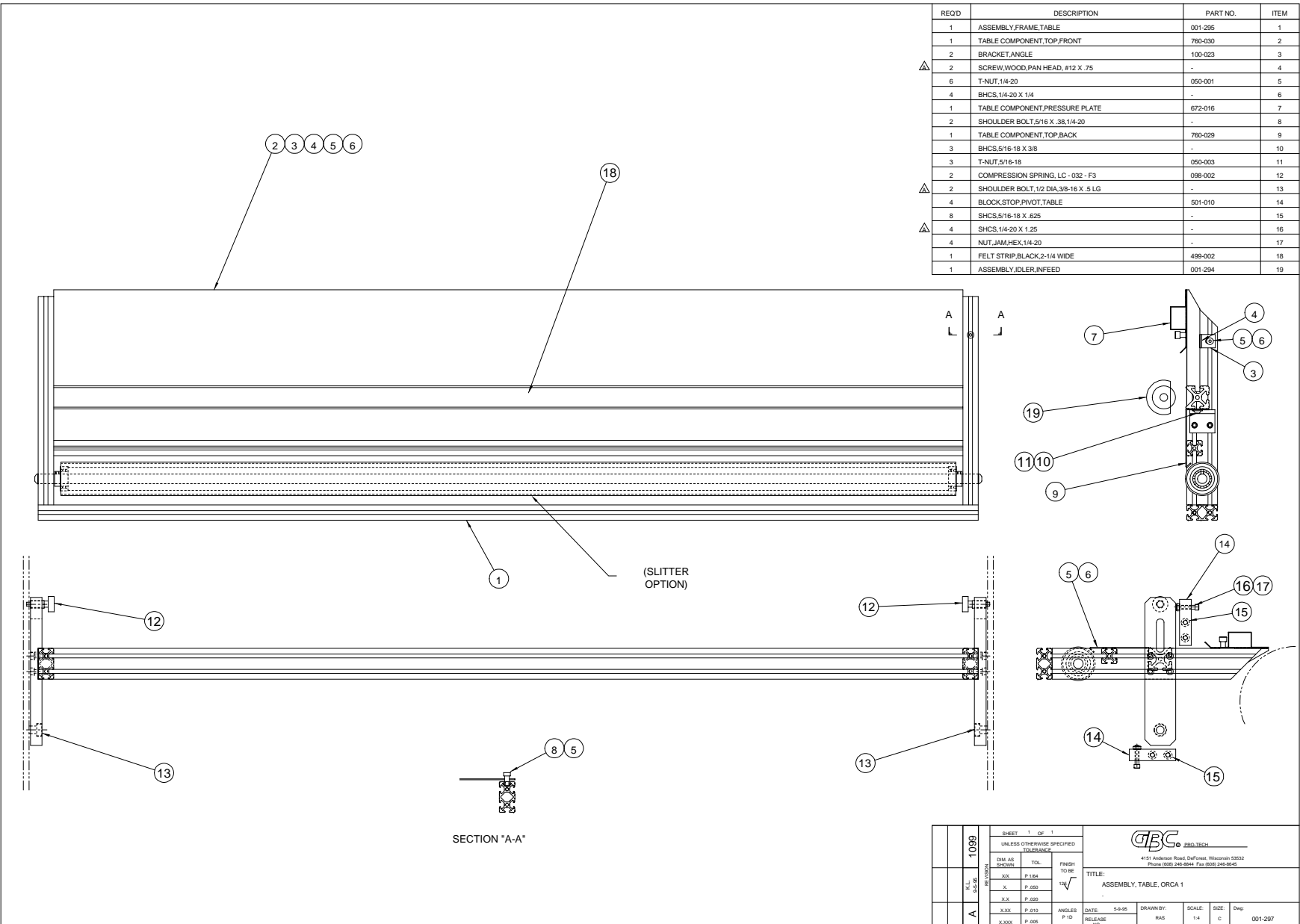


REQ'D	DESCRIPTION	PART NO.	ITEM
2	BEARING, IDLER	020-100	1
1	TUBE, SLITTER, PVC	490-001	2
1	ROLL, IDLER	620-016	3



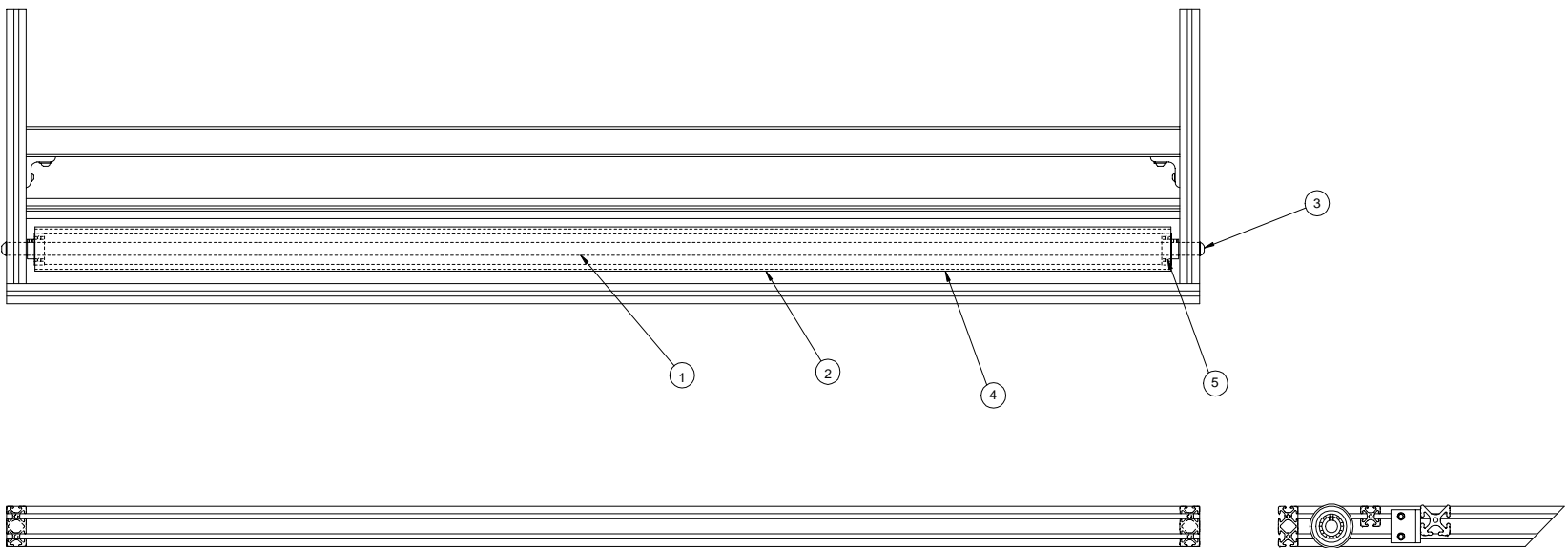
UNLESS OTHERWISE SPECIFIED TOLERANCE				Pro-Tech Engineering 2117 N. Slaughter Rd. Madison, Wisconsin 53704 Phone (608) 246-8844 Fax (608) 246-8843			
DM, AS	TOL.	FINISH	TO BE	TITLE: ASSEMBLY, IDLER, SLITTER, PAPER ORCA I DATE: 5-08-95 DRAWN BY: RAS DWG SCALE: C1 Dwg 001-296			
SIX	F .184		√				
X	F .050						
XX	F .020						
XXX	F .010						
		ANGLES	F ID				

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



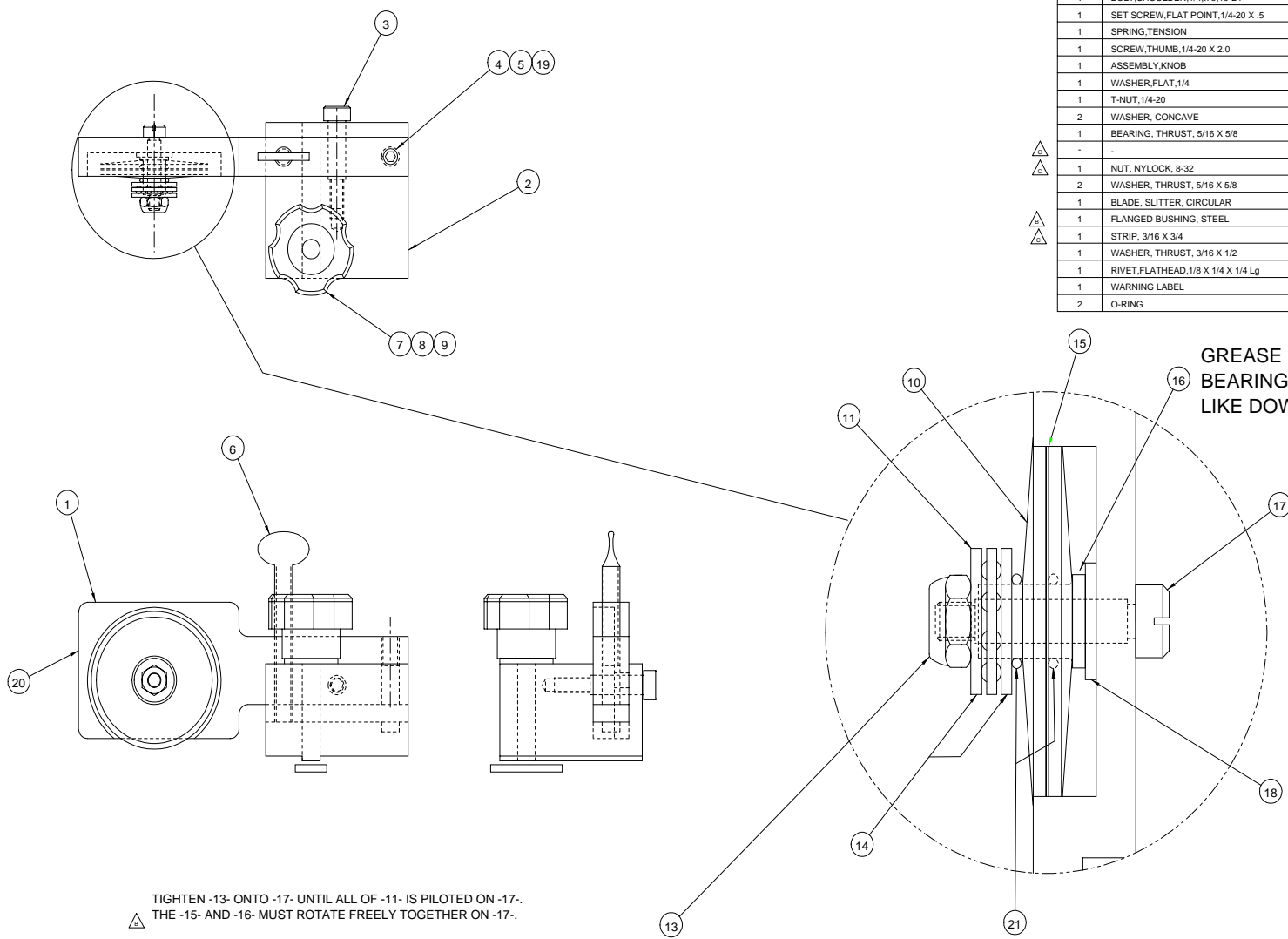
1099		SHEET 1 OF 1		UNLESS OTHERWISE SPECIFIED TOLERANCES		GBC PRO-TECH	
ANG	TOL	FINISH	TO BE	4111 Anderson Road, Oak Brook, Wisconsin 60521 Phone (800) 248-8844 Fax (800) 248-8545			
3/16	F .154	1/16	1/16	TITLE: ASSEMBLY, TABLE, ORCA 1			
1/8	F .050	1/8	1/8	DATE: 5-9-95	DRAWN BY: RAS	SCALE: 1:4	SIZE: C
1/4	F .020	1/4	1/4	RELEASE			Dwg 001-297
1/2	F .010	1/2	1/2				
3/4	F .005	3/4	3/4				

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



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DATE	TOL.	FINIS	TITL	DRAWN	DWG	SCALE	DWG	DATE	DRAWN	DWG	Dwg
05/09/95	ASME Y14.5	ASME Y14.5	ASSEMBLY, SLITTER, IDLER	RAS	001-298	C4	001-298	5-9-95	RAS	C4	001-298
REV	BY	DATE	DESCRIPTION	BY	DATE	DESCRIPTION	BY	DATE	DESCRIPTION	BY	DATE
1	X	05/09/95	ASSEMBLY, SLITTER, IDLER	RAS	05/09/95	ASSEMBLY, SLITTER, IDLER	RAS	05/09/95	ASSEMBLY, SLITTER, IDLER	RAS	05/09/95
2	X	05/09/95	ASSEMBLY, SLITTER, IDLER	RAS	05/09/95	ASSEMBLY, SLITTER, IDLER	RAS	05/09/95	ASSEMBLY, SLITTER, IDLER	RAS	05/09/95
3	X	05/09/95	ASSEMBLY, SLITTER, IDLER	RAS	05/09/95	ASSEMBLY, SLITTER, IDLER	RAS	05/09/95	ASSEMBLY, SLITTER, IDLER	RAS	05/09/95
4	X	05/09/95	ASSEMBLY, SLITTER, IDLER	RAS	05/09/95	ASSEMBLY, SLITTER, IDLER	RAS	05/09/95	ASSEMBLY, SLITTER, IDLER	RAS	05/09/95
5	X	05/09/95	ASSEMBLY, SLITTER, IDLER	RAS	05/09/95	ASSEMBLY, SLITTER, IDLER	RAS	05/09/95	ASSEMBLY, SLITTER, IDLER	RAS	05/09/95

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

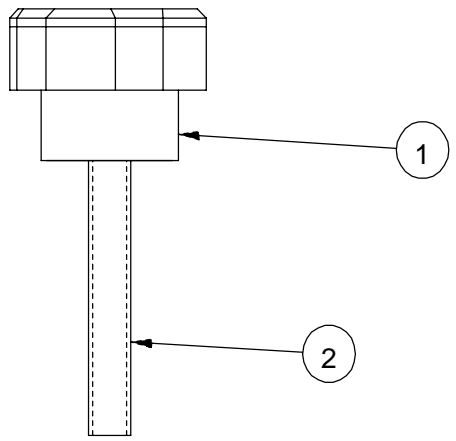


GREASE I.D. WITH BEARING GREASE LIKE DOW 44.

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-.

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UNLESS OTHERWISE SPECIFIED TOLERANCE						Pro-Tech Engineering					
DRG AS SHOWN						2117 N. Douglas Rd. Melrose, MA 02126-3294 Phone (617) 245-8544 Fax (617) 245-8545					
FINISH TO BE						TITLE					
.015 P.154						ASSEMBLY,SLITTER,INFEED					
.010 P.050						ORCA I					
.020 P.020						DATE					
.010 P.010						6-12-95					
.005 P.005						DRAWN BY					
						RAS					
						DWG SCALE					
						A1					
						Dwg					
						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

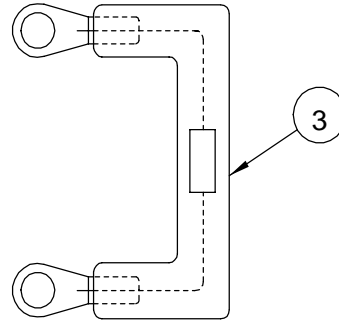
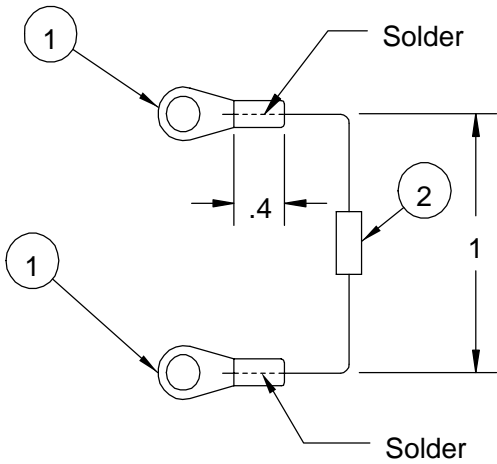


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UNLESS OTHERWISE SPECIFIED TOLERANCE			<b>Pro-Tech Engineering</b> 2117 N. Stoughton Rd. Madison, Wisconsin 53704 Phone (608) 246-8844 Fax (608) 246-8645						
DIM. AS SHOWN	TOL.	FINISH TO BE 125√	TITLE: ASSEMBLY,KNOB,1/4-20						
X/X	P 1/64		ORCA 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
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

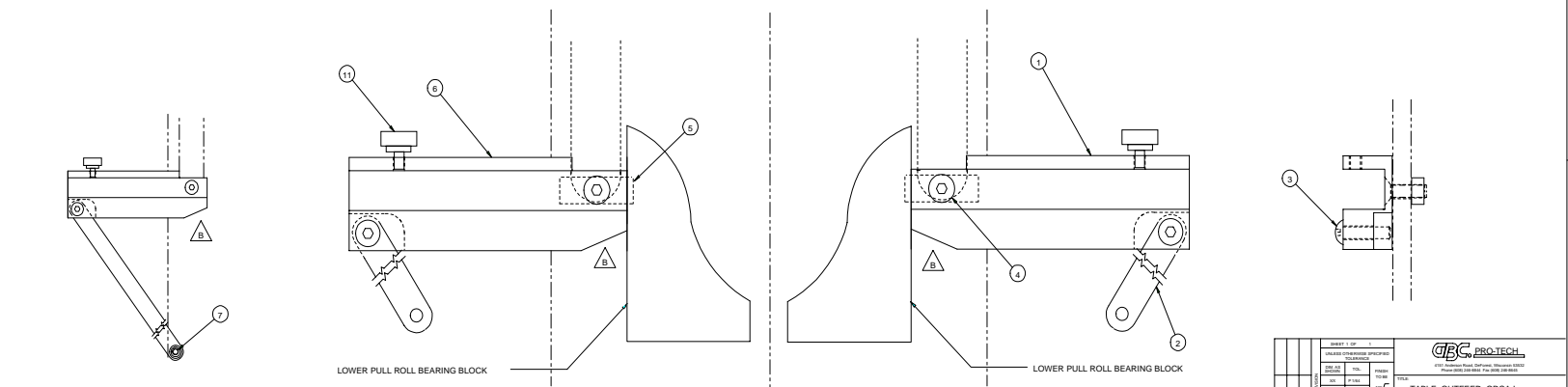
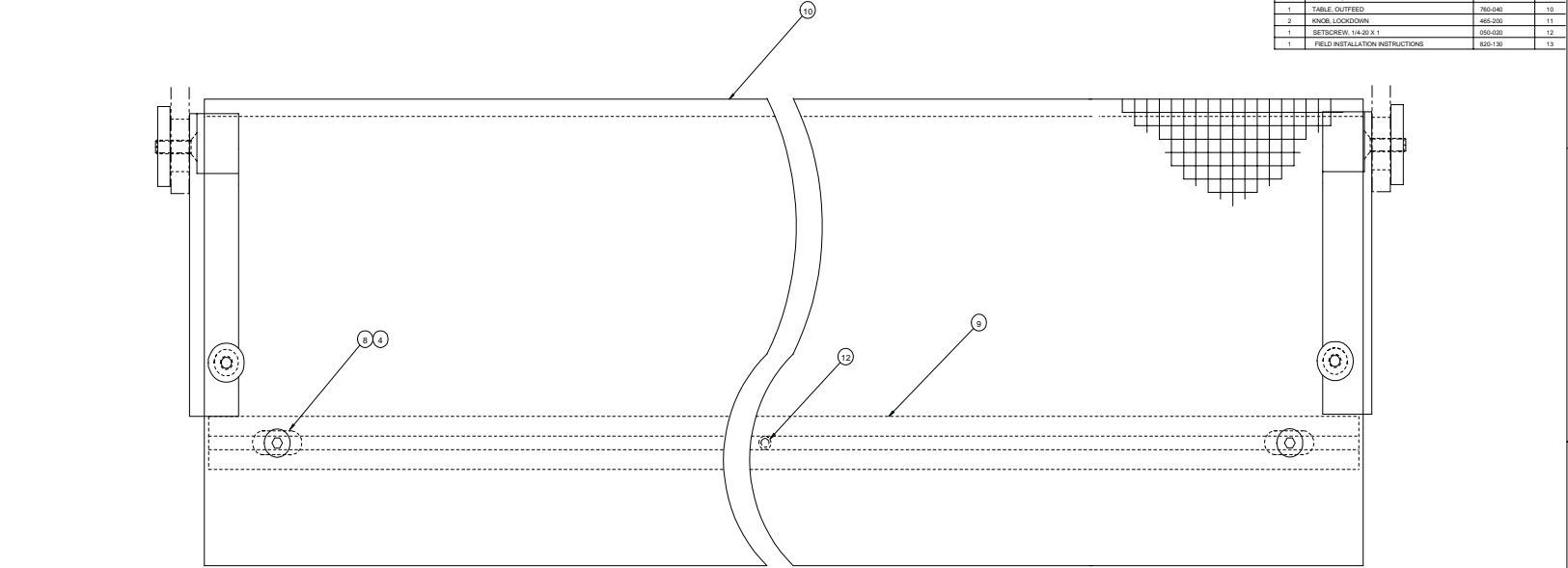


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UNLESS OTHERWISE SPECIFIED TOLERANCE				<b>Pro-Tech Engineering</b> 2117 N. Stoughton Rd. Madison, Wisconsin 53704 Phone (608) 246-8844 Fax (608) 246-8645							
DIM. AS SHOWN		TOL.								FINISH TO BE	
X.X		P .1/64		125°		TITLE: <b>ASSY, TRANS. VOLT. 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	SCREWBOLT 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 281-288-8888 Fax 281-288-8810</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

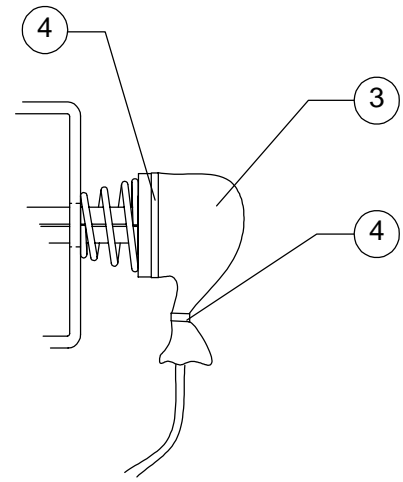
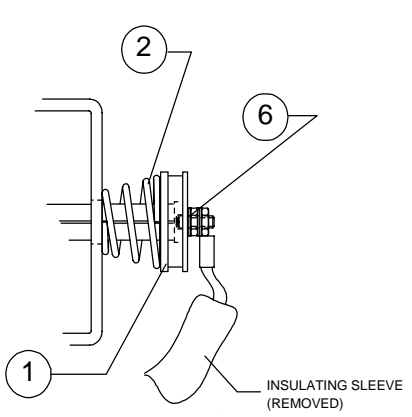
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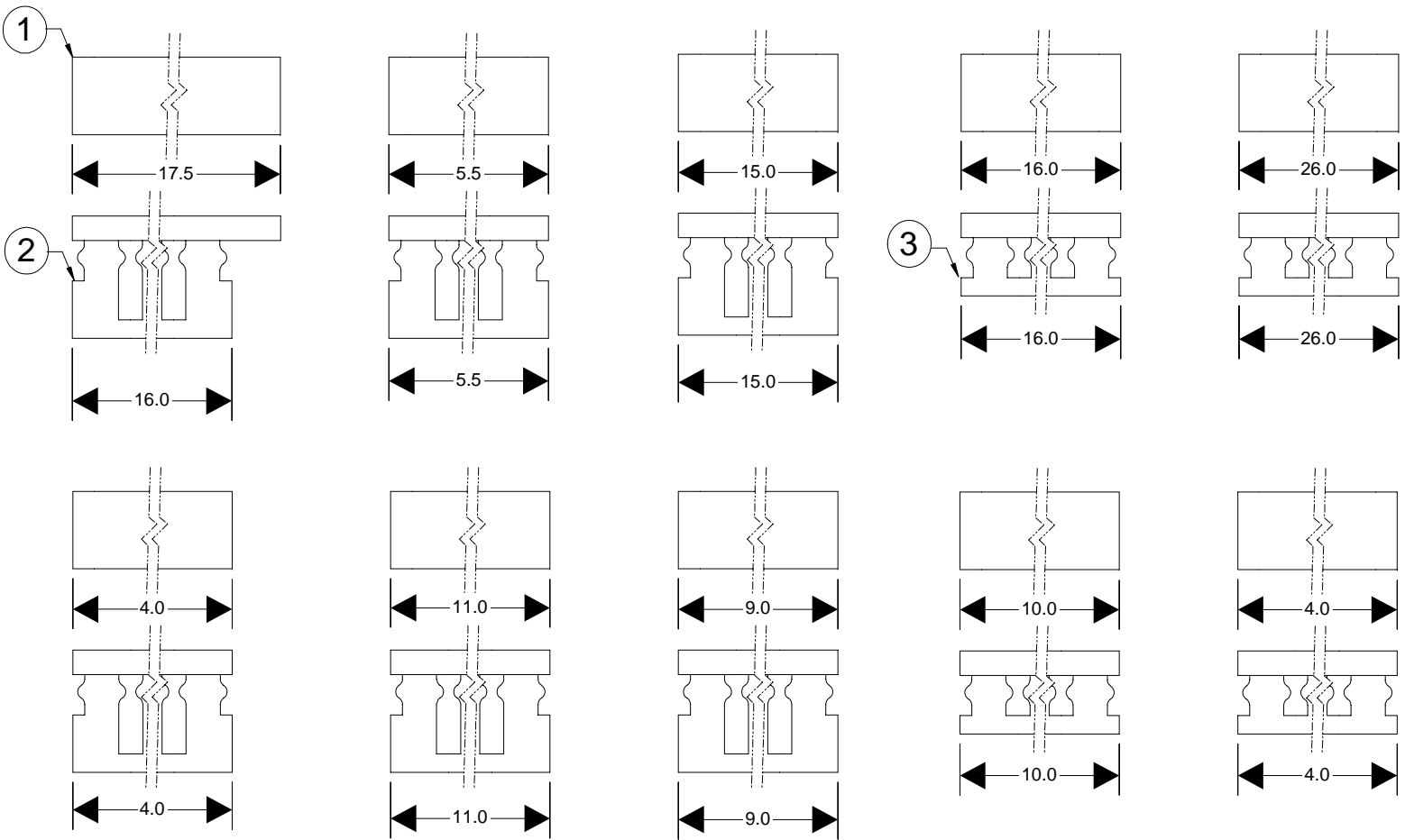
- △ A
- △ A
- △ A
- △ A
- △ A

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
		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		1 TO BE		DUCT, WIRE, SET, MAIN CHASSIS		
X	P. 250		✓		ORCA I		
X.X	P. 320						
.XXX	P. 010		ANGLES	DATE	DRAWN BY:	DWG SCALE:	Dwg
X.XXX	P. 006		P. 10	07-10-96	RLM	C1	180-150