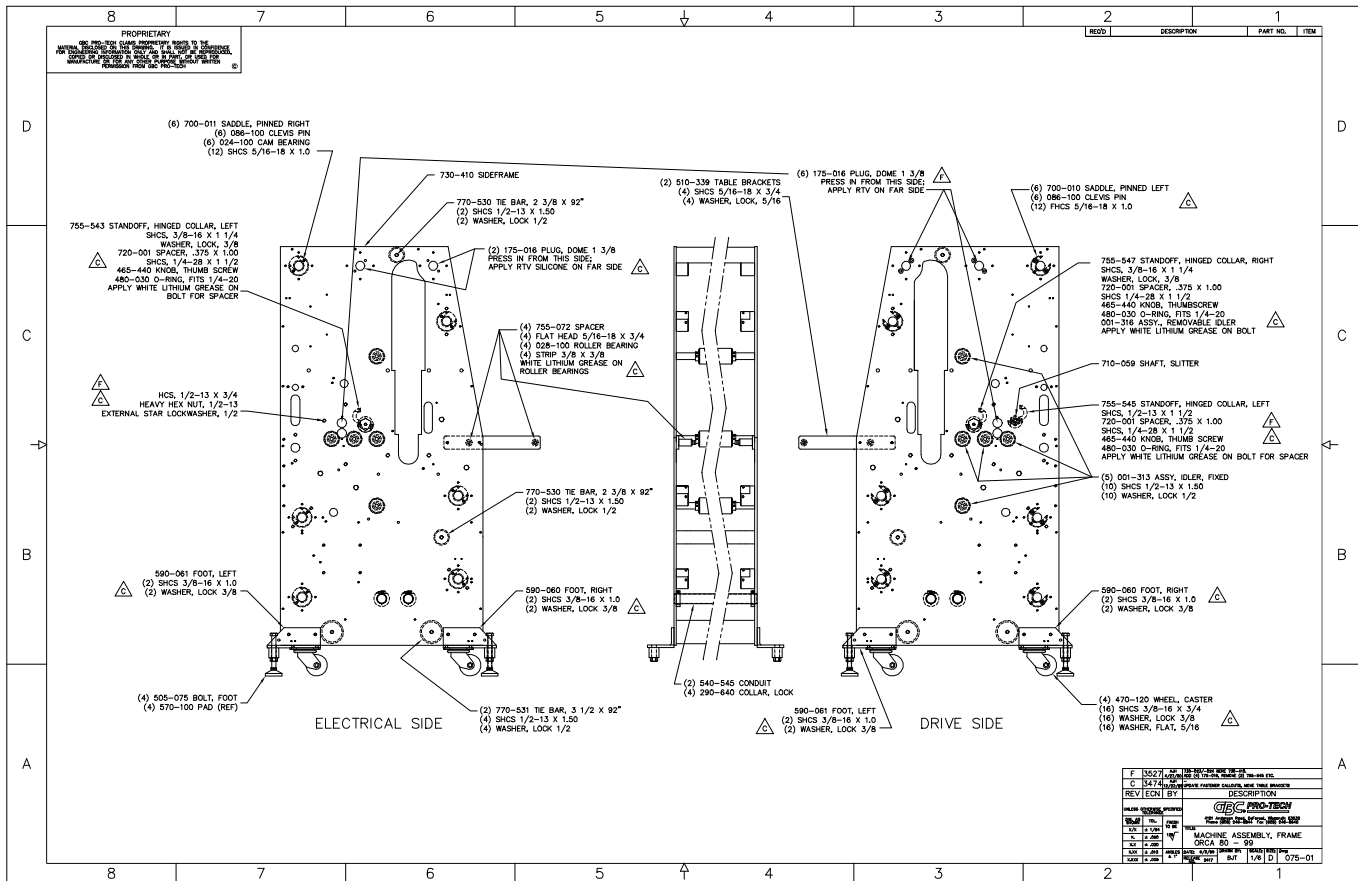




F	1/2-13 X 3/4	HEAVY HEX NUT, 1/2-13
C	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
REV	BY	DESCRIPTION
1	1/2-13 X 3/4	HEAVY HEX NUT, 1/2-13
2	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
3	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
4	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
5	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
6	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
7	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
8	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
9	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
10	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
11	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
12	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
13	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
14	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
15	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
16	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
17	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
18	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
19	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
20	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
21	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
22	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
23	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
24	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
25	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
26	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
27	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
28	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
29	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
30	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
31	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
32	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
33	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
34	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
35	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
36	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
37	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
38	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
39	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
40	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
41	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
42	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
43	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
44	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
45	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
46	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
47	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
48	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
49	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
50	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
51	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
52	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
53	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
54	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
55	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
56	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
57	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
58	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
59	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
60	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
61	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
62	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
63	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
64	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
65	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
66	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
67	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
68	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
69	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
70	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
71	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
72	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
73	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
74	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
75	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
76	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
77	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
78	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
79	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
80	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
81	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
82	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
83	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
84	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
85	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
86	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
87	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
88	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
89	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
90	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
91	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
92	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
93	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
94	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
95	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
96	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
97	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
98	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
99	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2
100	1/2-13 X 3/4	EXTERNAL STAR LOCKWASHER, 1/2

(2) 028-003 ROLLER BEARING, B-1812

(2) 032-260 THRUST WASHER, TRB-2233

(2) 560-076 DROP WASHER, MOD.

(2) 755-013 SPACER, FULL ROLL

(2) 290-450 LOCK COLLAR, 1 1/8

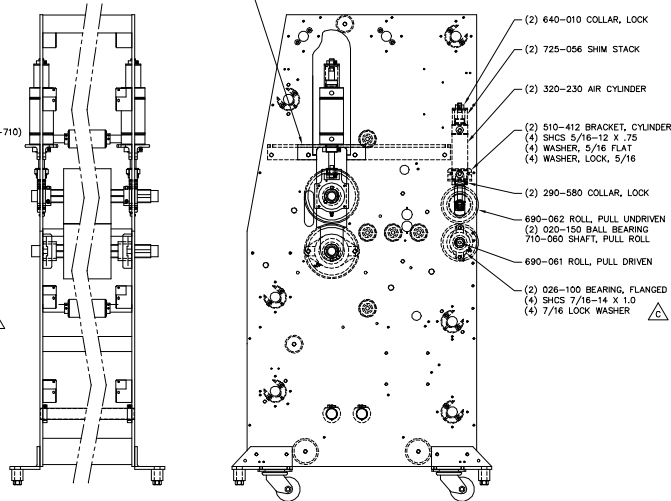
(2) 090-130 SNAP RING

(2) 032-410 THRUST WASHER, TRA-2031

(2) 059-130 WAVE SPRINGER

(2) 640-019 MOD LOCK COLLAR, 1/2 X 20

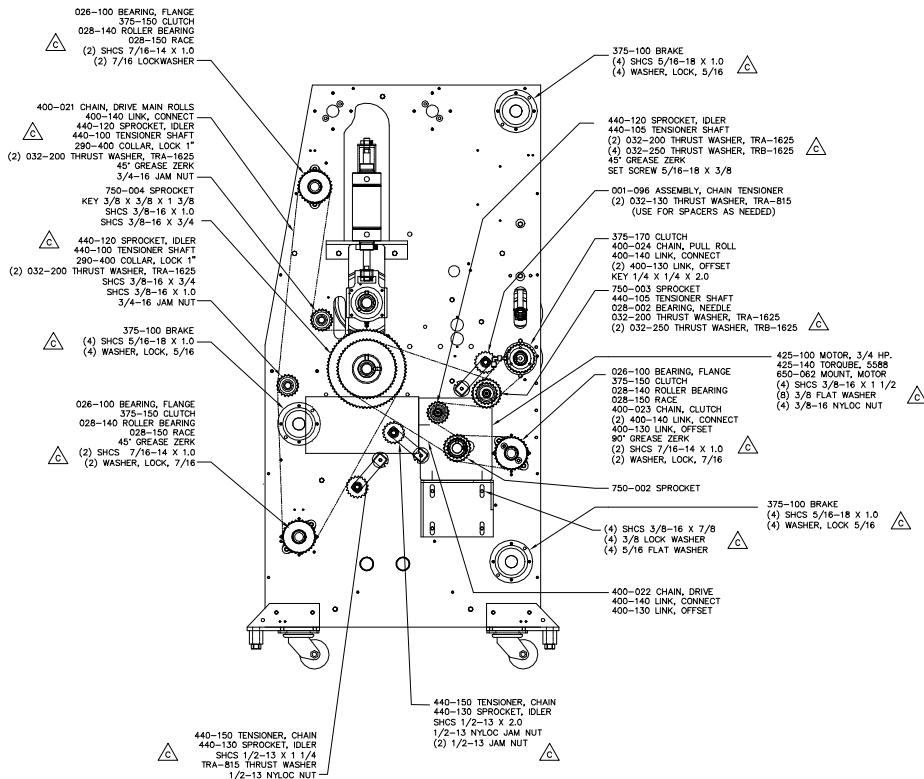
550-415 CYLINDER MOUNT
550-417 CYLINDER MOUNT
(2) SHCS 1/2-13 X 2.0
(2) SHCS 1/2-13 X 1 1/2
(4) 1/2-13 NYLOC NUT
(26") MAGNET TAPE (FLOOR STOCK 475-710)



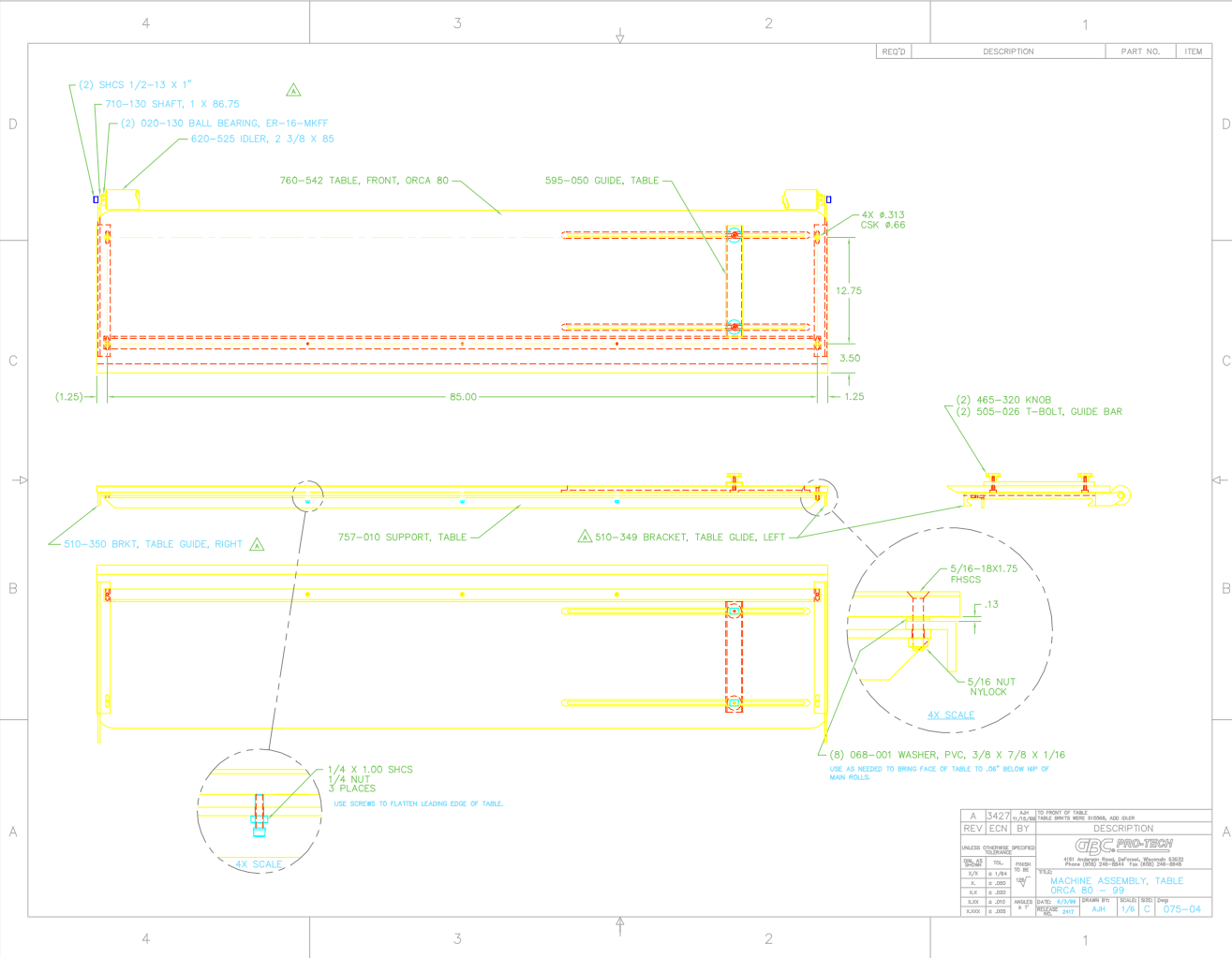
DRIVE SIDE

C	3474	AH	17-70	CORRECTED PARTNER CALLOUTS				
REV	ECN	BY		DESCRIPTION				
UNLESS OTHERWISE SPECIFIED								
TOL. DIM. FIN.				451 Ashland Road, Dairfield, Missouri, 63023 Phone (302) 849-8844 Fax (302) 849-8848				
TYPICAL TOLERANCE				TITLE:				
1/8"	± .004	FRACTION TO BE USED	1/32"	MACHINE ASSEMBLY, MAIN AND PULL ROLLERS, ORCA 80 99				
.001"	± .002							
.002"	± .002							
.005"	± .002							
.010"	± .002							
ANGLES < 90°				DATE: 6/2/98	DRAWN BY: BJT	SCALE: 1/8"	BIND: D	SUPP: 075-02
				BY: JLA				

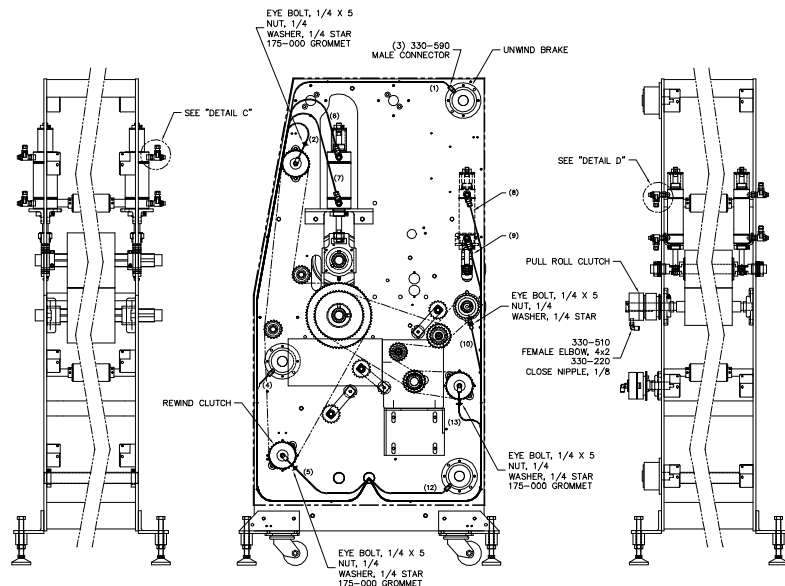
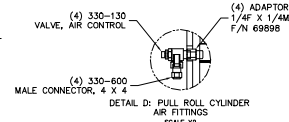
PROPRIETARY
GBC PRO-TECH CLAIMS PROPRIETARY RIGHTS TO THE
MATERIALS AND DESIGN OF THIS MACHINE. NO PARTS
FOR REPRODUCTION OR REPAIR SHALL BE MADE OR
USED IN ANY MANNER WITHOUT THE WRITTEN
PERMISSION FROM GBC PRO-TECH



C 3474		REVISED		DESCRIPTION	
REVISION BY		DATE		DESCRIPTION	
1		1/1/87		MACHINE ASSEMBLY, DRIVE	
2		1/1/87		ORCA 80 - 89	
3		1/1/87		1/2-13 NYLON JAM NUT	
4		1/1/87		1/2-13 NYLON JAM NUT	
5		1/1/87		1/2-13 NYLON JAM NUT	
6		1/1/87		1/2-13 NYLON JAM NUT	
7		1/1/87		1/2-13 NYLON JAM NUT	
8		1/1/87		1/2-13 NYLON JAM NUT	



4. USE APPROX. 50 EACH CABLE TIES AND CABLE TIE BASE 175-004 TO SECURE HOSES TO CABINET.

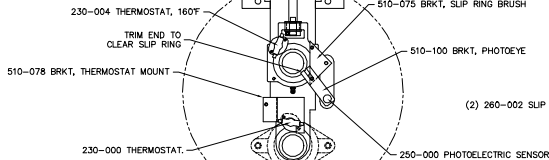


C 3474	REV	ECN	BY	DATE	DESCRIPTION
					ADD -20 TO 1/4 FASTENER GULLNOT
MATERIALS SPECIFIED					 451 Arden Road, Forest, Georgia 30533 Phone (608) 293-8844 Fax (608) 293-8848
QTY	UOM	TO/L	FINISH	TITLE	
X/8	1	10.0	TO BE	MACHINE ASSY, PNEUMATICS	
X/1	0.060			ORCA 80 - 99	
X/2	0.000				
X/3	0.000				
X/4	0.000				
X/5	0.000				
X/6	0.000				
X/7	0.000				
X/8	0.000				
X/9	0.000				
X/10	0.000				
X/11	0.000				
X/12	0.000				
X/13	0.000				
X/14	0.000				
X/15	0.000				
X/16	0.000				
X/17	0.000				
X/18	0.000				
X/19	0.000				
X/20	0.000				
X/21	0.000				
X/22	0.000				
X/23	0.000				
X/24	0.000				
X/25	0.000				
X/26	0.000				
X/27	0.000				
X/28	0.000				
X/29	0.000				
X/30	0.000				
X/31	0.000				
X/32	0.000				
X/33	0.000				
X/34	0.000				
X/35	0.000				
X/36	0.000				
X/37	0.000				
X/38	0.000				
X/39	0.000				
X/40	0.000				
X/41	0.000				
X/42	0.000				
X/43	0.000				
X/44	0.000				
X/45	0.000				
X/46	0.000				
X/47	0.000				
X/48	0.000				
X/49	0.000				
X/50	0.000				
X/51	0.000				
X/52	0.000				
X/53	0.000				
X/54	0.000				
X/55	0.000				
X/56	0.000				
X/57	0.000				
X/58	0.000				
X/59	0.000				
X/60	0.000				
X/61	0.000				
X/62	0.000				
X/63	0.000				
X/64	0.000				
X/65	0.000				
X/66	0.000				
X/67	0.000				
X/68	0.000				
X/69	0.000				
X/70	0.000				
X/71	0.000				
X/72	0.000				
X/73	0.000				
X/74	0.000				
X/75	0.000				
X/76	0.000				
X/77	0.000				
X/78	0.000				
X/79	0.000				
X/80	0.000				
X/81	0.000				
X/82	0.000				
X/83	0.000				
X/84	0.000				
X/85	0.000				
X/86	0.000				
X/87	0.000				
X/88	0.000				
X/89	0.000				
X/90	0.000				
X/91	0.000				
X/92	0.000				
X/93	0.000				
X/94	0.000				
X/95	0.000				
X/96	0.000				
X/97	0.000				
X/98	0.000				
X/99	0.000				
X/100	0.000				

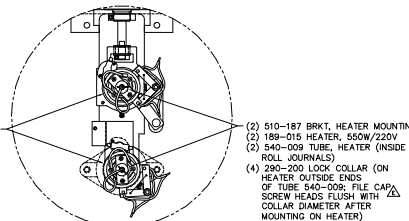
PROPRIETARY
 THE PRO-TECH CLASS PROGRAMS RIGHTS TO THE
 MATERIALS CONTAINED HEREIN, INCLUDING BUT NOT LIMITED TO
 THE DESIGN, CONSTRUCTION, AND OPERATION, IS THE PROPERTY OF
 PRO-TECH. NO PART OF THIS DOCUMENT MAY BE REPRODUCED OR
 TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR
 MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY
 INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT THE
 WRITTEN PERMISSION FROM PRO-TECH.

NOTES:

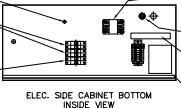
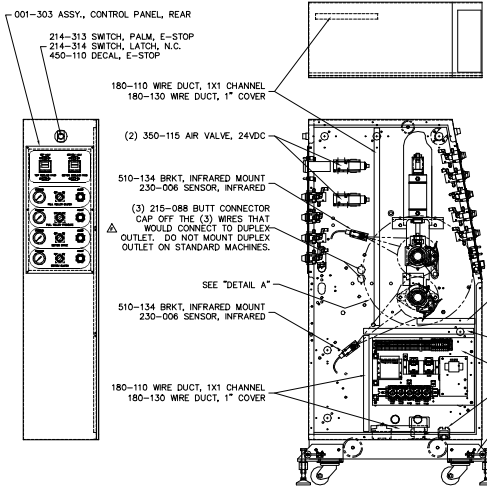
1. APPLY LOC-TITE-BLUE TO ALL ELECTRICAL FASTENERS.
2. REF. 810-088 WIRING SCHEMATIC FOR WIRING CONNECTIONS.
3. USE WIRE DUCT 180-110 (72 in.), WIRE DUCT 180-140 (72 in.), AND WIRE DUCT COVER 180-130 (144 in.) FOR WIRE ROUTING WHERE SHOWN.
4. SECURE REMAINING LOOSE WIRES TO CABINET USING CABLE TIES AND UL APPROVED CABLE TIE BASE 175-004 (50 PCS).



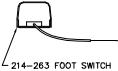
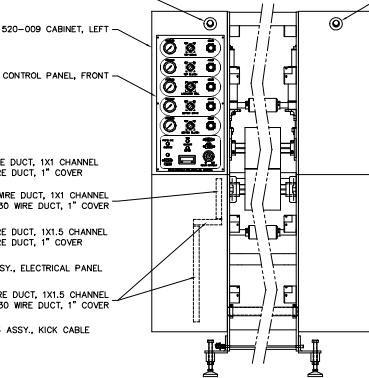
DETAIL A, SLIP RINGS AND
 HEATERS REMOVED
 SCALE X 2



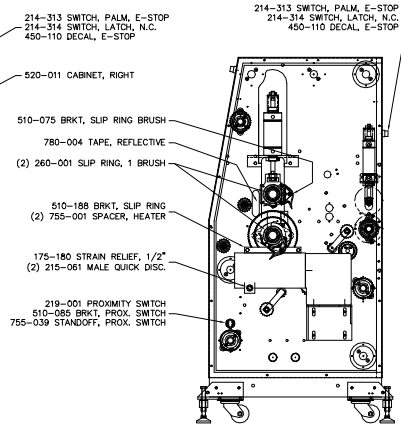
DETAIL A, SLIP RINGS AND
 HEATERS SHOWN
 SCALE X 2



ELEC. SIDE CABINET BOTTOM
 INSIDE VIEW



214-263 FOOT SWITCH



F	3627	REV	180-110 WIRE DUCT, 1X1 CHANNEL
E	3627	REV	180-130 WIRE DUCT, 1" COVER
REV	180-110 WIRE DUCT, 1X1 CHANNEL	BY	DESCRIPTION
180-110 WIRE DUCT, 1X1 CHANNEL	180-130 WIRE DUCT, 1" COVER	180-140 WIRE DUCT, 1X1.5 CHANNEL	180-130 WIRE DUCT, 1" COVER
180-140 WIRE DUCT, 1X1.5 CHANNEL	180-130 WIRE DUCT, 1" COVER	001-353 ASSY., ELECTRICAL PANEL	001-306 ASSY., KICK CABLE
001-353 ASSY., ELECTRICAL PANEL	001-306 ASSY., KICK CABLE	175-000 GROMMET	(2) 186-510 CIRCUIT BREAKER, 32A
(2) 186-510 CIRCUIT BREAKER, 32A	186-545 CIRCUIT BREAKER, 10A	210-000 CONTACTOR	185-000 RECTIFIER, STD RECOVERY
210-000 CONTACTOR	185-000 RECTIFIER, STD RECOVERY	175-180 STRAIN RELIEF, 1/2"	180-140 WIRE DUCT, 1X1.5 CHANNEL
180-140 WIRE DUCT, 1X1.5 CHANNEL	180-130 WIRE DUCT, 1" COVER	450-007 PRIMARY WIRING DECAL	
450-007 PRIMARY WIRING DECAL			

RECEIVED: 10/10/00
 DATE: 10/10/00
 BY: [Signature]
 TITLE: [Signature]
 MACHINE ASSEMBLY, ELECTRICAL
 ORCA 80 - 99
 REVISION: 10/10/00
 DATE: 10/10/00
 BY: [Signature]
 TITLE: [Signature]
 MACHINE ASSEMBLY, ELECTRICAL
 ORCA 80 - 99
 REVISION: 10/10/00
 DATE: 10/10/00
 BY: [Signature]
 TITLE: [Signature]

