OR-T 231-C2F/C4F
Automatic strapping machine
Vertical strapping
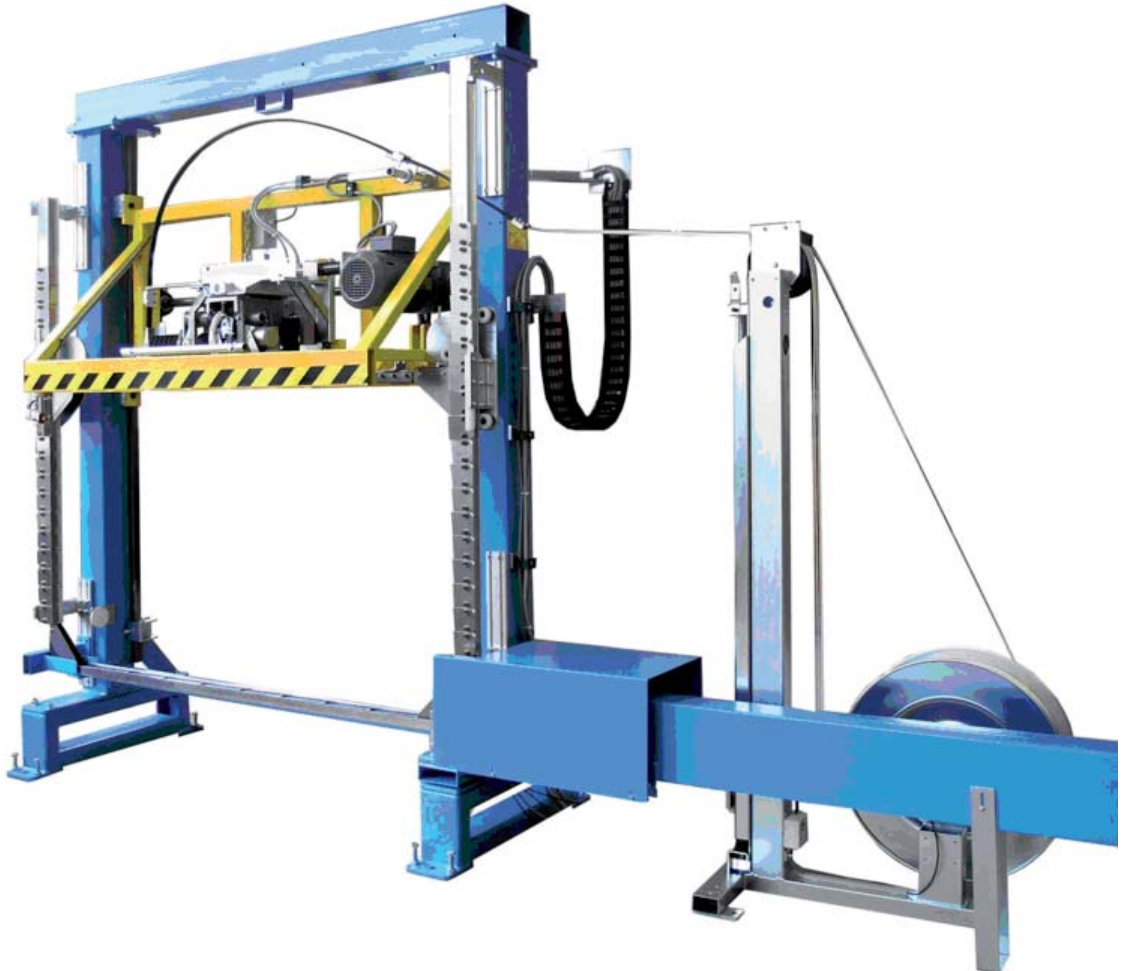
Customer benefits

Characteristics	Customer benefits
Segmented track system	· Strap infeed at all heights possible
Adjustable, electronically controlled strap tension, floating head	· Maximum product securing during transportation thanks to balanced strap tension around the package
User-friendly control panel with push buttons and display	· Easy operation · Secure continuous duty
Robust and proven design with first class industrial components	· High availability · Low maintenance cost

OR-T 231-C2F/C4F
Technical data

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Machine

Strapping cycle time	Per strap, approx. 10 s (Underfeed) 17 s (Lance)
Strap tension	200–2200 N (head OR-T 230) 500–5000 N (head OR-T 240) Adjustable by potentiometer, electronically controlled Floating head ensures equalised strap tension around package
Strap tensioning way of the strapping head	200 mm (head OR-T 230) Unlimited (head OR-T 240)
Carriage vertical speed	Approx. 160 mm/s
Sealing method	Heat weld sealing system for PP and PET, simple adjustment
Conveying heigth	From 320 mm

Arch dimensions	See page 4
Sword or underfeed	Lance: For Euro pallets Underfeed: For packages
Strap dispenser	Separate strap dispenser with accumulator
Strap end	Automatic strap end detection
Colours	Frame: Blue, RAL 5012 Movable parts: Yellow, RAL 1023 Control desk: Grey, RAL 7035
Electrical supply	400 VAC, 50 Hz, 3PE Rated power 4 kW
Compressed air	5–6 bar Consumption 16 Nl/cycle
Machine weight	Approx. 1500 kg

Conveyor

The conveying systems is not part of the OR-T 231-C2F/C4F machine

Control system

Stand alone control desk
The Man Machine Interface consists of
– Main switch and Emergency push button
– Push button for various start functions
– Selector swiches for machine mode and program
– Potentiometer for strap tension selection
– Indicator lamps for machine on condition indication
– Numerical display for machine condition indication

Standard strapping programs
– Service
– Manual
– Automatic
– Pass through

PLC Simatic S7-300

Interface, signal exchange
All signals for exchange must be potential free

The strapping machine is able to receive the following signals
– Start of the selected strapping program
– Confirmation: Conveyor not in motion
– External Emergency-Stop is activated
– External safety clear (light barriers, access door etc.

The strapping machine sends the following signals
– Strapping program completed (automatic mode)
– Conveyor release
– Activated emergency-Stop on the strapping machine

Detailed description "Signal Exchange" available

Strap

Polyester (PET)	Width	12, 16, 19 mm
	Thickness	0,56–0,8 mm
Polypropylene (PP)	Width	12, 16, 19 mm
	Thickness	0,7–0,85 mm

Core size	Ø	406 mm
	Width	152 mm

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Features

Simple operation
User friendly control panel

Numerical display for machine condition indication

Segmented track system
Strap infeed at all heights possible

Maximum product securing during transportation
Adjustable strap tension, electronically controlled, floating head for balanced strap tension around the package

Long life cycle and low maintenance cost
First class industrial components, e.g. SEW motors, powered by frequency controller for fast movement and precise control
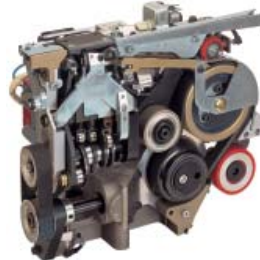
Options

Top compression
2000–6000 N,
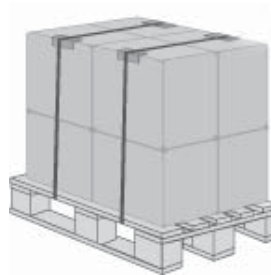fully adjustable

Strapping head OR-T 240
(instead of OR-T 230)
For high tension applications (500–5000 N)

Top edge protector device "SE"
See drawing
1884-300-052 and
STX SE 03 02 10
Warning min. corner in magazine
(not in combination with top compression)

Min. package height 200 mm (incl. pallet)
For machine with sword, instead of min. 450 mm

Max. package height 2350 mm (incl. pallet)
Instead of max. 1850 or 1350 mm

Strap end pre-warning
To ensure short machine downtimes when changing coils

Flash light
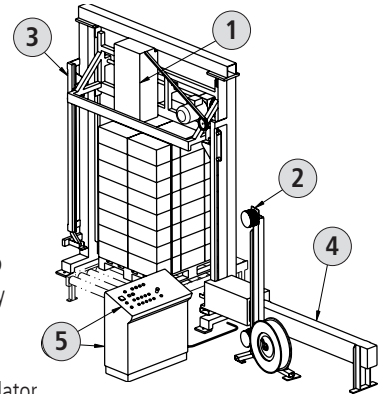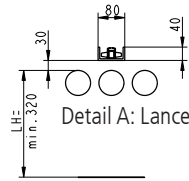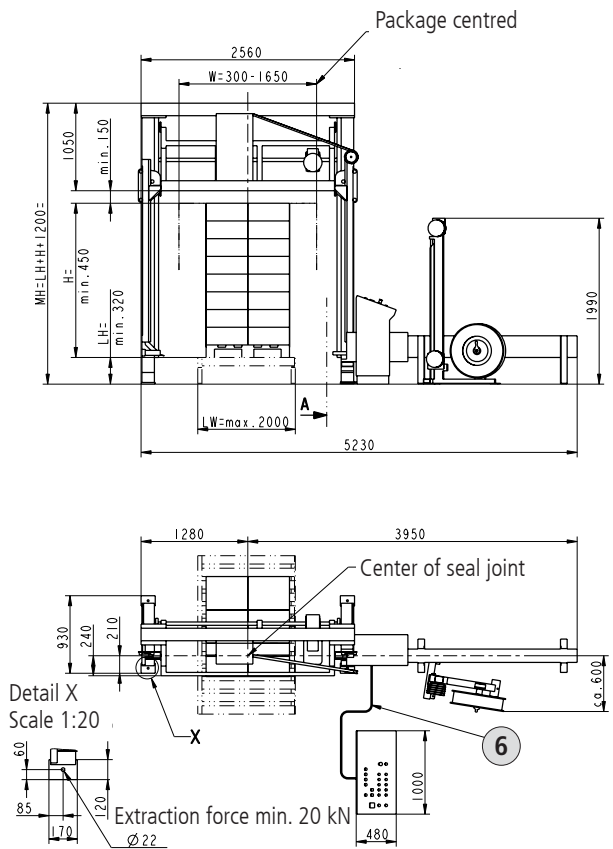General fault signal with red indicator lamp

Control components for one conveyor
Consists of
– Two outputs for one
   motor (0,7–1,1 kW)
– Three inputs for light
   barriers
Without software

Package centred

2560
W=300-1650
1050
min.150
MH=LH+HH+1200
H= min.450
LH= min.320
1990
LW=max.2000
A
5230

Detail A: Lance
80
30
40
LH= min.320

1280
3950
Center of seal joint
930
240
210
ca.600
Detail X
Scale 1:20
X
60
85
120
L70
Ø22
Extraction force min. 20 kN
480
1000

(1) Strapping head for high strap tension, operational reliability and easy maintenance

(2) Strap dispenser with accumulator

(3) Telescope strap guide

(4) Lance with friction drive, adjustable height ± 15 mm

(5) Control system with programmable controller

(6) Cable length standard: 3 m (optional ... m according order)

Arch dimensions OR-T 230-C2F/C4F
Arch width and arch height can be combined

| Package width | 300–850 | 300–1250 | 300–1650 |
Package height	(W* = 850)	(W* = 1250)	(W* = 1650)
450–2350 (H = 2350)	Special	Special	Special
450–1850 (H = 1850)	Standard	Standard	Standard
450–1350 (H = 1350)	Standard	Standard	Standard

* Max.

Standard
Special

H = Arch height
W = Arch width