

## OR-T 231-B1F/B2F/B5F

# Automatic strapping machine Vertical strapping with side seal



### Customer benefits

#### Characteristics

Machine equipped with sword, can be placed on floor level

Indexing strapping head, stroke automatically adapting to load

Compact design  
Control cabinet and dispenser integrated

User-friendly control panel with push buttons and symbols

Robust and proven design with first class industrial components

#### Customer benefits

· Automatic pallet strapping on floor level possible

· Tight strap tension, even for varying load widths

· Less space required

· Easy operation  
· Secure continuous duty

· High availability  
· Low maintenance cost

## Technical data

### Machine

<b>Strapping cycle time per strap</b>	With lance 11–16 s With underfeed 8–14 s Depending on – Arch and package sizes – Head stroke – Strap PP or PET – Adjusted strap tension	<b>Strapping heights (from conveyor level)</b>	Min. 750 mm (incl. pallet)
<b>Strap tension</b>	200–2200 N Adjustable by potentiometer	<b>Arch dimensions</b>	See page 4
<b>Lance or underfeed</b>	Pallet loads: Lance No pallets: Underfeed	<b>Strap dispenser</b>	Mounted on sword box or laterally on the floor
<b>Indexing head</b>	– Up to arch size 1675 mm Head stroke 320 mm – Up to arch size 1900 mm Head stroke 570 mm	<b>Colours</b>	Machine frame: Light blue, RAL 5012 Head frame, strapping arch: Traffic yellow, RAL 1023 Control cabinet: Light grey, RAL 7035
<b>Sealing method</b>	Heat weld sealing system for PP and PET strap, simple adjustment Pre-heating time 90 s	<b>Electrical supply</b>	400 VAC, 50 Hz, 3PE Rated power 2 kW
		<b>Compressed air</b>	6 bar / 95 psi Consumption 30 NI/cycle
		<b>Machine weight</b>	Approx. 550 kg

### Conveyor

The conveying systems is not part of the OR-T 231-B1F/B2F/B5F machines

### Control system

#### Control cabinet mounted on machine frame

Order selection: in feed side or down stream side

#### Operating MMI consists of

- Main switch and Emergency push button
- Push button for various start functions
- Selector switches for machine mode
- Potentiometer for strap tension selection
- Indicator lamp for machine condition indication

#### PLC Simatic S7-224

#### Interface, signal exchange

All signals for exchange must be potential free

#### The strapping machine is able to receive the following signals

- Start of strapping cycle
- External Emergency-Stop is activated

#### The strapping machine sends the following signals

- Strapping program completed  
Machine ready
- General fault

### Strap

<b>Polypropylene (PP)</b>	Width 12, 16 mm Thickness 0,65–0,85 mm	<b>Core size</b>	Ø 406 mm Width 152 mm
<b>Polyester (PET)</b>	Width 12, 16 mm Thickness 0,56–0,80 mm	<b>Strap end</b>	Automatic strap end detection and ejection

## Features

### Simple operation

User friendly control panel



### Service aspects

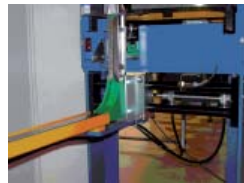
Fast and easy head change due to head mounted by only four screws and all electrical connections by one plug



## Options

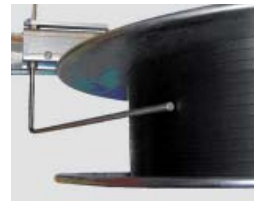
### Lance and underfeed

To strap loads with or without pallets (includ elevation supports)  
Conveying height min. 190 mm



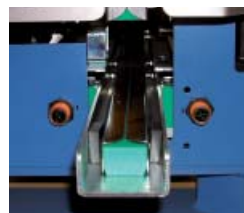
### Strap end pre-warning

To ensure short machine downtimes when changing coils



### Lance area control

Sword protection, for manual load positioning



### Indicator lamp

Red General fault  
Orange Strap end  
Green Machine ON



### Head doors with hinges

Quick opening of the head covers for maintenance

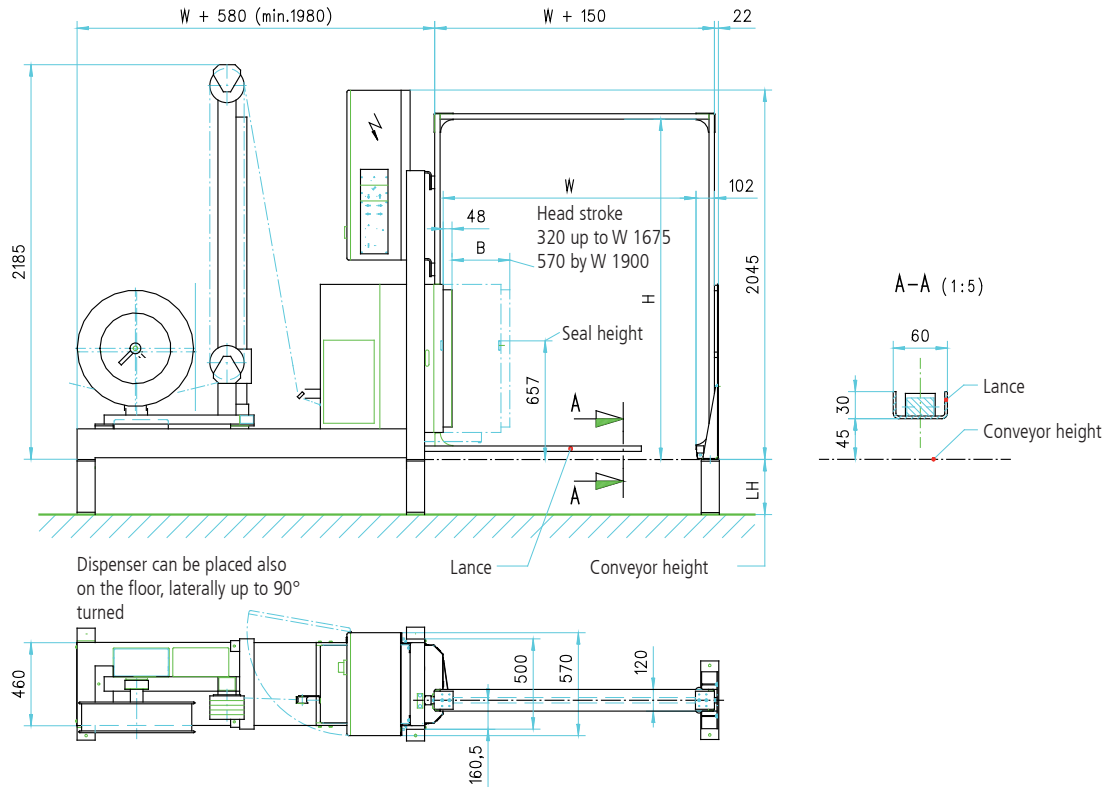


### Support feet

For flexible conveyor height (to suit customers conveyor)



**Layout:  
Variant with sword**



**Arch dimensions  
OR-T 231-B1F/B2F/B5F**

Package width	< 630 (W = 760)	< 1000 (W = 1170)	< 1250 (W = 1400)	< 1550 (W = 1700)	< 1750 (W = 1880)
<b>Package height</b>					
<b>750-3000</b> (H = 3095)					
<b>750-2800</b> (H = 2865)					
<b>750-2700</b> (H = 2795)					
<b>750-2300</b> (H = 2385)					
<b>750-1800</b> (H = 1865)					
<b>750-1400</b> (H = 1455)					
<b>750-1000</b> (H = 1045)					

Standard  
Spezial

H = Arch height  
W = Arch width

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