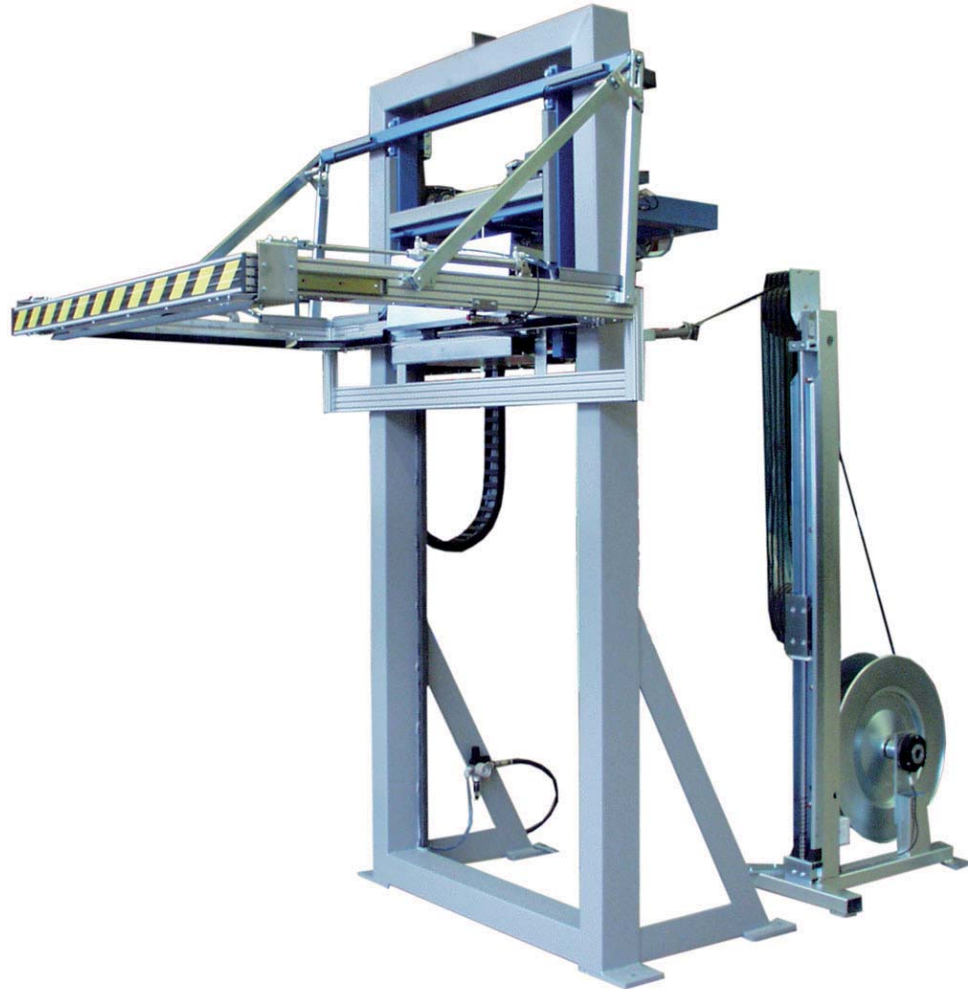


OR-T 231-D1LF

Automatic strapping machine Horizontal strapping



Customer benefits

Characteristics

Teach-In programming via control panel

Adjustable, electronically controlled strap tension, floating head

Safety system for vertical movement

User-friendly control panel with push buttons and display

Robust and proven design with first class industrial components

Customer benefits

· Short set-up time, high flexibility

· Maximum product securing during transportation thanks to balanced strap tension around the package

· High operation safety

· Easy operation
· Secure continuous duty

· High availability
· Low maintenance cost

OR-T 231-D1LF

Technical Data



Machine

Strapping cycle time	Approx. 9 s per strap
Vertical speed	Approx. 200 mm/s Automatic stop of vertical movement in case of obstacle
Strap tension	200–2200 N Adjustable by potentiometer, electronically controlled Floating head ensures equalised strap tension around pack
Indexing head	Horizontal stroke Max. 400 mm Approx. speed 100 mm/s
Sealing method	Heat weld sealing system for PP and PET, simple adjustment
Min. strapping height	From 90 mm above transport height resp. from 250 mm above floor
Max. strapping height	Up to 1675 mm (H16) or up to 2175 mm (H21)

Arch dimensions	See page 4
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 Voltage tolerance +/-5% Rated power 1,8 kW
Compressed air	5–6 bar Consumption 16 NI/cycle
Machine weight	Approx. 900 kg
Packaging size/weight	Standard package for truck Width 2300 mm Length 4000 mm Height 2200 mm Gross weight approx. 1100 kg

Conveyor

The conveying systems is not part of the OR-T 231-D1LF 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 switches 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

- Pass through
- 1–9 programs, selectable by selector switch on the desk or by 4 inputs with BCD-Code from external control
- Up to 6 strap positions per program, programmable by Teach-In function

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 strapping program selection by BCD-Code
- External Emergency-Stop is activated
- External safety clear (light barriers, access door etc.)

The strapping machine sends the following signals

- Strapping program completed
- Enabled conveyor motion
- Activated emergency-Stop on the strapping machine

Detailed description "Signal Exchange" available

Strap

Polyester (PET)	Width	9, 12, 16 mm
	Thickness	0,56–0,8 mm
Polypropylene (PP)	Width	12–16 mm
	Thickness	0,65–0,85 mm

Core size	Ø	406 mm
	Width	152 mm

Features



Simple operation

User friendly control panel
Numerical display to indicate machine status



Maximum product securing during transportation

Adjustable strap tension, electronically controlled, floating head for balanced strap tension around the package



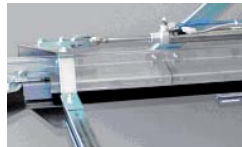
Long life cycle and low maintenance cost

First class industrial components, e.g. SEW motors, powered by frequency controller for fast movement and precise control

Options

Strap centering unit

For precise strap positioning, pneumatically powered.



Photocell Teach-In start on top of pallet

Allows to store and work with the strapping programs in relation to the top of the pallet. Ensures proper strapping in case of variation of pack heights.



Simatic-Touchpanel TP 177

User-friendly guidance with HMI touchpanel



Upgrade for additional programs and strap positions

Teach-In system for

- 19 programs x 1-6 strap positions
- 10 programs x 1-19 strap positions



Option package for glass bottle applications

- Strap centering unit with pushers at head side and at head opposite side
- Side pushers, adjustable, stroke 80 mm
- Two strap tensions, adjustable
- Sensor an additional signal, head at top position
- Additional signal "Pallet finished"

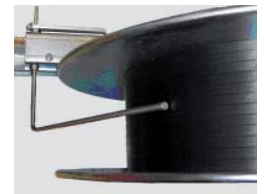


Max. strapping height

Upt to 2675 mm (H26) or up to 3175 mm (H31)
See also page 4

Strap end pre-warning

To ensure short machine downtimes when changing coils

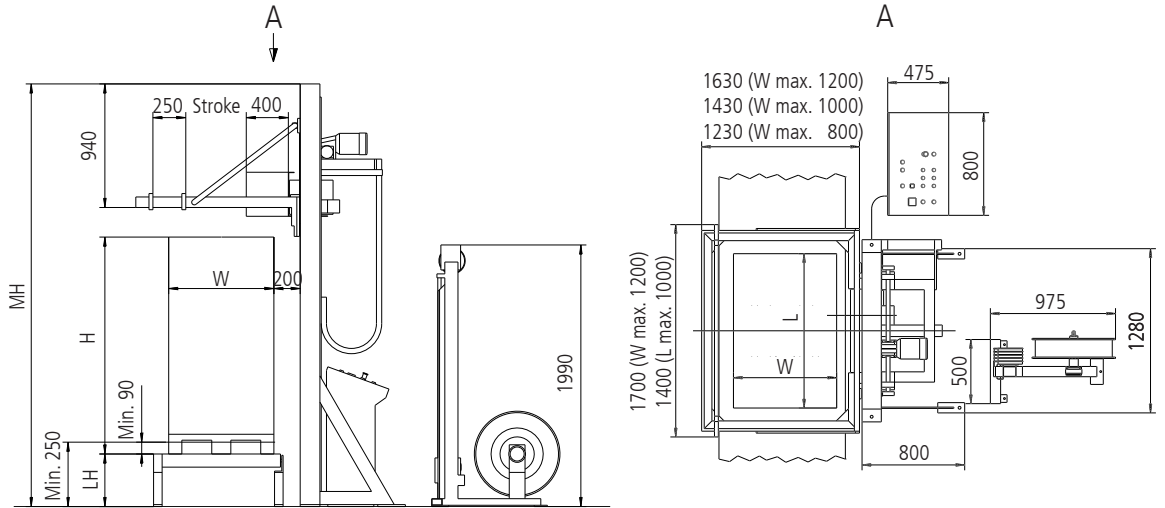


Flash light

General fault signal with red indicator lamp



Layout



**Arch dimensions
Working height
OR-T 231-D1LF**

Min. working height*	Max. working height* LH + H	Machine height MH	
Min. 250	1675	2710	Standard H16
resp.	2175	3210	Standard H21
min. 90 above LH	2675	3710	Special H26
	3175	4210	Special H31

* Above floor

Arch dimensions W x L	For package dimensions W x L
900 x 1480	500– 800 x 400–1200
1100 x 1480	500–1000 x 400–1200
1300 x 1480	800–1200 x 400–1000
1300 x 1480	800–1200 x 400–1200

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