OLIVER®

PRODUCTS COMPANY

GRAND RAPIDS, MICHIGAN, U.S.A. 49504–5298

USERS OPERATING AND INSTRUCTION MANUAL

MODEL 619

DOUGH PRESS

S20000-CVR

OLIVER PRODUCTS COMPANY
MODEL 619 DOUGH PRESS

INDEX

SAFETY INSTRUCTIONS

Various safety devices and methods of guarding have been provided on this machine. It is essential, however, that machine operators and maintenance personnel observe the following safety precautions. Improper installation or operation of this equipment may cause injury to personnel or equipment.

1. Read this manual before attempting to operate your machine. Never allow an untrained person to operate or service this machine.

2. Connect the machine to a properly grounded electrical supply that matches the requirements shown on the electrical specification plate and follow specifications of local electrical codes.

3. Disconnect and lock-out the machine from the power supply before cleaning or servicing.

4. Check and secure all guards before starting the machine.

5. Observe all caution and warning labels affixed to the machine.

6. Use only proper replacement parts.

7. Do not wear loose fitting clothing or loose hair. Shirt tails should be tucked in.

8. Wear proper personal safety equipment.

9. Keep Hands away from the moving parts of this machine while it is in operation.

10. In addition to these general safety instructions, also follow the more specific safety instruction given for the different areas of the machine in the operating instructions.

DO NOT USE FOR OTHER THAN ORIGINALLY INTENDED PURPOSE

OLIVER PRODUCTS COMPANY
MODEL 619 DOUGH PRESS

DESCRIPTION/SPECIFICATION

Description

The Oliver Dough Press consists of a hopper which can hold up to aproximately 35 pounds of dough (depending on the density). The lid and sides of the hopper are made of heavy cast aluminum The pressing plate located at the bottom of the hopper compresses the dough and is operated through hydraulics.

The hydraulic pump is powered by a 2 HP totally enclosed motor. The system has a built-in 4-1/2 gallon hydraulic oil tank making the machine totally self contained.

This machine is ideal for doughnut and bakery operations and is mounted on four casters for easy movement about the work area.

Dimensional Specifications

Size: 22" wide x 25" deep x 42-1/4" high
(See drawing on next page)

Weight:

Net Weight = 550 pounds

Shipping Weight = 600 pounds

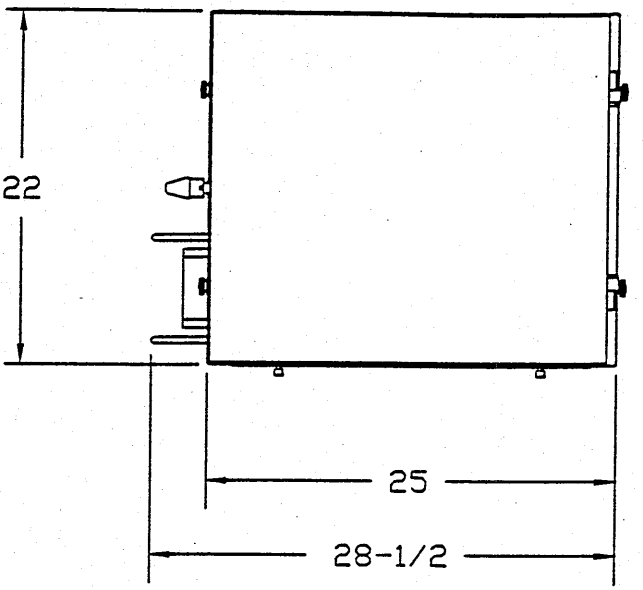
Capacity (Product):

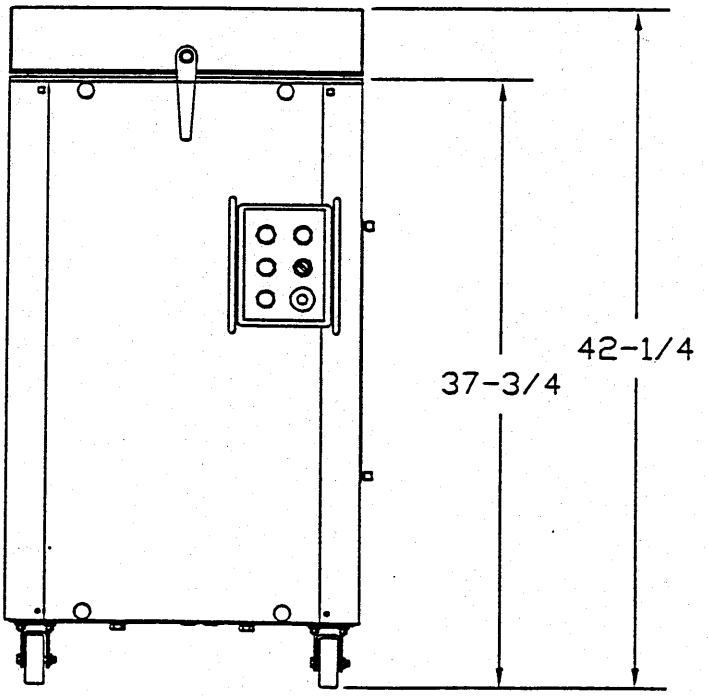
Fill Capacity (approximate) = 10-1/2 to 35 pounds.

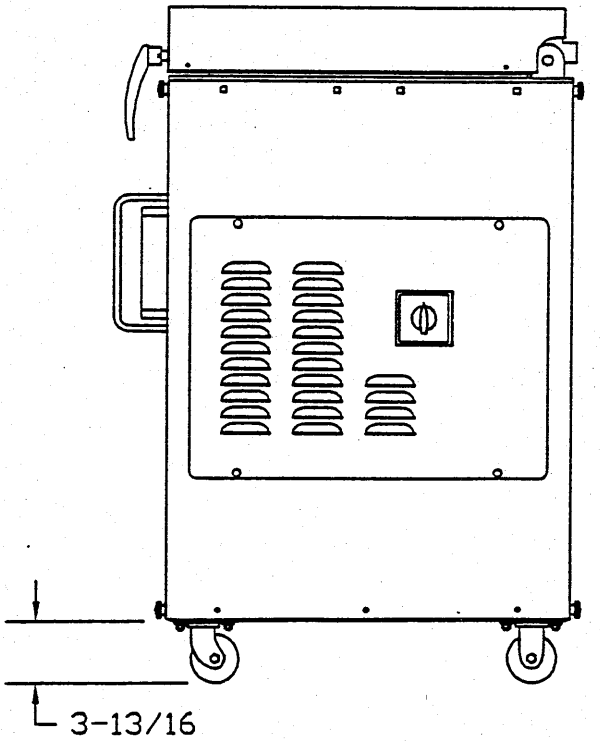
Electrical Specifications

Standard----------	2HP, 6.2 Amps, 3 ph, 60 hz, 230 VAC
Optional----------	2HP, 6.5 Amps, 3 ph, 60 hz, 208 VAC
Optional----------	2HP, 10 Amps, 1 ph, 60 hz, 230 VAC
Others_____	Consult factory

Physical Size Drawing







OLIVER PRODUCTS COMPANY
MODEL 619 DOUGH PRESS

OPERATING INSTRUCTIONS

Before You Start:

CAUTION

The Dough Press must be connected to a properly grounded electrical supply that matches the specifications shown on the machine data plate.

IMPORTANT:

ALL ELECTRICAL CONNECTIONS MUST BE MADE BY A QUALIFIED ELECTRICIAN

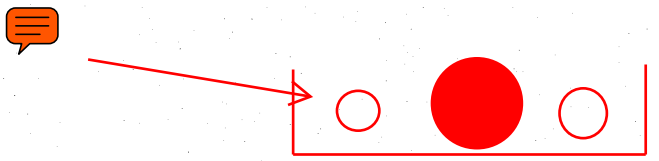
After connecting the Dough Press to the electrical supply, check to see if the motor is running in the correct direction. Remove the front cover by removing the four thumb screws which secure it. Once the cover has been removed you should be able to see the fan end of the motor on your Dough Press, this fan **MUST** rotate in a clockwise direction.

CAUTION

Extended running of a dough press with the motor rotating in the incorrect direction will severely damage the hydraulic pump of your Dough Press.

If the motor is rotating in the incorrect direction turn the machine off, disconnect it from the power supply and reverse two of the three power wires in the plug at the end of the power cord. DO NOT move the ground (green) wire.

Recheck the motor for proper rotation direction (clockwise looking at the fan end of the motor). Each time the machine is moved to a different power supply or has electrical work done that could alter the motor rotation, recheck the motor for proper rotation direction.



Controls:

1. **MOTOR START/STOP**
   Pulling out this button will "START" the motor. Pushing it in will "STOP" the motor. This button may also be considered as an "EMERGENCY STOP" button which will stop all operation of of the Dough Press at any given time.

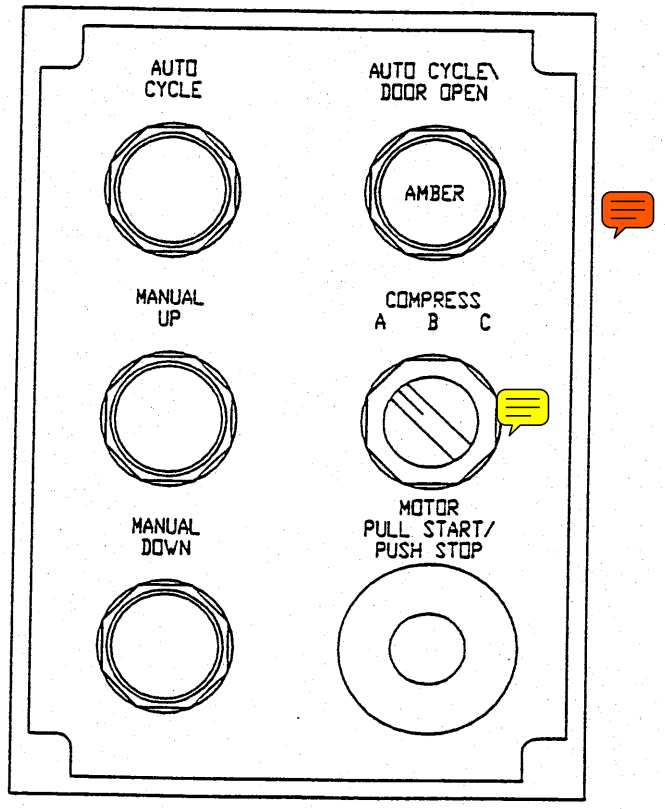


Figure 1.

2. **MANUAL UP**
   Push and hold to bring the Pressing Plate to top of the hopper.

3. **MANUAL DOWN**
   Push and hold to bring the Pressing Plate to the bottom of the hopper.
   A BUZZER will sound as plate lowers.

4. **COMPRESS**
   Selects the amount of pressure that is placed on the dough during the pressing cycle. Selection "A" being the least.

5. **AUTO CYCLE**
   This button will activate the pressing cycle, moving the pressing plate to the top of the hopper. After the maximum pressure is reached there is a 3-5 second delay. The buzzer will then sound and the cycle is reversed. The buzzer will stop when the pressure plate has returned to the bottom of the hopper, completing the pressing cycle.

6. **AUTO CYCLE\DOOR OPEN**
   This light, when on, indicates the "Auto Cycle" is in progress. Although, if the door is not completely closed and latched securely, the light will blink and the Auto Cycle will not be allowed to start.

Basic Operation

- Do not exceed loading capacity.
- Turn power on. This switch is located below the control panel.
- Pull MOTOR start.
- Set COMPRESS switch according to consistency of dough.
  A - soft dough
  B - moderate dough
  C - stiff dough
- Press and hold MANUAL DOWN button to lower Pressing Plate. Make sure the floor of the hopper (Pressing Plate) has been lowered before attempting to open the lid.
- Open the lid and load the dough into the hopper. Spread the dough over the floor of the hopper making it approximately the same height, this is done to eliminate large air pockets.
- Close the lid and turn the handle in a clockwise direction making sure it is secure.
- Push and release the AUTO CYCLE button. This will activate the pressing cycle. The button will light when the cycle is activated. The buzzer will sound after pressing takes place. When the buzzer stops, the pressing cycle is complete.
- Open lid.
- Push and hold the MANUAL UP button. The Pressing Plate will raise to carry the dough to the top of the hopper.
- Remove dough from the hopper.
- The above process may now be repeated.

AFTER THE DOUGH PRESSING HAS BEEN COMPLETED:

- Push MOTOR stop.
- Turn Power off.
- See cleaning instructions in the Maintenance section.

IMPORTANT:

EMERGENCY STOP BUTTON

Pushing the STOP button will cause total shutdown of Dough Press operation.

OLIVER PRODUCTS COMPANY
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MAINTENANCE

WARNING

Disconnect and lock-out from the power supply before cleaning or servicing.

Cleaning

The exterior and contact surfaces should be cleaned daily using common cleaners.

Occasionally, as required, you should also remove the build up of flour and dough particles in the base of the machine around the motor.

Lubrication

The machine requires no lubrication, but the oil level in the hydraulic system should be checked periodically. To check the oil level remove the rear cover by removing the four thumb screws which secure it to the dough press, then remove the tank breather/cap and determine where the top of the oil is in relation to the top surface of the tank. Fill to within (1) inch of the top surface. If necessary add HYDRAULIC OIL* to return it to the proper level, DO NOT OVERFILL. In addition to the above we advise replacing the hydraulic oil in the system approximately every three years.

*Hydraulic Oil Specification

The hydraulic oil used in your Dough Press should be made of good quality base stocks compounded with the following additives: antiwear, antioxidation, antifoaming, and antirust. In addition it should be an "ISO" viscosity grade No. 32.

Hydraulic Filter Replacement

Replace the throw-away filter on the hydraulic system at least once a year, more often when under heavy use. To replace the filter, remove the front cover, unscrew the old filter and replace. The filter is located on the return line near the tank.

NOTE: After replacing the filter, run the machine for 5 minutes and recheck the oil level. Add oil as necessary to restore to proper level.

Removing the Lid:

WARNING!

DISCONNECT FROM POWER SUPPLY AND LOCKOUT BEFORE REMOVING LID.

- Remove the lid cover by removing the four screws which secure it in position.

- Open the lid as far as it will go.

- Release the tension on the two large torsion springs by moving spring wire to the side and out from behind the spring clamp. **Use care as the lid will drop once the spring tension has been removed.**

- Close the lid and remove the Left Hand snap ring from the lid hinge pin and push the pin to the right to remove it.

- CHECK TO BE SURE POWER SUPPLY IS DISCONNECTED. Remove the cover of the wiring box. Take care to mark the wires for connecting sequence BEFORE disconnecting. Disconnect and pull the wires completelty out of the lid. Use panduit connectors to reconnect the wires.

- Reassemble by reversing the above steps.

Replacing the Locking Hook or Cam:

- Remove the lid cover by removing the four screws which secure it in position.

- Detach the spring from the hook.

- Open the lid.

- Loosen the set screw on the cam.

- Turn the handle until the pin securing the cam to the shaft is in line with the notch in the locking hook. Using a small drift punch force the pin upwards removing it from the handle shaft.

- Pull the shaft and cam assembly forward out of the lid.

- The hook or locking cam can now be replaced.

- Reassemble by reversing the above steps.

Replacing a Pressing Plate:

- Open the lid and raise the bottom of the hopper.
- Remove the front and rear and side panels to gain access to the pusher components.
- Remove the 16 screws securing the pressing plate to the backing plate.
- Using a narrow block of wood or other soft material, force the pressing plate upwards until it is free from the backing plate and then lift the pressing plate out of the cavity.
- Reassemble by reversing the above steps.

Removing the Backing Plate

- Remove the 16 screws that secure the pressing plate to the to the backing plate as described above.
- Remove the nut securing the backing plate to the cylinder rod. The backing plate can now be lifted from the machine.
- Use "Locktite" Thread Locker 242 on the nut to secure the backing plate to the cylinder rod. This adhesive will prevent loosening during operation. The remaining components can be reassembled by reversing the above steps.

Replacing the Hydraulic Cylinder:

- Push Manual Up button to bring hopper to the top of the machine.

WARNING!

DISCONNECT FROM POWER SUPPLY AND LOCKOUT BEFORE PROCEEDING WITH CYLINDER REPLACEMENT.

- Remove front, rear and side panels to access the cylinder area.
- Remove the pressing plate assembly, (see above procedures). Once this has been done, the nut securing the backing plate to the cylinder rod can be removed using a universal socket style wrench.
- Remove the bolts securing the limit switch bracket to the hex support rods. Do not disconnect the wires. (cont'd)

Replacing the Hydraulic Cylinder: (cont'd.)

- Remove 4 bolts securing the electrical enclosure to the frame. Do not disconnect wires. Set aside.

- Remove the eight screws securing the cylinder to the cylinder mounting channel.

- Remove the four bolts securing the cylinder mounting channel to the lower hex support rods.

- The upper portion of the Dough Press can now be removed and set to one side.

- Disconnect both high pressure hoses at the cylinder allowing removal of the cylinder for repair or replacement.

- When the machine is reassembled, the nut securing the thrust plate to the cylinder rod should be installed using "Loctite" thread locker 242 adhesive to prevent loosening during operation. All other components can be reinstalled by reversing the above steps.

Removing the Motor:

- Remove the front, rear and motor side panels.

- Remove the four screws securing the pump bracket to the motor.

- Remove the four nuts securing the motor to the base of the Dough Press.

- Remove the terminal cover on the motor and disconnect the wiring, remember to note the wire terminations to ease reassembly of the motor.

- The motor should now be free and can be removed by sliding the coupling apart and lifting the motor free of the machine.

- Reassemble by reversing the above steps.

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TROUBLE SHOOTING GUIDE

In AUTO CYCLE, the pressing plate raises, but does not return to the down position.

Possible Cause

- Possible defective pressure switch, try another pressure position for verification.

The buzzer does not sound during the down travel of the pressing plate.

Possible Cause

- The buzzer is defective.

The motor "Hums" but will not start:

Possible Causes

- The motor is a dual voltage motor and may be wired for high voltage but an attempt is being made to run it on low voltage.
- The electric supply to the motor is single phase instead of three phase.
- One of the leads of the 3 phase system has opened.

The motor runs but stalls at either end of the cylinder's travel:

Possible Causes

- The setting of the hydraulic relief valve is too high.

The motor runs slowly but stalls easily before completion of its stroke:

Possible Causes

- The motor is wired for high voltage but is connected to a low voltage supply.

The motor stalled and can not be restarted:

Possible Causes

- The overload relay has tripped. Allow the relay about five minutes to cool and attempt to restart.
- An incorrect overload relay was installed or setting of the overload relay is incorrect.

OLIVER PRODUCTS COMPANY
MODEL 619 DOUGH PRESS

RECOMMENDED SPARE PARTS LIST

Part Number	Description	No. Req'd.
6303-6725	Motor (1-60-230)	1
6303-6613	Motor (3-60-230)	1
0619-0002	Switch-Limit	1
5757-8081	Switch-Limit Micro	1
0619-0001	Sensor-Proximity	1
5918-6636	Shockmount	4
5725-9610	Fuse FRN 1 1/4	1
5725-9618	Fuse FRN 3.2 (3PH Only)	2
5725-9630	Fuse FRN 15	3
5749-5624	Relay	3
5708-6852	Operator-PB black	3
5708-6891 *	Operator-push/pull 3pos red	1
5708-6708	Indicator- light 120v amber	1
5708-6575	Switch-Knob 3 pos	1
5749-8274	Contactor	1
5750-1254	Relay-Overload	1
5757-5190	Switch-Disconnect	1
0620-0090	Manifold	1
5114-9557	Head-Filter	1
5114-9558	Filter-Spin	1
5137-7004	Pump	1
5604-6958	Coupling	1
0620-0036-001	Shaft-Handle	1
0620-0037-1	Cam-Latch	1
4605-1000-0026	Spring -LH	1
4605-1000-0027	Spring-RH	1
7024-6101	Spring-Extension	1

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MODEL 619 DOUGH PRESS

ITEM NO.	PART DESCRIPTION	PART NO
001	BRACE-LOWER (DOUGH PRESS)	0620-0006-001
002	PLATE-CYLINDER SUPPORT	0620-0007-001
003	BASE	0620-0008-001
004	PANEL-SEPERATION	0620-0032
005	PANEL-SEPERATION (ELECT SIDE)	0620-0032-004
006	CASTER-RIDGID 3" WHEEL	5902-2378
007	CASTER-SWIVEL W/BRAKE 3"	5902-2377
101	COVER-TOP	0620-0001-001
102	COVER-ELECTRICS SIDE	0620-0029-101
103	COVER SIDE	0620-0029-002
104	COVER-FRONT	0620-0030-101
105	COVER-REAR	0620-0031-001
106	COVER-ASS'Y ELECTRIC BOX	0620-0080-101
107	THUMB SCREW	5843-0536
108	GUARD-W/PLC SWITCH	0620-0106-002
109	HANDLE-PULL	5908-5101
110	PLATE-HANDLE BACKING	0619-0028
201	TANK-AUTO HYDRAULICS	0620-0069-001
202	MANIFOLD	0620-0090
203	CLAMP-HEAVY DUTY HOSE	5106-8087
204	CYLINDER-CUSTOM	5108-7665
205	HEAD-FILTER	5114-9557
206	FILTER-SPIN	5114-9558
207	FITTING HOSE	5115-2079
208	GUAGE	5118-0506
209	HOSE-HYDRAULIC	0619-0016
210	PUMP	5137-7004
211	FLANGE-PUMP MOUNTING	5137-7375
212	VALVE-4WAY DOUBLE SOLENOID	5148-7111
213	SUBPLATE	5148-7553
214	BREATHER-TANK	5149-0201
215	COUPLING	5604-6958
216	SWITCH-PRESSURE	5757-8516
217	SWITCH-PRESSURE 900-3200	5757-8517
218	FITTING-ELBOW 90DEG ADJ ADAPT	5115-2087
219	ADAPTER-90DEG, 3/8FLARE X 9/16	5115-2088
220	FITTING-ADAPTER 9/16-18 X 3/8	5115-2092
221	FITTING-ADAPTER 9/16-18 X 3/4	5115-2093
222	HOSE-ASSY MANIFOLD TO CYLINDER	5121-8166
223	HOSE-ASSY FILTER TO VALVE	5121-8183
224	HOSE-ASSY PUMP TO VALVE	5121-8184
225	HOSE-ASSY CYLINDER TO VALVE	5121-8186
226	HOSE-ASSY VALVE TO MANIFOLD	5121-8187
233	PLATE-CYLINDER ALIGNMENT	0620-0120
235	NIPPLE-BLACK PIPE	6203-0407
236	COUPLING-BLACK PIPE	5115-0332

Revised 5-01-01

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PARTS LIST

ITEM NO.	PART DESCRIPTION	PART NO.
237	SPACER-PUMP/FLANGE	0619-0044
301	HOOK-LOCKING	0620-0017-3
302	PIN-HINGE	0620-0033
303	CLAMP-SPRING	0620-0034
304	BRACKET-SPRING	0620-0035
305	SHAFT-HANDLE	0620-0036-001
306	CAM-LATCH	0620-0037-1
307	ROD-HANDLE	0619-0018
308	SPRING-LH	7030-0024
309	SPRING-RH	7030-0023
310	SPRING-EXTENSION	7024-6101
311	LID-DOUGH PRESS	0620-0018-002
312	CAM-SWITCH	0620-0078
313	HUB-HANDLE	0619-0019
314	KNOB-HANDLE	5911-7110
401	BRACE-UPPER FRONT ADJUSTABLE	0620-0002-003
402	PLATE-HOPPER FRONT	0620-0059
403	PLATE-HOPPER REAR	0620-0060-001
404	PLATE-HOPPER SIDE	0620-0061
405	BRACE-UPPER ADJUSTABLE	0620-0063-002
406	CATCH	0620-0067-1
407	PLATE-BACKING	0620-0076
408	PLATE-PRESSING	0620-0077
409	SCREW-SLOTTED TRUSS HEAD	5843-5383
410	HEX-ADJUSTABLE	0619-0026-001
422	KIT-LATCH SHIM	0619-0029K
501	CORD-MOTOR 1PH, 230V	0619-0004
501	CORD-MOTOR 3PH, 208/230V	0619-0010
502	ENCLOSURE MTG. BAR	0620-0015
505	PLATE-LIMIT SWITCH ACT.	0620-0083-001
506	PLATE-LIMIT SWITCH MT.	0620-0088-001
507	NUTBAR-LIMIT SWITCH	0620-0103
508	BAR-NUT	0711-0030-001
509	SWITCH-LIMIT	0619-0002
510	SWITCH-LIMIT MICRO	5757-8081
511	COVER-LIMIT SWITCH MICRO	5757-8414
512	SENSOR-PROXIMITY	0619-0001
513	BOX-OUTLET	5764-8154
514	BUSHING-STRAINRELIEF	5765-1082
516	SHOCKMOUNT	5918-6636
517	MOTOR (1-60-230V)	6303-6725
517	MOTOR (3-60-230V)	6303-6613
518	COVER-HANDY BOX	5765-8500

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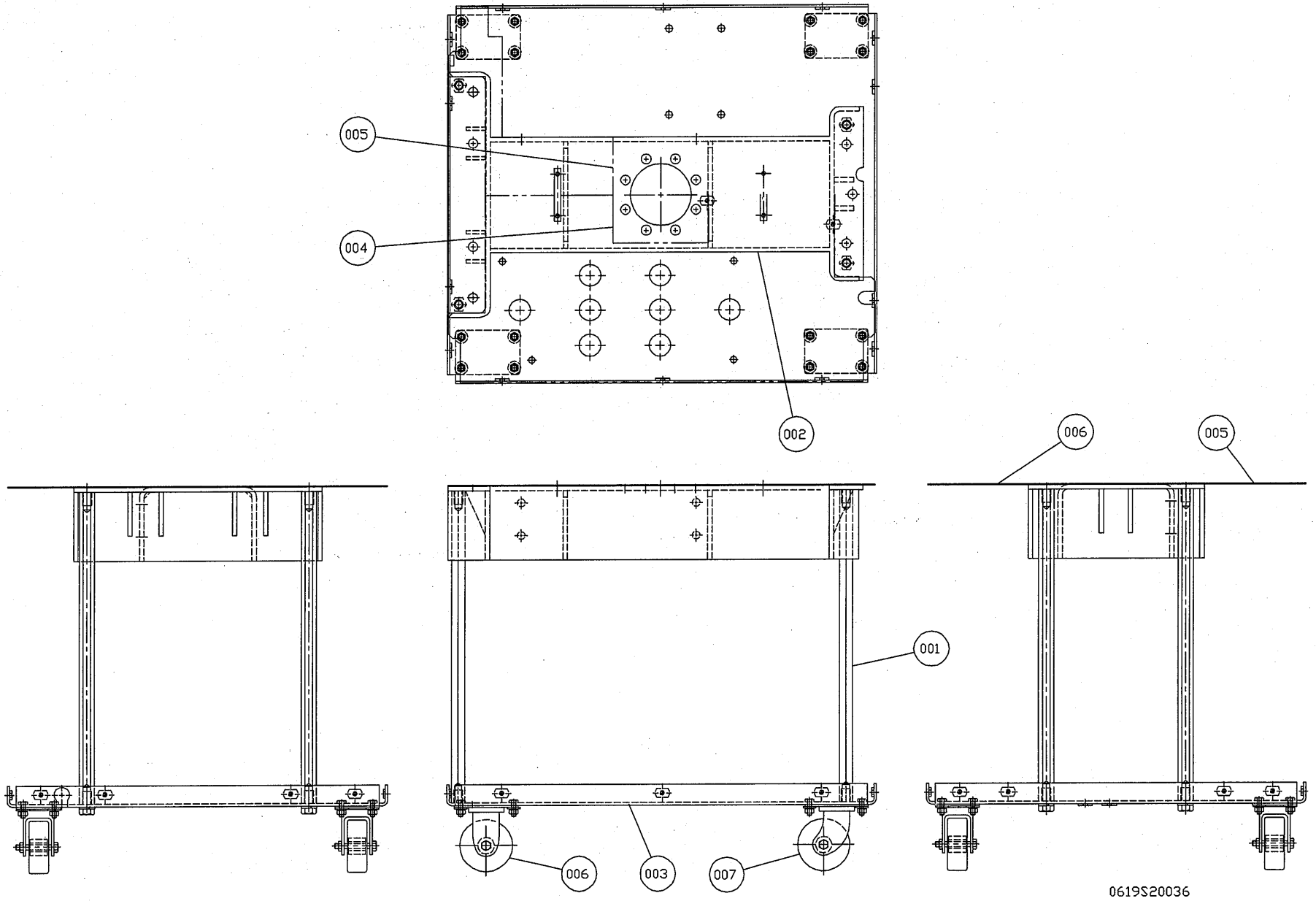

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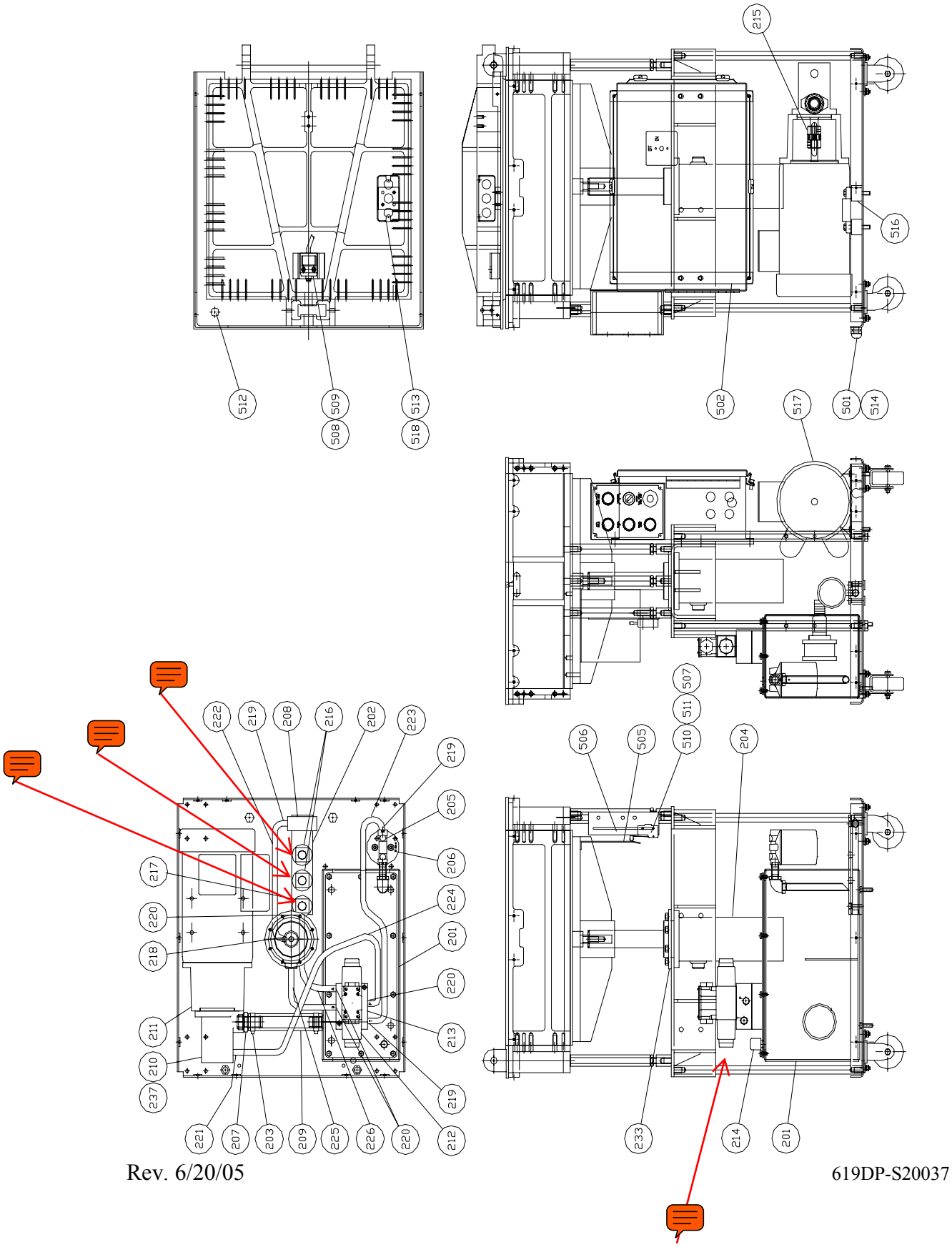
MAIN FRAME-DOUGH PRESS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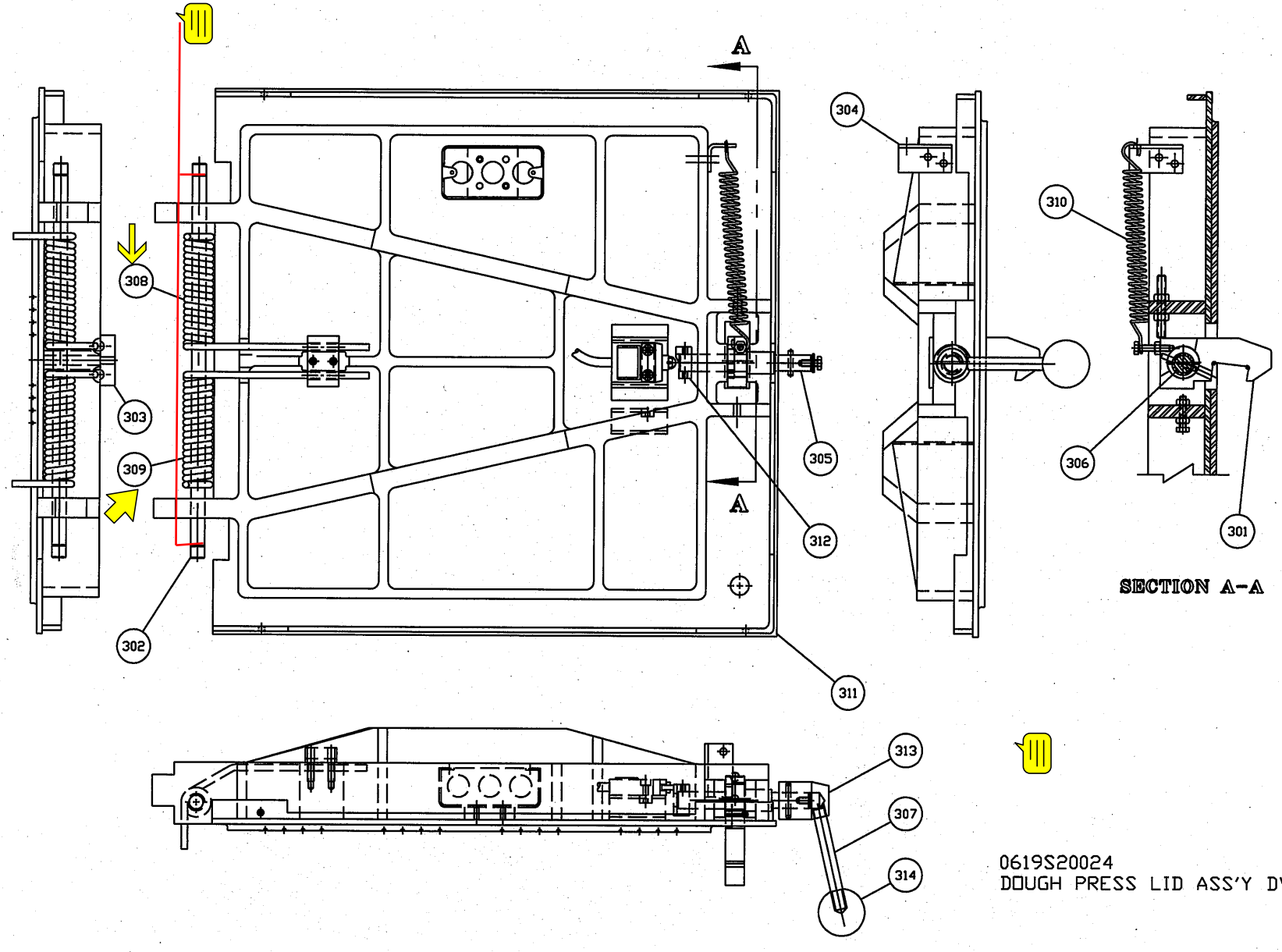

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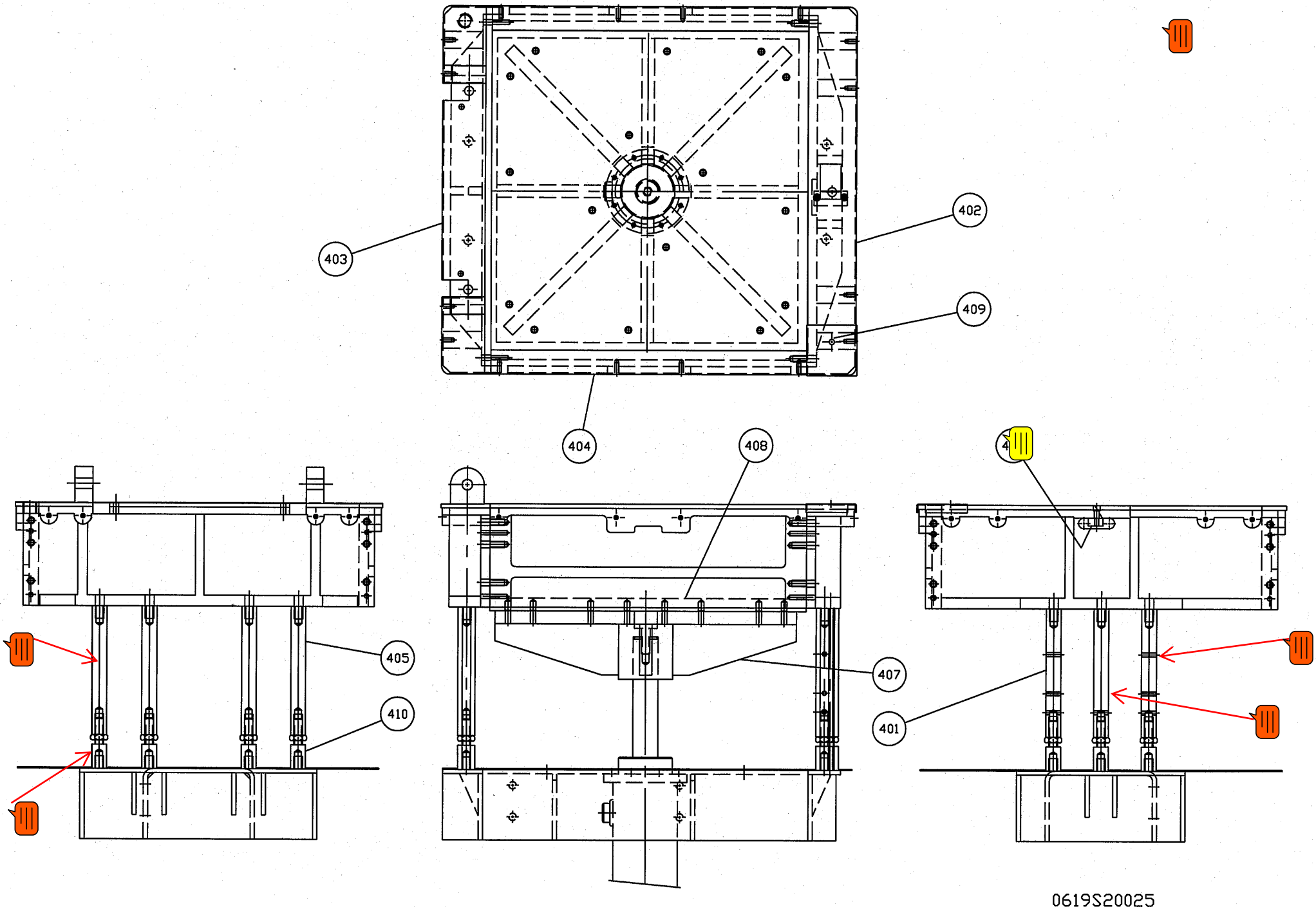
DOUGH PRESS LID ASS'Y DWG.



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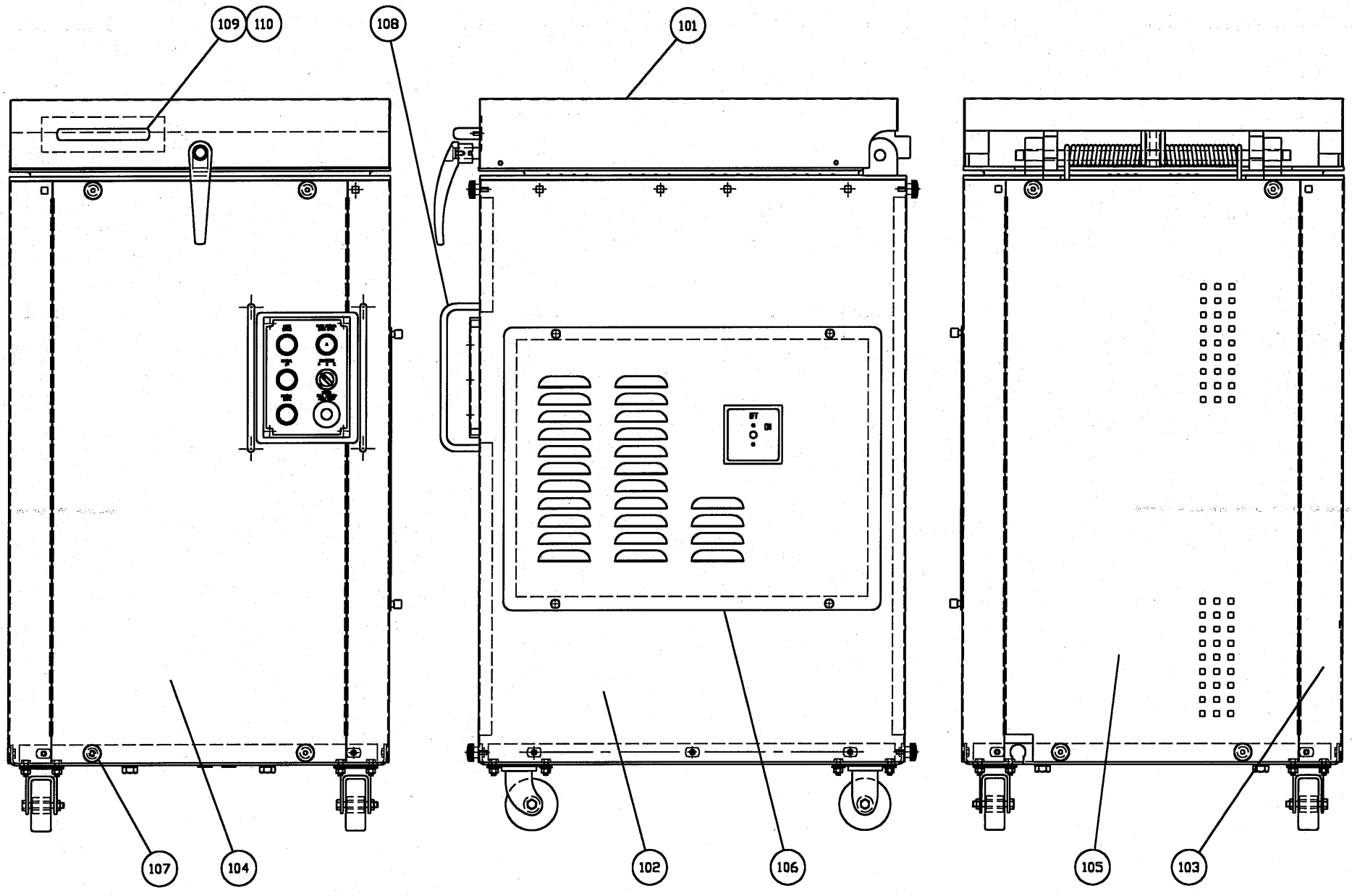
PUSHER ASS'Y-DOUGH PRESS



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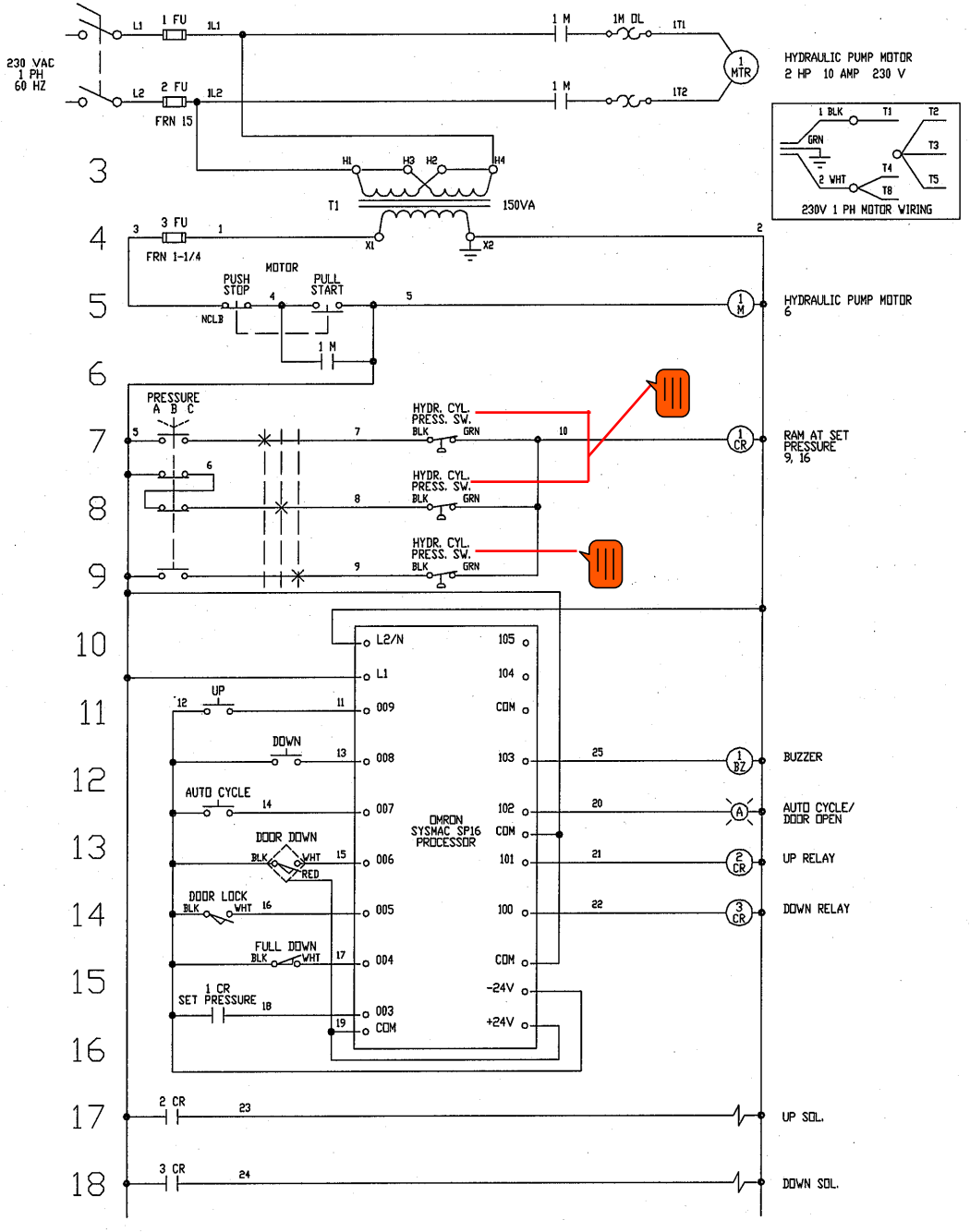
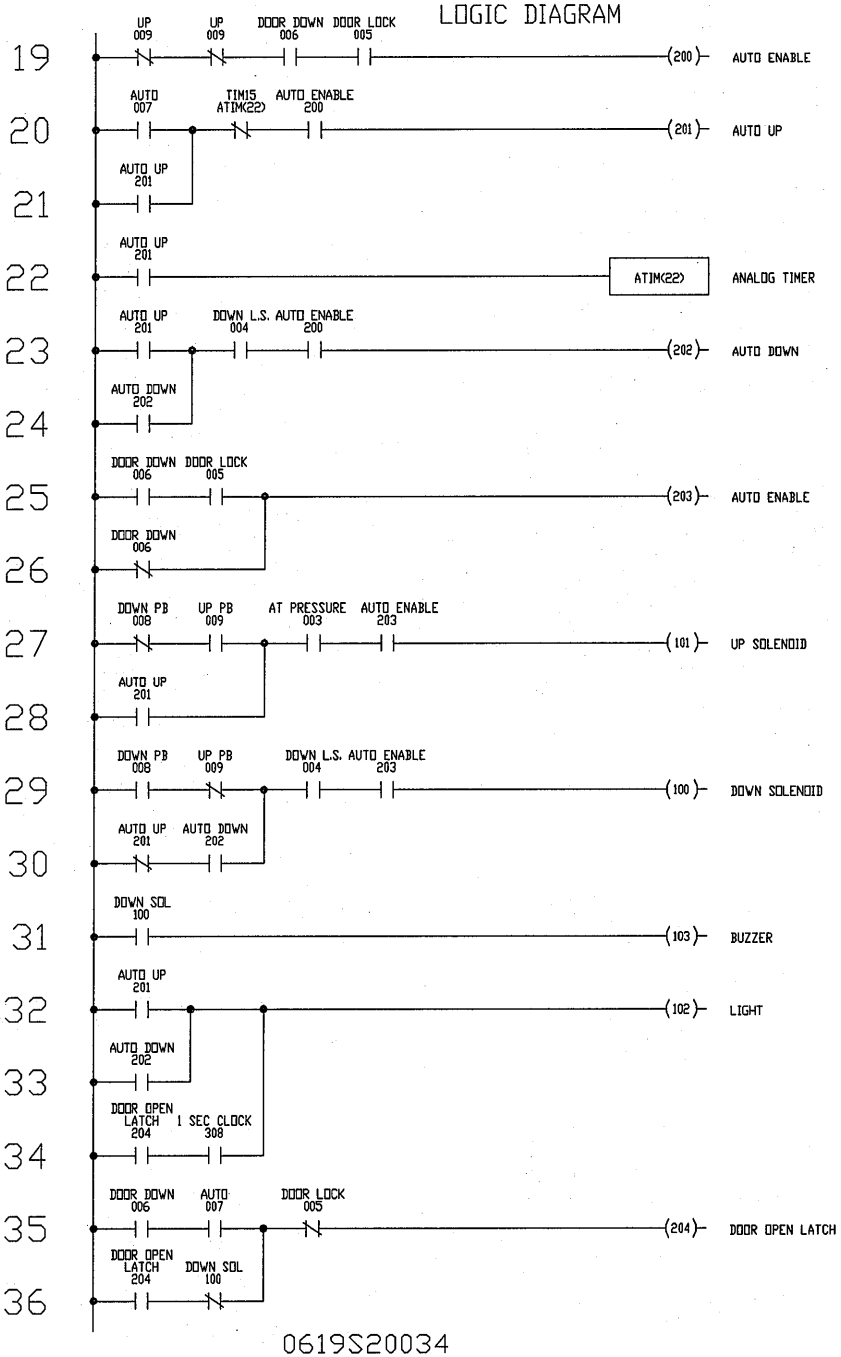
COVERS-AUTO HYD. (DOUGH PRESS)





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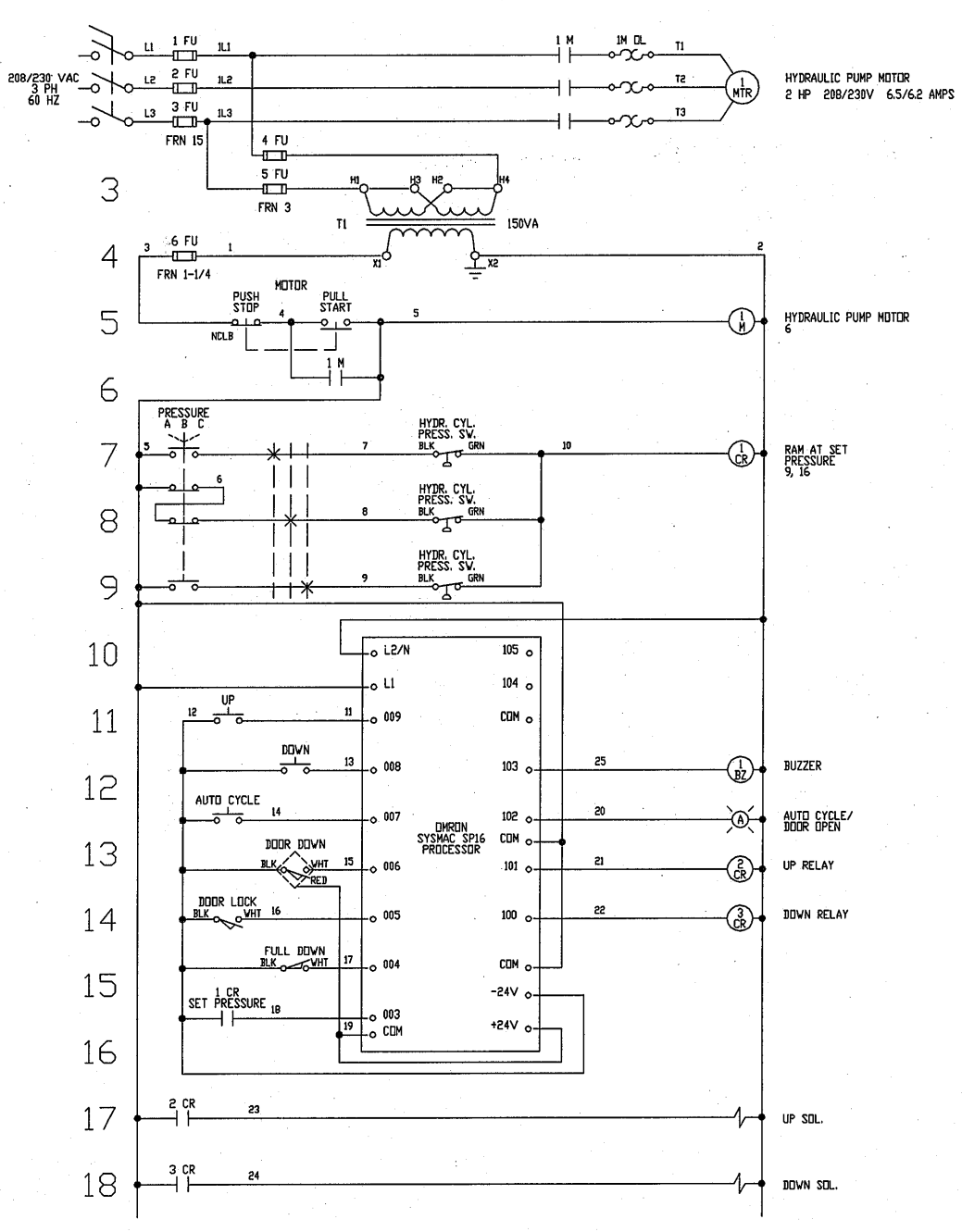
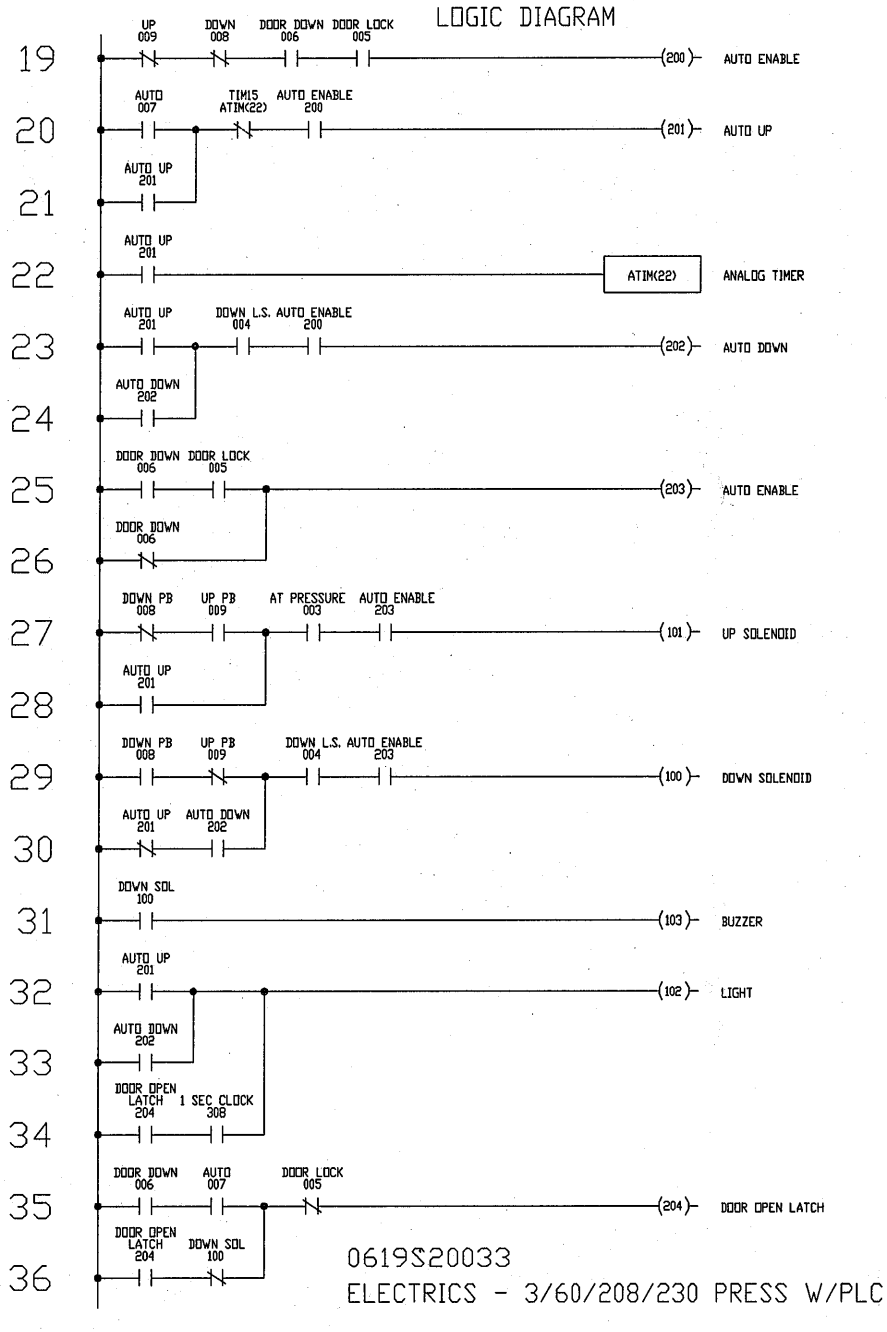
ELECTRICS - 1/60/230 PRESS W/PLC


208/230 VAC
3 PH
60 HZ
L1
L2
L3
1 FU
2 FU
3 FU
FRN 15
1L1
1L2
1L3
1 M
1M OL
T1
T2
T3
1 MTR
HYDRAULIC PUMP MOTOR
2 HP 208/230V 6.5/6.2 AMPS
4 FU
5 FU
FRN 3
H1
H3
H2
H4
T1
150VA
6 FU
FRN 1-1/4
X1
X2
MOTOR
PUSH STOP
PULL START
NCLB
1 M
HYDRAULIC PUMP MOTOR
6
PRESSURE
A B C
HYDR. CYL. PRESS. SW.
BLK
GRN
1 CR
RAM AT SET PRESSURE
9, 16
L2/N
L1
009
008
007
006
005
004
003
COM
OMRON SYSMAC SP16 PROCESSOR
105
104
103
102
101
100
-24V
+24V
UP
DOWN
AUTO CYCLE
DOOR DOWN
DOOR LOCK
FULL DOWN
1 CR SET PRESSURE
BUZZER
AUTO CYCLE/ DOOR OPEN
2 CR
UP RELAY
3 CR
DOWN RELAY
2 CR
UP SOL.
3 CR
DOWN SOL.


LOGIC DIAGRAM
UP 009
DOWN 008
DOOR DOWN 006
DOOR LOCK 005
AUTO ENABLE
AUTO 007
TIM15 ATIM(22)
200
AUTO UP
AUTO UP 201
ATIM(22)
ANALOG TIMER
DOWN L.S. 004
AUTO DOWN
AUTO DOWN 202
DOOR DOWN
DOOR LOCK
DOWN PB 008
UP PB 009
AT PRESSURE 003
UP SOLENOID
DOWN L.S.
DOWN SOLENOID
DOWN SOL 100
BUZZER
LIGHT
DOOR OPEN LATCH 204
1 SEC CLOCK 308
DOOR OPEN LATCH
0619S20033
ELECTRICS - 3/60/208/230 PRESS W/PLC

OLIVER®
PRODUCTS COMPANY
oliverproducts.com

445 Sixth St., N.W., Grand Rapids, Michigan 49504-5298
(616) 456-7711 • 800/253-3893 • Fax: (616) 456-5820

WARRANTY

PARTS
Oliver Products Company (Oliver) warrants that if any part of the equipment (other than a part not manufactured by Oliver) proves to be defective (as defined below) within one year after shipment, and if Buyer returns the defective part to Oliver within one year, Freight Prepaid to Oliver's plant in Grand Rapids, MI, then Oliver, shall, at Oliver's option, either repair or replace the defective part, at Oliver's expense.

LABOR
Oliver further warrants that equipment properly installed in accordance with our special instructions, which proves to be defective in material or workmanship under normal use within one (1) year from installation or one (1) year and three (3) months from actual shipment date, whichever date comes first, will be repaired by Oliver or an Oliver Authorized Service Dealer, in accordance with Oliver's published Service Schedule.

For purposes of this warranty, a defective part or defective equipment is a part or equipment which is found by Oliver to have been defective in materials workmanship, if the defect materially impairs the value of the equipment to Buyer. Oliver has no obligation as to parts or components not manufactured by Oliver, but Oliver assigns to Buyer any warranties made to Oliver by the manufacturer thereof.

This warranty **does not** apply to:
1. Damage caused by shipping or accident.
2. Damage resulting from improper installation or alteration.
3. Equipment misused, abused, altered, not maintained on a regular basis, operated carelessly, or used in abnormal conditions.
4. Equipment used in conjunction with products of other manufacturers unless such use is approved by Oliver Products in writing.
5. Periodic maintenance of equipment, including but not limited to lubrication, replacement of wear items, and other adjustments required due to installation, set up, or normal wear.
6. Losses or damage resulting from malfunction.

The foregoing warranty is in lieu of all other warranties expressed or implied AND OLIVER MAKES NO WARRANTY OF MERCHANTABILITY OR FITNESS FOR PURPOSE REGARDING THE EQUIPMENT COVERED BY THIS WARRANTY. Oliver neither assumes nor authorizes any person to assume for it any other obligations or liability in connection with said equipment. OLIVER SHALL NOT BE LIABLE FOR LOSS OF TIME, INCONVENIENCE, COMMERCIAL LOSS, INCIDENTAL OR CONSEQUENTIAL DAMAGES.

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WARRANTY PROCEDURE

1. If a problem should occur, either the dealer or the end user must contact the Customer Service Department and explain the problem.

2. The Customer Service Manager will determine if the warranty will apply to this particular problem.

3. If the Customer Service Manager approves, a Work Authorization Number will be generated, and the appropriate service agency will perform the service.

4. The service dealer will then complete an invoice and send it to the Customer Service Department at Oliver Products Company.

5. The Customer Service Manager of Oliver Products Company will review the invoice and returned parts, if applicable, and approve for payment.

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RETURNED PARTS POLICY

This policy applies to all parts returned to the factory whether for warranted credit, replacement, repair or re-stocking.

Oliver Products Company requires that the customer obtain a Return Material Authorization (RMA) number before returning any part. This number should appear on the shipping label and inside the shipping carton as well. All parts are to be returned prepaid. Following this procedure will insure prompt handling of all returned parts.

To obtain an RMA number contact the Repair Parts Deptartment toll free at (800) 253-3893.

Parts returned for re-stocking are subject to a **RE-STOCKING CHARGE**.

Thank you for your cooperation,

Repair Parts Manager
Oliver Products Company