

Two adjustments are provided to obtain the proper parison desired. The mandrel adjusting nut is used to vary the wall thickness and therefore the container weight. The die may be adjusted eccentrically to produce a uniform wall around the parison.

There is no means whereby the diameter of the parison can be changed significantly, except when using certain high swell resins. These materials expand considerably upon exiting from the die at high pressure. In this case, the hydraulic shot pressure can sometimes be manipulated to increase or decrease the amount of swell and therefore the resulting parison diameter.

Each die is surrounded by an electric heater band which is controlled by individual variacs mounted on the control cabinet. These variacs are manually set variable transformers which supply power to the heater band continuously.

The stripper

The stripper plate, which is actuated by an air cylinder, ejects the formed container downward from the mold area after the molds have opened far enough for clearance.

The timing of the stripper action is important. The molds must be opened far enough to allow the stripper and the container to move downward without interference. A delay here only serves to increase cycle time, so it must occur as soon as possible.

The velocity of the stripper movement should be kept at a reasonable rate. Excessive speed will only serve to shorten the life of the unit. Too slow a speed will not effectively strip the container away from the die and mandrel with a clean break.

Care should be taken in adjusting the lower limit switch cam to insure that the stripper plate is all the way up when the switch is tripped. If the cam trips too soon, the molds may hit the stripper plate as they are closing.

For description of the air circuitry and control of the stripper turn to Page 23, 24.

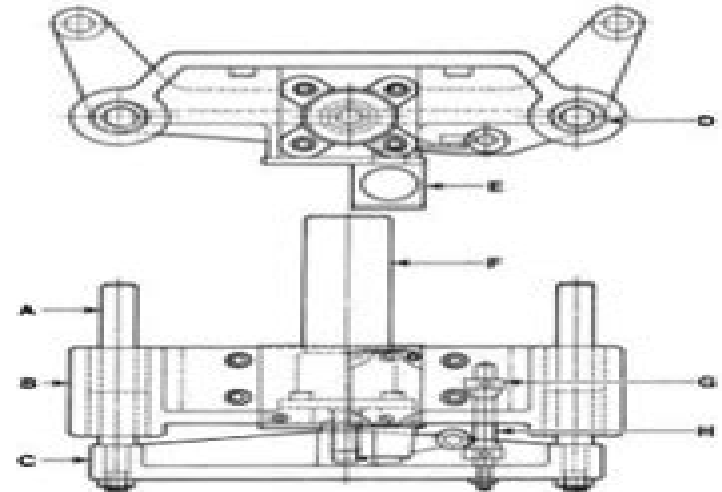
The clamp

The purpose of the clamp mechanism is to locate and hold the molds together securely while the container is being blown. The clamp consists primarily of two platens upon which the molds are mounted, guide bars, and platen rails which locate and support the platens and a toggle mechanism which moves and locks the

Stripper

ITEM PART NAME

- A Guide Bar
- B Mounting Bracket
- C Stripper Carrier
- D Ball Bushing
- E Limit Switch 802TNP
- Limit Switch Arm W1B
- F Air Cylinder
- G Limit Switch Cam
- H Cam Rod



platens. It will be noted that there are actually three platens, but the third, or rear platen, serves no function as far as the molds are concerned. It is a necessary part of the clamping assembly in that it serves to connect the front platen through the guide bars to the toggle mechanism.

Page 17 shows the clamp in the closed or locked position. The toggle linkage has been rotated into a straight line configuration. When the guide bars are adjusted properly, they will have been stretched approximately .010 inches in order for the linkage to reach this straight line position. This puts a pre-load on the molds which is greater than the force developed by the air pressure within the molds. This pre-load plus the straight line linkage, eliminates any possibility of the molds being blown open.

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