



Model R-4 Reciprocating Screw Blow Molding Machine

R-4



Lower volume production of a wide range of parts up to 1-gallon size. Additional applications for schools, laboratories, R&D development.

- ▶ Processing output of 70 lbs./hour HDPE, up to 200 grams maximum shot size.
- ▶ Available with spin trim automation for non-handled bottles. Pull up or ram down finish available for handled bottles.
- ▶ Options: Bottom blow, needle blow, special functions, proportional control hydraulics, parison programming.



▶ Single Serve Bottles



▶ Non-Handled Bottles



▶ Wide Mouth Jars



▶ Dairy Bottles



▶ Industrial and Household

R-4 Specifications

► Screw Mechanism

- 1.5" (38 mm) dia., 24/1 (L/D) reciprocating screw
- Bi-metallic barrel
- Hydraulic motor screw drive, variable (0-175 RPM)
- 70 lbs/hr (32 kg) HDPE output
- 200 grams maximum shot size, HDPE
- 75 lb. (34 kg) hopper capacity
- 3.25" x 8" stroke injection cylinder

► Clamp Mechanism

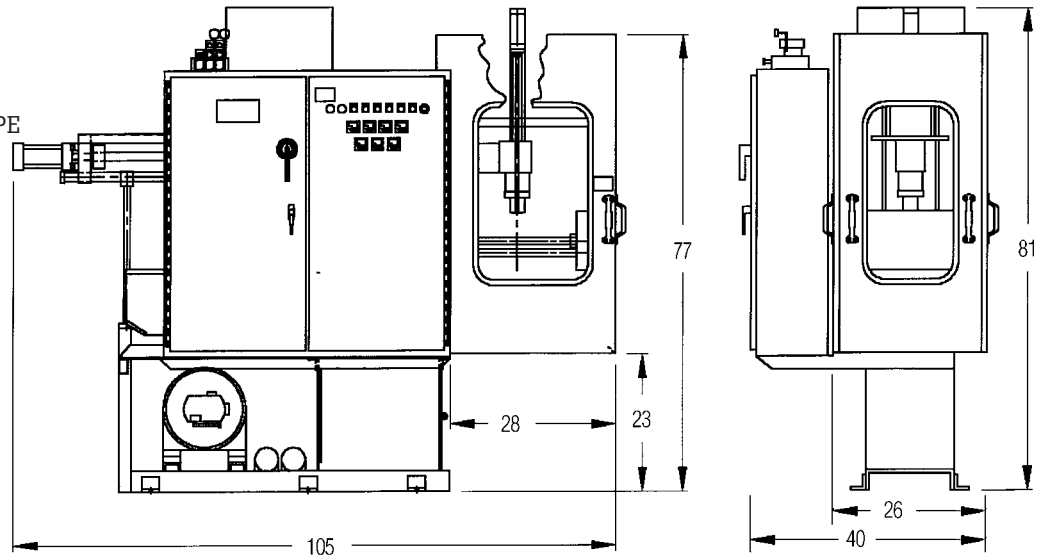
- 5 tons force
- 2.5" bore x 10" stroke hydraulic cylinder
- 6" minimum platen opening, 20" maximum platen opening
- 10" x 10" (L x W) usable platen area
- T-square arrangement for rapid mold installation

► Hydraulic

- 19 GPM variable volume, pressure compensated piston pump
- Manifold mounted directional valves and flow controls
- 35-gallon reservoir capacity, with level/temp safety switch
- Spin-on filter element with indicator gage

► Electrical

- 25 HP, 1800 RPM, 220/440 volt, 3 phase, 60 Hz motor
- 220 volt heater bands, 9.3 Kw heater load, single head
- Two-zone extruder temperature controls, fan cooling
- Individual die head temperature controls, variac nozzle controls
- 88 full load amps @ 220 volts, appx. 60 running amps
- Solid state programmable controller
- Solid state touchpad data access unit



Notice: The company reserves the right to incorporate any changes in design without obligation to make these changes on units previously sold.

► General

- 3,100 lbs. net weight
- 3-5 tons chilled water required, molds and machine
- 3 CFM @ 100 PSI compressed air required

► Other Standard Equipment

- Main line coalescent air filter
- Manifold mounted air valves
- Quick exhaust valve on blow line
- Mold safety bottle jam protection
- Screw safety timer
- RPM indicator for screw speed
- 16-station water manifold
- Hopper magnet
- Machine mounting pads
- Fully guarded with electrical interlock for operator safety

► Optional Equipment

- 1, 2 or 3 parison die heads
- Parison programming
- Bottom blow attachment
- Ram-down or Pull-up top finish unit
- Dual pressure blow
- Special extruder feed screws for engineering resins
- Automation for spintrimming and handle deflashing
- Proportional valve hydraulics

| R-4 Production Capability | | | |
|--|--------------|----------------|------------------|
| | | | |
| X | - - | 5" (127 mm) | 3.375" (85.7 mm) |
| D | 6" (152 mm) | 4.25" (108 mm) | 3" (76 mm) |
| H | 11" (280 mm) | 11" (280 mm) | 11" (280 mm) |
| Standard head centers listed. Systems may be modified to accommodate your specific requirements. | | | |



Rocheleau Tool & Die Co., Inc.