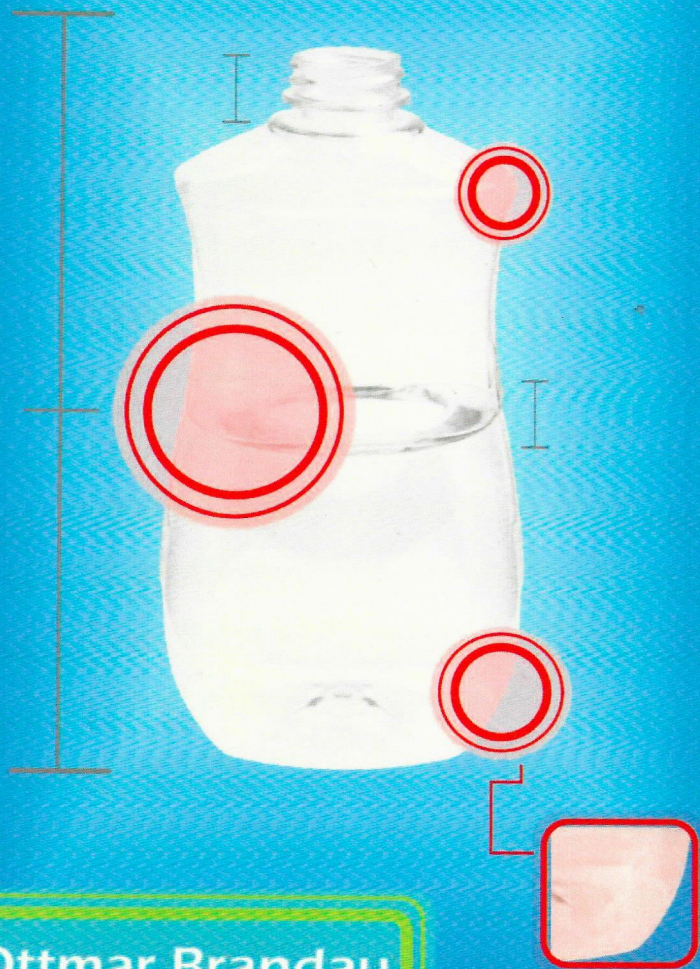


THE RAPID GUIDE TO PERFECT PET BOTTLES

A Practical Troubleshooting Handbook

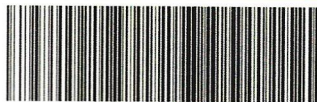


Ottmar Brandau

THE RAPID GUIDE to PERFECT PET BOTTLES

About the Author

Ottmar Brandau has worked in the PET industry since 1988 in various capacities. He is president of Apex Container Tech Inc, a Canadian company involved in all aspects of blown container manufacturing. He has comprehensive knowledge of the stretch blow molding process, materials, and machinery and has trained hundreds of operators and engineers all over the world. His web site www.blowmolding.org offers support for the blow molding community.



The Rapid Guide to Perfect PET Bottles

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The Rapid Guide to Perfect PET Bottles

the piston. Make sure pressure compensation valve works properly.

C: Check blow mold leader pins and bushings

D: Vents should be not more than 0.25 mm (0.010") deep; typically they are 0.1 mm (0.004")

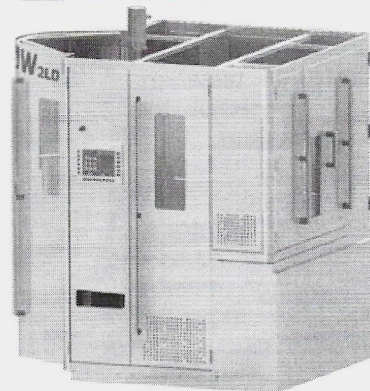
E: Increase blow time and/or check cooling water flow

Further explanation:

When molds are new, the vents have been properly cut, and the machine clamping mechanism (whether hydraulic or mechanical, with or without pressure compensation) works well, mold split lines should not be noticeable and barely visible. If vents are too deep (greater than 0.25 mm or 0.010") and stretch ratios are small material may flow into the vents. On the other side, as time goes on and molds wear vents can get crushed. This leads to venting problems that may create hot bottle parts as the air inside the mold may prevent or delay the cooling of the material in the mold.

When leader pins and bushings wear molds are no longer aligned. This can felt when running a finger over the parting line. If on one side the parting line is proud in one way and the other way on the other side the mold halves are offset.

1BLOW



BENEFITS / ADVANTAGES

- Accepts other Brands of Blow Mold Formats
- 20% LOWER Energy
- 20% LESS Floor Space
- Rapid Change Over

TECHNOLOGY OPTIONS

- Air Recovery
- Preferential Heating
- Neck Orientation
- Heat Set
- Sure Grip

MODEL	BOTTLE	NECK	OUTPUT
5XL	12.0 L	55mm	1,800 bph
3XXL	30.0 L	60mm	600 bph
2XL	4.0 L	38mm	3,800 bph
4L	4.0 L	38mm	7,500 bph



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