

Model R-4

ROCHELEAU MODEL R-4

Reciprocating Screw
Blow Molding Machine

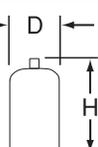
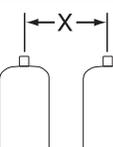
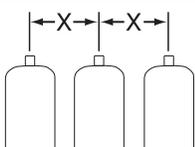


- ♦ Quick mold and tooling set-up
- ♦ Quick color changes
- ♦ Quick height adjustments with T-square arrangement
- ♦ Quick payback due to low capital cost

The Rocheleau Model R-4 Blow Molder is best characterized by its versatility. The R-4 utilizes a 1.500" diameter (38 mm), 24/1 ratio (L/D) feed screw. The reciprocating screw design of blow molders have fewer moving parts than continuous extrusion machines, thus simplifying setups and reducing maintenance cost. The rapid parison drop rate is very advantageous for thin wall containers, typical in dairy/juice bottle applications. Wide mouth containers can be made with automated secondary spintrim systems at a much lower cost than comparable continuous extrusion machines. The R-4 is equally well suited to smaller industrial/toy/medical parts.

A variety of multi-parison die heads, with options such as parison programming and ram-down or pull-up impact neck finishing, add to the capabilities of the R-4. Single cavity systems can produce articles up to lightweight 1-gallon bottles, dual cavity systems are suitable for articles up to 1-quart size, three cavity systems are quoted up to 16-ounce size.

The solid state PLC electronics provide dependable, user-friendly access to machine controls, with file storage for multiple job setups. Controls can be easily modified to allow for special functions such as needle blow, dual pressure blow controls, bottom blow, core pull mold action, etc.

R-4 PRODUCTION CAPABILITY			
			
X	—	5" (127 mm)	3.375" (85.7 mm)
D	5" (127 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.

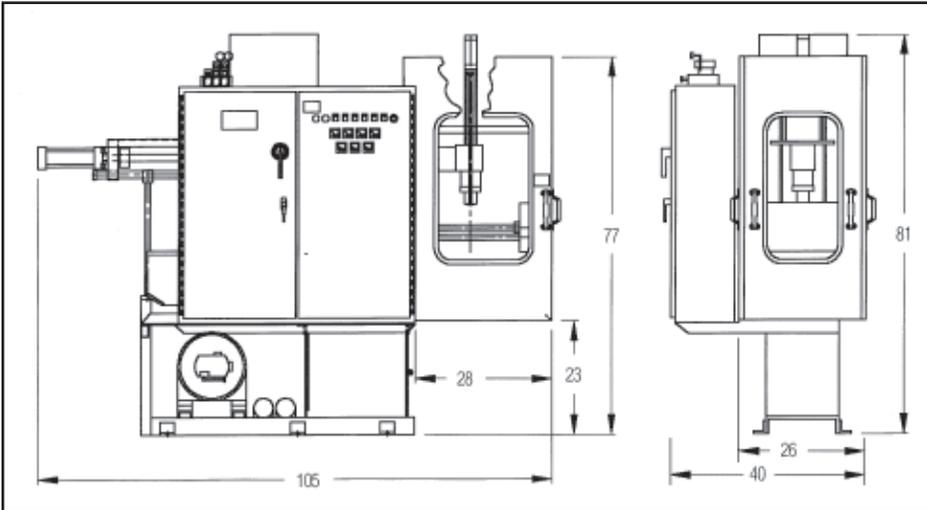


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R-4 SPECIFICATIONS



SCREW MECHANISM

- ◆ 1.500" (38 mm) diameter, 24/1 ratio (L/D) reciprocating screw
- ◆ Bi-metallic barrel
- ◆ Hydraulic motor screw drive, variable 0-175 RPM
- ◆ 70 lbs/hour (32 kg) HDPE output
- ◆ 225 gram full shot capacity, HDPE
- ◆ 75 lb. (34 kg) hopper capacity
- ◆ 3.25" x 8" stroke injection cylinder

CLAMP MECHANISM

- ◆ 2.5" bore x 10.0" stroke hydraulic cylinder, 5 tons force
- ◆ 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, 9.5 Kw heater load, single head
- ◆ 2-zone extruder temperature controls, fan cooling
- ◆ Individual die head temperature controls, variac nozzle controls
- ◆ 88 full load amps @ 220 volts, approximately 60 running amps
- ◆ Solid state programmable controller
- ◆ Solid state touchpad data access unit

GENERAL

- ◆ 3,100 pounds 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
- ◆ Bottom blow attachment
- ◆ Parison programming
- ◆ 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

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