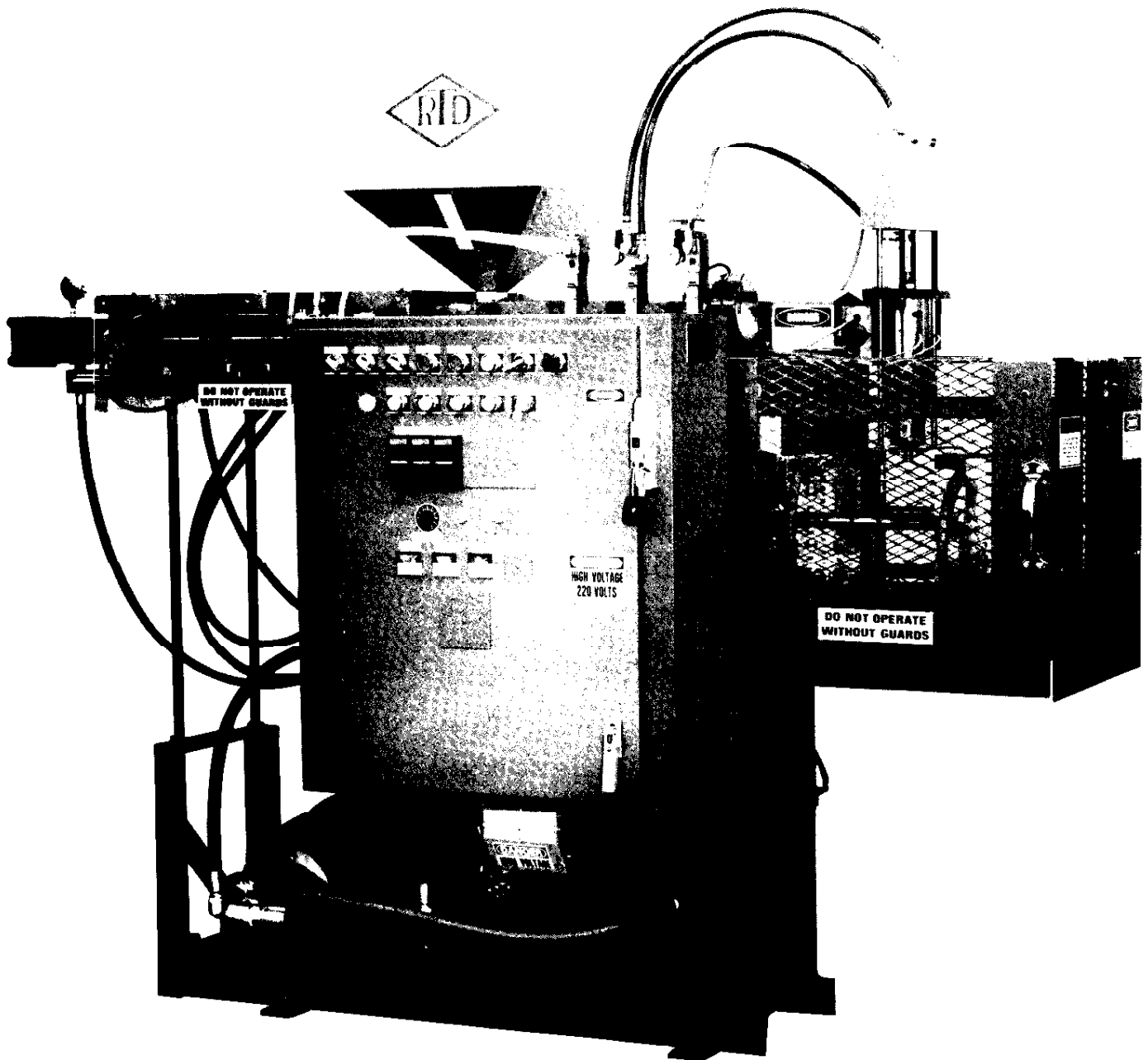


# MODEL R-4 BLOW MOLDER



The Model R-4 Rocheleau Blow Molder is best characterized by its versatility. The reciprocating screw type of extrusion blow molder uses a 1.500" diameter, 24 to 1 ratio (L/D) screw. The R-4 produces parts up to a one-half gallon size efficiently.

A variety of multi parison heads gives the machine even more versatility. The R-4 is ideal for running very small medical or industrial parts, as well as one-half gallon containers.

The Model R-4 Rocheleau Blow Molder incorporates low maintenance and easy access to controls in an economical space-saving machine.

The Model R-4 is fully guarded for operator safety. Clamp guards have electrical interlocks for added safety.

We feel that the Model R-4 Rocheleau Blow Molder will soon set a new industry standard for small extrusion blow molders.

## FEATURES

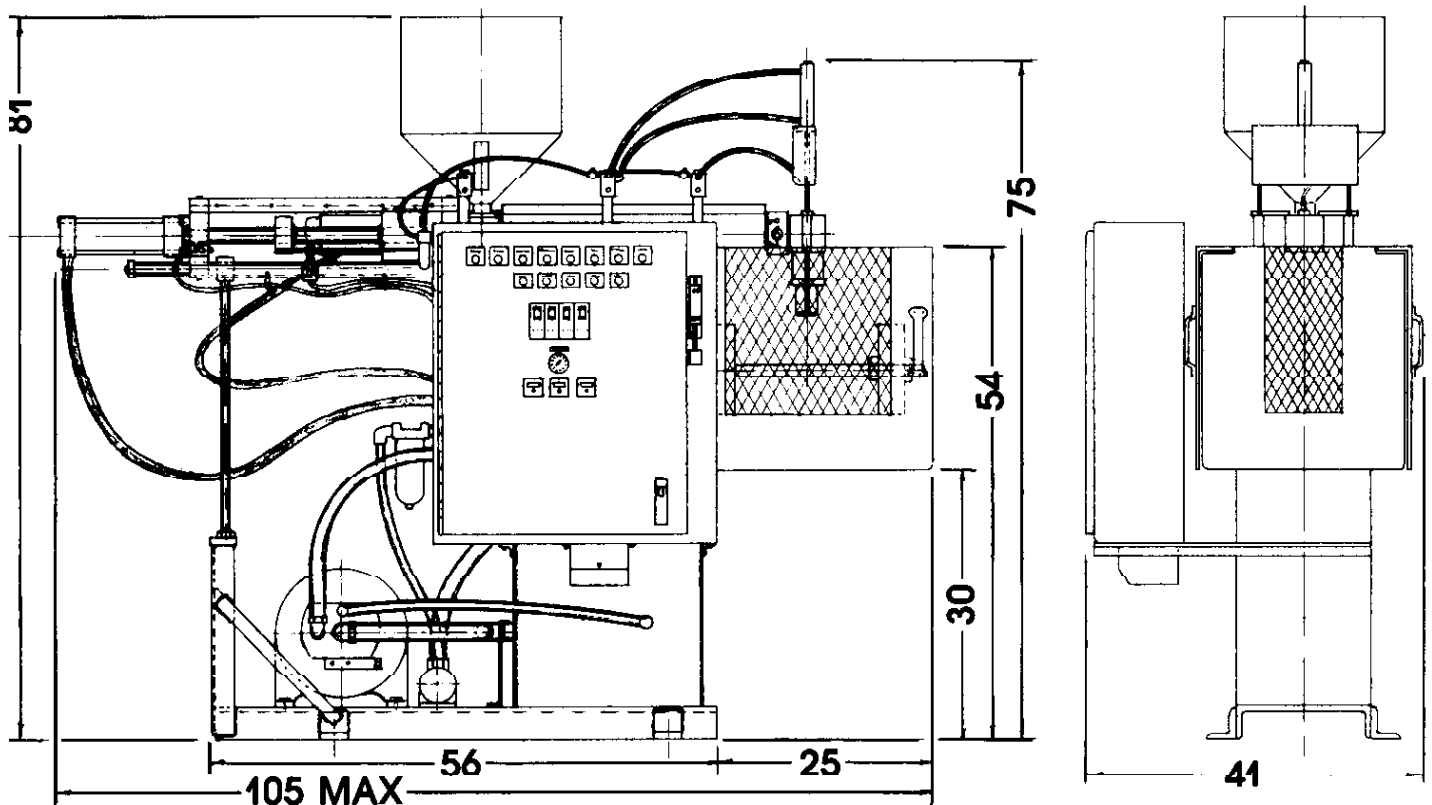
- Quick mold and tooling set-up
- Quick color changes
- Quick height adjustments with T-square arrangement
- Quick payback due to low capital cost



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## MODEL R-4 SPECIFICATIONS

### SCREW MECHANISM

- SCREW: 1.5 in. dia. 24 to 1 LD with Maddock Type Mixing Head
- BARREL: bi-metallic
- SCREW DRIVE: hydraulic motor variable to 290 RPM
- FULL SHOT: 225 grams HDPE
- PLASTICIZING CAPACITY: 100 lbs/hr. HDPE
- HOPPER CAPACITY: 75 lbs.
- EXTRUSION STROKE: 8" maximum

### CLAMPING MECHANISM

- HYDRAULIC CLAMP FORCE: 16,000 lbs.
- MAX PLATEN OPENING: 18 inches
- MIN PLATEN OPENING: 5 inches
- USABLE PLATEN AREA: 10x10

### HYDRAULIC

- PUMP: 15 GPM 2,000 PSI.
- VALVES: manifold mounted spring offset type
- CYLINDERS: 2.5 in. dia. x 7 in. stroke for clamp, 3.25 in. dia. x 8 in. stroke for injection
- OIL RESERVOIR: 30 gals.
- OIL FILTER: externally mounted
- OIL STRAINER: internally mounted

### ELECTRICAL

- MOTOR: 15 h.p., 1800 rpm, 220/440 volts, 3 ph., 60 cycle
- CONTROLS: 110 volts through transformer
- HEATERS: 240 volts
- HEAT CONTROLS: 3 solid state pyrometers and 1 solid state variac
- HEATING WATTS: 9,800
- FULL LOAD POWER CONSUMPTION: 65 amp
- FUNCTIONS: through programmable controller

### GENERAL

- MACHINE SIZE: 105 in. long 41 in. wide 81 in. high
- NET WEIGHT: 2,150 lbs.
- SHIPPING WEIGHT: 2,900 lbs.

### STANDARD EQUIPMENT

- heat exchanger for cooling hydraulics
- main line air filter and oiler
- pressure reducing valve and gauge for blowing
- quick exhaust valve on blow line
- 3 zone pyrometer heat control
- variac heat control for bushing
- programmable controller
- top knock out attachment
- one set blank mandrel pin and bushing
- plug-in timers

### OPTIONAL EQUIPMENT

- 2 or 3 parison heads
- bottom blow attachment
- low pressure preblow
- hopper magnet
- vibration mounts
- parison programming
- special screws
- 16 station water manifold (8 in 8 out)
- transformer for various voltage

NOTICE: The company reserves the right to incorporate any changes in design without obligation to make these changes on units previously sold. Prices quoted are for U.S. only, and subject to change without notice. State and local taxes extra where applicable.