

## *Automatic PET Rotary Blowing Machine XLRCL-08*



The XLRCL-08 fully automatic rotary PET bottle blowing molding machine is designed and built by our advanced technology, the machine produce the PET bottle with high pressure compressed air. The whole operation process is of self control and is free of manual operation.

The machine integrates with intelligence, automation, stability, high output, economy and it is free of pollution.

The production is widely used in food, beverages, cosmetics, pharmaceutical container production.

- **Mould:** We have adopted the latest CAD/CAE/CAM system to our mould design, such as UG, Pro-E that ensures the project efficiency. Also, we have advanced processing equipment. Your product will be through effective project management that will reduce the costs and let your products show on the market in the shortest time.
- **Preform feeding:** The preforms are unloaded into the preform hopper and are then transferred to unscrambler by a preform elevator. The unscrambler conveys preforms to a feed rail, at the end of rail the preforms are captured by in-feeding star-wheel. Then preforms are sent to the heating module.
- **Horizontal preform heating:** The preforms start moving along the heating module. During the heating process, the preforms constantly turn around themselves, so as to ensure an excellent and symmetrical heat distribution. Each oven module and each lamp can be adjusted with regards to position and power, thus assuring the maximum process setting flexibility. At the heating module outlet, a sensor detects the preform temperature and compares it with the temperature setting point; if the two values do not correspond; it increases or decreases the heating module lamps power.
- **Star wheel preform feeding**
- **Preforms stretch blow-molding:** After leaving the heating oven, preforms are transferred by mechanically synchronized gripper fixed on the transfer wheel to the cam-controlled blow wheel. In blowing stations, there are two phases of stretch-blowing process:
  - stretching and pre-blowing, which occur simultaneously through the descent of the stretching rod and the supply of low-pressure compressed air;

- final blowing with high-pressure compressed air, through which the bottles take their final shape.

### Technical Parameter:

Blowing section	Blowing station	8
Working high of the preform (from preform supporting ledge to ground)	About 1.6m	
Heating section	Heating oven	10
Heater layer	8	
Electrical	Voltage	380V
Frequency	50/60Hz	
Installation power	power	185kw/h
Average running power	100-150 kw/h (Auxiliary equipments are excluded)	
Air supply	Low pressure air	7-8 bar
	Low pressure air consumption (by high pressure transit)	5 m <sup>3</sup> /min
	High pressure air	35~40bar
	High pressure air consumption	8 m <sup>3</sup> /min
Chilling water	Pressure	5bar
Chilling water for heating section (chilling water temperature ≤20°C)	Flow	4 m <sup>3</sup> /h
	Power	9kw
	Pressure	8bar
Chilling water for 2 body mould water temperature ≤5~12°C)	flow	6 m <sup>3</sup> /h
	power	11 kw
	Pressure	8bar
Chilling water for bottom mould chilling water temperature ≤5~12°C)	flow	2 m <sup>3</sup> /h
	power	6 kw
	Pressure	8 bar
Total weight	Blowing section +heating section +electrical cabinet	16 T
Overall dimension	Blowing section(L×W×H)	4120mm×3080mm×3620mm
	Heating section(L×W×H)	4440mm×1860mm×3200mm
	Unscramble section (L×W×H)	6000mm×5100mm×4100mm
Preform	High	≤170mm
	Inner diameter	Φ14mm~Φ26mm
	Supporting ledge	Φ26mm~Φ36mm
Bottle	Diameter of round bottle	Φ50mm~Φ100mm
	Bottle diagonal size	50mm~100mm
	Max height	≤330mm
	Max volume	≤1.5L
material	PET	
Capacity	15000 BPH (600ml) (depends on preform and bottle design)	