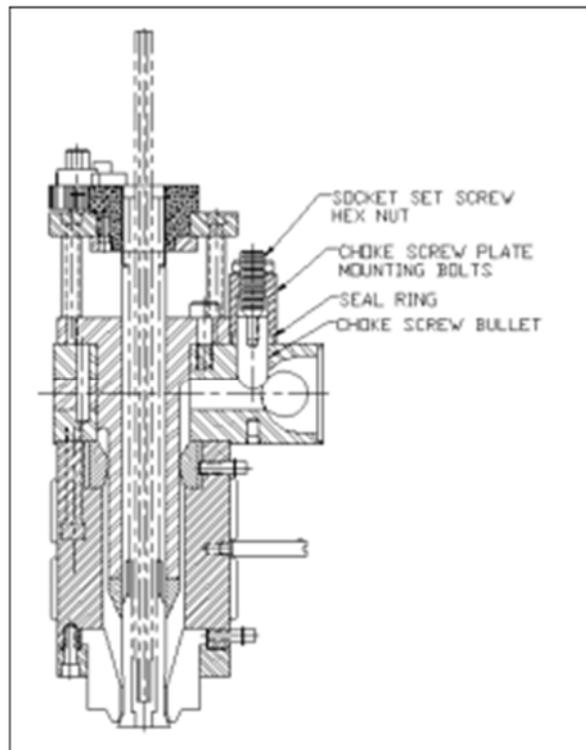


Uniloy Milacron is pleased to introduce an improved design "Sealed" Choke Screw Assembly. This design can help eliminate the problems of plastic leaking by the choke screw bullet causing variations in parison lengths and plastic leaking on top of the head.

In the past, we have discovered that plastic will creep up along side of the choke screw bullet and get between the bullet and the socket set screw forcing the bullet down and closing off the flow. Plastic will also travel up the socket set screw threads causing a leak on the top of the head. Once this occurs, these conditions get progressively worse until it becomes necessary to unbolt the choke screw assembly, clean out the plastic, and reassemble. This procedure must be done with the machine out of production so when you add loss of production to increased maintenance cost, a solution to this problem would be a winning proposition.

**Uniloy has the solution!** We have redesigned the Choke Screw Assembly using a longer choke screw bullet and a seal that prohibits the plastic leakage. This new design can be used on Uniloy -1, -2, and -4 style heads. It can also be used on most Liberty designed heads.



Parts required per head include:

- (1) Socket Set Screw
- (1) Hex Nut
- (1) Choke Screw Plate
- (2) Mounting Bolts
- (1) Seal Ring
- (1) Choke Screw Bullet

We have also designed a sealed blank plate to be used on the number one head in place of the choke screw. Head number one is the head on the far right or electrical side of the machine. The blank plate is non-adjustable, fixing the number one head wide open. This forces the machine operator to adjust the choke screws on the other heads to balance the parison lengths relative to head number one. This arrangement provides balanced parison lengths with optimum drop speed.

Parts required per head include:

- (1) Blank Plate
- (1) Seal Ring
- (2) Mounting Bolts

The following tables include the individual part numbers for both Uniloy and Liberty choke screw and blank plate components. The Uniloy 1.00" chokes and plugs are commonly used on -1 and -4 style heads. The .875" parts are used on -2 style heads. Liberty dome blow heads typically use a .884" choke screw and plug and Liberty handleware heads use the larger .999" size.

Description	Qty/Hd	Uniloy Choke Part # by Dia.		Liberty Choke Part # by Dia.	
		1.0009/1.0004	.8759/.8754	.9995/.9990	.884/.883
Socket Set Screw	1	10419171	10419171	10419172	10419170
Hex Nut	1	10419728	10419728	10419728	10419741
Choke Screw Plate	1	10409783	10412378	10861076	10421382
Mounting Bolts	2	10353923	10353438	10352424	10353497
Seal Ring	1	10409784	10413485	10900934	10421381
Choke Screw Bullet	1	10409785	10417935	10861075	10421380

Description	Qty/Hd	Uniloy Blank Part # by Dia.		Liberty Blank Part # by Dia.	
		1.0009/1.0004	.8759/.8754	.9995/.9990	.884/.883
Blank Plate	1	10409787	10900911	10900907	10900910
Seal Ring	1	10409784	10413485	10900934	10421381
Mounting Bolts	2	10353923	10353438	10352424	10353497

For more information on these parts, please contact your local Uniloy Parts Sales Representative. Trained Uniloy Service Representatives are available to assist in the installation of these packages at your facility.