

**Angular Blow Pin Adjustment** which is a retrofit that makes it possible to perfectly adjust the vertical alignment of your blow pins. This retrofit will work on any Uniloy Reciprocating Screw Blow Molding Machine with either air or hydraulic prefinish.

Benefits include:

- Faster Tooling Set-Up Times
- Reduced Wear on Shear Steels and Blow Pins
- Improved Container Finish

### **Why You Need Angular Adjustment**

One of the most important fine adjustments required for producing a good blow molded container, is centering the blow pin head in the shear steel in the molds. This adjustment is normally done by loosening the prefinish cylinder clamps and moving the cylinder, air adaptor, and blow stem together until the blow pin head is centered. This method has been used for years but its shortcoming is that it does nothing for any angular misalignment which may exist. If a blow pin cylinder does not sit in a perfectly vertical orientation, the blow stem will hang a few degrees off from plumb. This means that even if centered by moving the cylinder horizontally, the blow pin head will not be at a right angle with the shear steel as it passes through vertically. This causes a less than optimal neck finish and accelerated wear on the shear steels and blow pins.

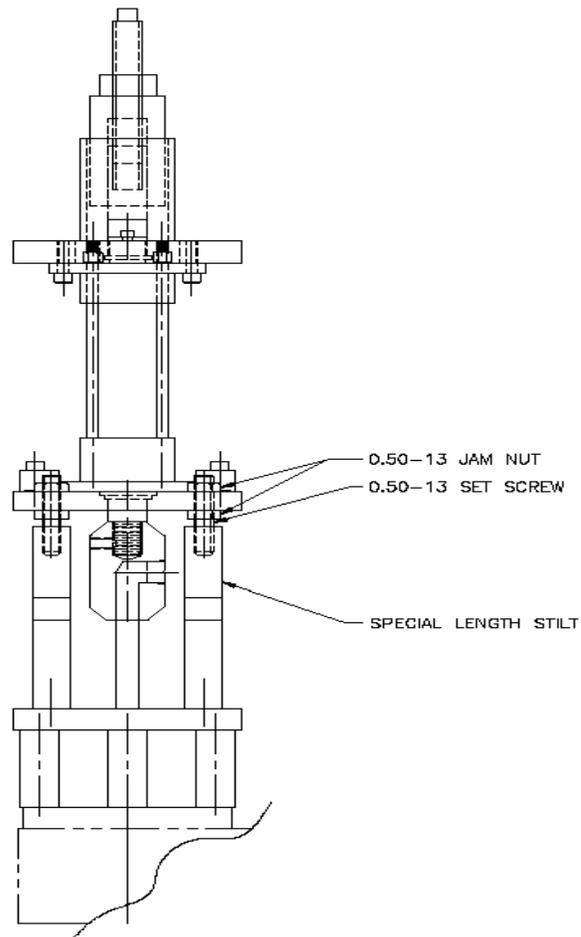
### **How the Retrofit Works**

In a typical prefinish setup, there is a prefinish cylinder which is clamped to a mounting plate. The mounting plate is supported by either 2 or 4 support stilts which extend down to either the mandrel adjust assembly (in the case of a nonprogrammed head), or the programmer cylinder top plate (in the case of a programmed head).

If the machine being retrofitted has four support stilts beneath each prefinish cylinder, the retrofit will be accomplished by installing four new support stilts, along with four set screws and eight jam nuts per head. This arrangement makes it possible to adjust the length of the support stilts as required to get the blow stem in a perfectly vertical position.

If the machine being retrofitted has two support stilts beneath the prefinish cylinder, the retrofit will be accomplished by installing a specially designed cylinder mounting plate assembly. This plate assembly has four built in adjustment screws located at the four corners. Adjusting these screws allows the operator to tilt the prefinish cylinder as required to get the blow stem in the optimal vertical position.

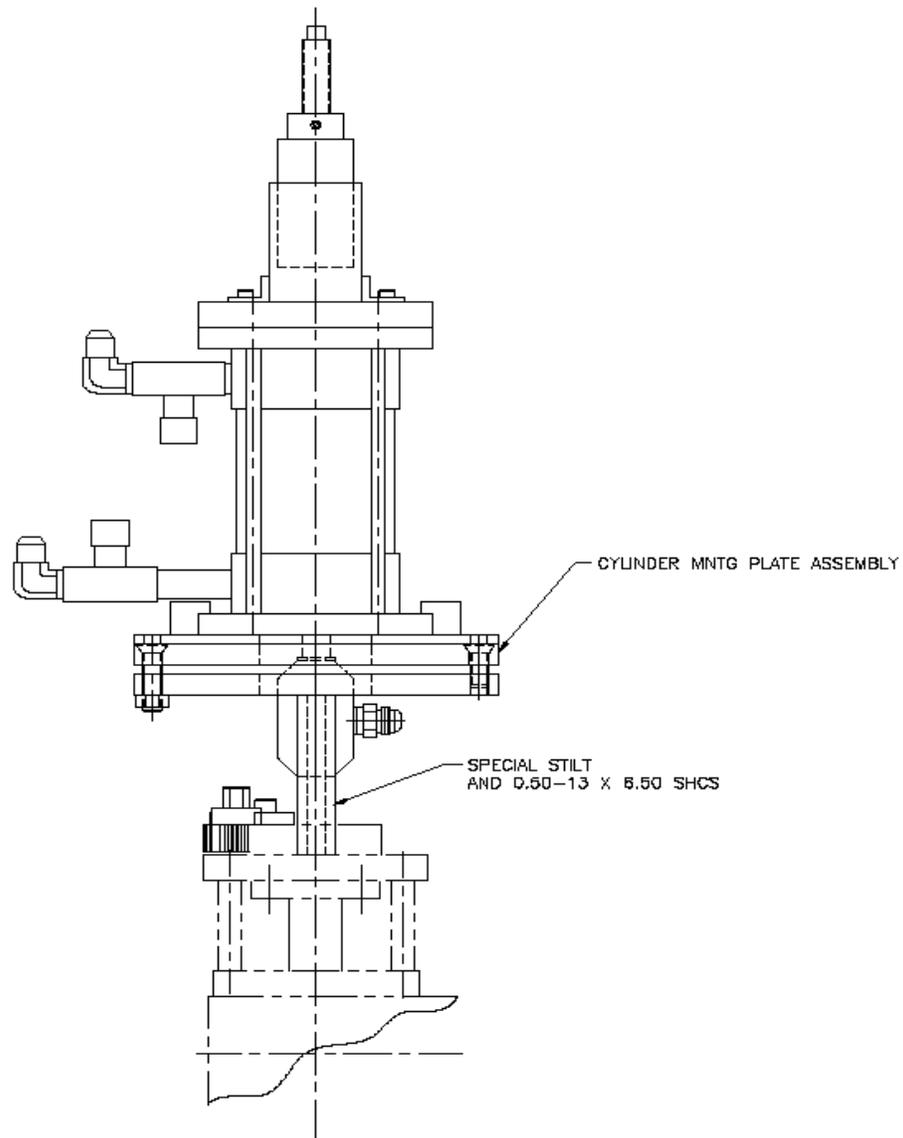
## Four Stilt Applications



The four stilt scenario is typically found with hydraulic prefinish without parison programming. It can also be found with both hydraulic and air prefinish with parison programming. The retrofit parts required for the four stilt application include:

- Special Length Stilts 4 per head
- 0.50-13 Set Screws 4 per head
- 0.50-13 Jam Nuts 8 per head

## Two Stilt Applications



The two stilt scenario is typically found with air prefinish without parison programming. The retrofit parts required for the two stilt application include:

- Special Length Stilts 2 per head
- Cylinder Mntg Plate Assembly 1 per head
- 0.50-13 x 6.5" SHCS 2 per head

### Sales and Service

For more information on these upgrades, 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.