

***** Increase the flexibility of your blowmolding machine *****

This month's web posting presents all of the extended shot conversions currently available for Uniloy Reciprocating Screw blowmolding machines. Extended shot conversions are designed to increase the amount of plastic which can be produced by your machine during each cycle.

The ability to produce more plastic in a single cycle, through an extended shot retrofit, increases the flexibility of your machine because it may allow you to:

- Run a wider range of container weights and sizes
- Run an existing container at a heavier weight
- Provide a basis to be able to increase the cavitation of your machine

Machine through put may also need to be increased in order to keep the machine cycle time at an acceptable level. Machine through put can be increased via a larger extruder drive motor or a higher efficiency extruder screw. Please contact your local Uniloy Parts Sales Representative to explore all of the aspects of your intended machine application change.

Retrofit Package Descriptions

The following section describes the capabilities and components of the kits for the machine types listed. Some kits are more involved than others, depending on the machine model and the amount of shot increase.

For 2011 and 2014 Machines

Shot Capabilities	Stroke (inches)	Shot (grams)
Existing	4.5	250
Extended	8.0	450

This retrofit package for a 2011 or 2014 machine includes:

- Shot Cylinder
- Shot Cylinder Tie Bars
- Shot Cylinder Limit Switch Trip Rod
- Ball Spline and Ball Spline Bushing
- Ball Spline Seals
- Extruder Barrel
- Barrel Split Ring
- Extruder Screw with keys
- Fittings and Fasteners

For 250R1 Machines

Shot Capabilities	Stroke (inches)	Shot (grams)
Existing	8.0	450
Extended	9.25	560

This retrofit package for a 250R1 machine includes:

- Shot Cylinder
- Shot Cylinder Tie Bars
- Ball Spline and Ball Spline Bushing
- Extruder Screw with keys
- Fittings and Fasteners

For 5700, 5710, 5720, 5730, 5800, 5810, 5830, 5840 Machines

Shot Capabilities	Stroke (inches)	Shot (grams)
Existing	6.0	675
Extended	7.25	815

The retrofit package for these machines includes:

- Shot Cylinder
- Shot Cylinder Mounting Plate
- Shot Cylinder Limit Switch and Brackets
- Thrust Bearing With Shoes
- Thrust Bearing Wear Strips
- Ball Spline and Ball Spline Bushing
- Ball Spline Seals
- Fittings and Fasteners

Machines with non-rotating shot cylinders will require only the check marked items. Machines with rotating shot cylinders will require all of the items listed above. Rotating shot cylinders are replaced by standard cylinders and thrust bearings.

For 5805, 5815, 5835, 5845, 5855, and 350R1 Machines

Shot Capabilities	Stroke (inches)	Shot (grams)
Existing	6.0	675
Extended	7.25	815

The retrofit package for these machines includes:

- Shot Cylinder
- Shot Cylinder Mounting Plate
- Thrust Bearing Wear Strips
- Ball Spline and Ball Spline Bushing

- Ball Spline Seals
- Extruder Reducer Shroud
- Fittings and Fasteners

For 5805, 5815, 5835, 5845, 5855, and 350R1 Machines

Shot Capabilities	Stroke (inches)	Shot (grams)
Existing	6.0	675
Extended	9.25	1100

The retrofit package for these machines includes:

- Shot Cylinder
- Thrust Bearing with Shoes
- Thrust Bearing Wear Strips
- Ball Spline and Ball Spline Bushing
- Ball Spline Cap
- Ball Spline Seals
- Extruder Reducer
- Extruder Reducer Shroud
- Extruder Barrel
- Barrel Support Bracket with Adapter & Spacer
- Barrel Split Ring
- Extruder Screw with Keys
- Extruder Adapter Plate
- Decline Nozzle and Extruder Drive Belts
- Fittings and Fasteners

For 350R2 Machines

Shot Capabilities	Stroke (inches)	Shot (grams)
Existing	8.0	900
Extended	9.25	1100

This retrofit package for a 350R2 machine includes:

- Shot Cylinder
- Ball Spline and Ball Spline Bushing
- Ball Spline Cap
- Ball Spline Seals
- Fittings and Fastener

For 350R2 Machines

Shot Capabilities	Stroke (inches)	Shot (grams)
Existing	8.0	900
Extended	13.25	1600

This retrofit package for a 350R2 machine includes:

- Shot Cylinder
- Ball Spline and Ball Spline Bushing
- Ball Spline Cap
- Ball Spline Seals
- Extruder Shroud
- Extruder Barrel
- Front Barrel Support Bracket
- Barrel Split Ring
- Extruder Screw with Keys
- Extruder Adapter Frame
- Decline Nozzle
- Extruder Drive Belts
- Fittings and Fasteners

For 350R4 Machines

Shot Capabilities	Stroke (inches)	Shot (grams)
Existing	12.0	1500
Extended	13.25	1600

This retrofit package for a 350R4 machine includes:

- Shot Cylinder
- Ball Spline and Ball Spline Bushing
- Ball Spline Cap
- Ball Spline Seals
- Fittings and Fasteners

Note: The overall length of the existing 350R4 ball spline must be measured and supplied to Uniloy at the time of order.

A Word About Extruder Conversions

In addition to shot size retrofits, Uniloy has designed a number of extruder conversions that increase the through put capacity of your machine as well. These retrofits include:

- AC Variable Frequency Drive Retrofits
- High Output Screw Retrofits

Uniloy also has the ability to increase shot capacity and through put by upgrading the extruder diameter. Examples of this type of retrofit include:

- 350R4 to 400R25
- RSI3500 to RSI4500

The benefit of choosing one of these retrofits includes:

- Increased Shot Capacity
- Increased Through Put
- Reduced Shear Heat
- Reduced Plastic Degradation

Please contact your local Uniloy Parts Sales Representative for more information on these conversions.

Installation

Trained Uniloy Service Technicians are available to install these packages at your facility.