



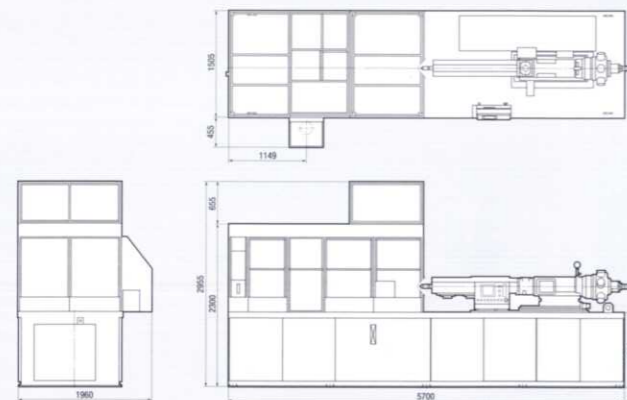
**One Step Stretch Blow Molding Machines**

**PF4-1BH**  
**PF3-1BH**  
**PF3-1BHLL**

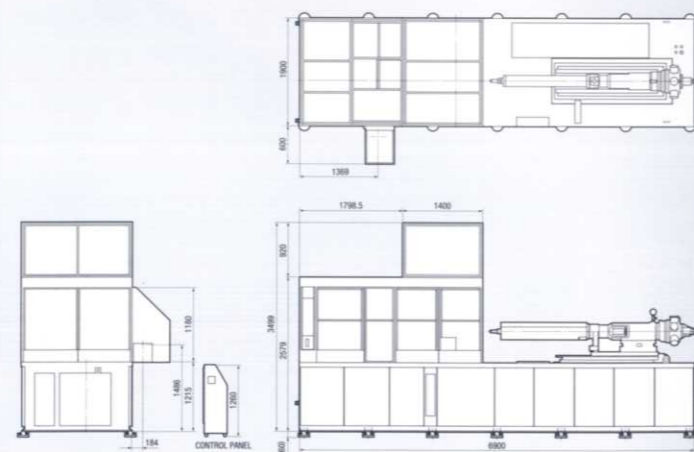
SPECIFICATIONS OF MACHINE

		PF4-1BH	PF3-1BH	PF3-1BHLL
THEORETICAL INJECTION CAPACITY	cm <sup>3</sup>	515	515	1060
DRIVING POWER	kW	34.3	34.3	59.2
HEATER CAPACITY	kW	45.3	45.1	62.5
OIL RESERVOIR CAPACITY	L	450	450	700
MACHINE SIZE (L×W×H)	mm	5700×1505×2955	5700×1505×2955	6900×1900×3499
MACHINE WEIGHT (APPROX.)	ton	9.5	9.5	16.5

**PF3-1BH/PF4-1BH**  
 FOUNDATION DRAWING



**PF3-1BHLL**  
 FOUNDATION DRAWING



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● Considerable effort has been undertaken to ensure that the information contained in this catalog is accurate but no warranties regarding accuracy are given.

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# ONE STEP STRETCH BLOW MOLDING MACHINES

**PF Series**

## PF4-1BH/PF3-1BH/PF3-1BHLL

### THIS MACHINE MOLDS LARGE PET BOTTLES WITH HANDLES WITH NEW CONCEPT.

There is two-step "cold parison" method in which the room temperature preform is reheated and blow molded and the one-step "hot parison" method in which the heat retained in the preform after it is molded is utilized.

On "PF Series" machines the preform is partially cooled, temperature distribution equalized, reheated and blown in a "cool parison" system. This new concept, in which the preform molding and blow molding processes are separated incorporates the advantages of both the one-step and two-step systems in an epoch-making bottle production system.

#### CONCEPTS OF THE PF SYSTEM

##### High quality

ASB's unique preform temperature control system provides the optimum temperature profile for consistent, uniform material distribution.

##### High productivity

ASB's unique post-molding preform cooling system combined with the fast dry cycle time means very high bottle output rates considering the size of the machines.

##### Low investment

Smaller machine size and straightforward mechanical design means that manufacturing costs are lower and makes the machines easy to operate and maintain.

##### Low mold cost

Fewer, smaller sized mold components means that mold costs are lower.

##### Fast mold change

Fewer, smaller sized mold components means that mold changeovers are fast.

##### Compact machines

Smaller tooling means the machines can be smaller and lighter for a given output so that valuable production space can be used more efficiently.

##### Energy efficient

PF machines use variable displacement pumps, and of course ASB's "cool parison" system means less energy is lost before reheating preforms.

##### Clean production

Hydraulic clamping systems are below the injection mold, thus eliminating potential oil contamination problems.

### PF4-1BH/PF3-1BH

● Molding Machine for the production of 4-6L PET Bottles

\*Machine shown in photo includes options.



Examples of bottles produced on PF4-1BH/PF3-1BH machine.

This machine is designed to produce larger bottles in 4 to 6 liter range sized bottles. PF4-1BH produces 4 preforms at a time of up to 109 grams weight and PF3-1BH produces 3 preforms at a time of up to 146 grams weight. This ensures high productivity for large sized bottles compared to conventional machines, because of the compact size and simplified mold design. It is possible to mold bottles with an integrated handle.



Examples of bottles produced on PF4-1BH/PF3-1BH machine.



Examples of bottles produced on PF4-1BH/PF3-1BH machine.

### PF3-1BHLL

● Molding Machine for the production of 12L PET Bottles

\*Machine shown in photo includes options.



It produces 3 preforms at a time of up to 377 gram weight. It is possible to mold large PET bottles up to 12L and bottles with handle.



Example of bottle produced on PF3-1BHLL machine.

#### PRODUCTS

		PF4-1BH	PF3-1BH	PF3-1BHLL
CAVITY NUMBER (PREFORM)	cavity	4	3	3
CAVITY NUMBER (BOTTLE)	cavity		1	1
MAX. PRODUCT CAPACITY	L		6	12
MAX. NECK FINISH SIZE	T mm	63(no handle) 48(handle)		73(no handle) 63(handle)
MAX. INLET OUTER DIAMETER	E mm	60(no handle) 45(handle)		70(no handle) 60(handle)
MAX. SUPPORT RING DIAMETER	SR mm	63(no handle) 54(handle)		73(no handle) 63(handle)
MAX. PRODUCT OUTER DIAMETER	BD mm		180	230
MAX. PRODUCT HEIGHT	HB mm		350	430
MAX. PRODUCT WEIGHT (C Type)	g	109	146	377

\*Specifications are subject to change without any obligation on the part of the manufacturer.

