

Monablow® 2150

INCREASED SIZE RANGE IN PLASTIC CONTAINER PRODUCTION

The Monablow 2150 is an advanced, yet simple and rugged, single station blow molder. Using field proven components and technology, Hayssen engineers have combined their exceptionally versatile vertical continuous extruders with generously sized clamps, straight line clamp index, long stroke blow pin actuation and "deep cooled" blow pins. The result — a highly versatile and fast workhorse, for both in-house and custom molders.

The Monablow 2150 is simple in design, rugged in construction, easy to operate and thrifty to maintain.

For an exceptionally wide size range of bottles

DUAL PARISON OPERATION

- Up to dual 64 oz. bottles
- Produces bottles up to 5¼" wide
- Up to 160mm (6.299") between centers. Extrusion heads and blow stations built to center distances between 125mm (4.921") and 160mm (6.299") per buyer's specification.

SINGLE PARISON OPERATION

- Up to 5 liter containers
- Up to 7" diameter

PRODUCES COMPLETELY FINISHED BOTTLES

IN-MOLD FINISHING (Standard Feature) Neck and tail trim can be separated in the mold and container ejected completely finished.

IN-LINE ADJACENT TO THE MOLD TRIMMING

This optional feature permits fully automated production of most con-

tainers which cannot be finished in mold. For handware and other designs requiring wide layflats and secondary flash removal, the in-line finishing feature provides the ability to fully finish the bottle. (Necks up to 48mm may be compression formed, in mold, using the standard built-in Monablow features, eliminating reaming and cutting to size.)

USES ALL TYPES OF RESINS

The Monablow 2150's vertical extruder permits exceptionally smooth flow through the extrusion level and assures trouble-free operation with virtually all commercially available blow molding grade resins, including: HDPE • LDPE • PVC • POLYPROPYLENE • POLYCARBONATE • NITRILE BASE BARRIER RESIN • CRYSTAL STYRENE • ACRYLIC • FEP (Teflon) • UHMWPE

SINGLE STATION/ VERTICAL EXTRUDER BLOW MOLDING MACHINE

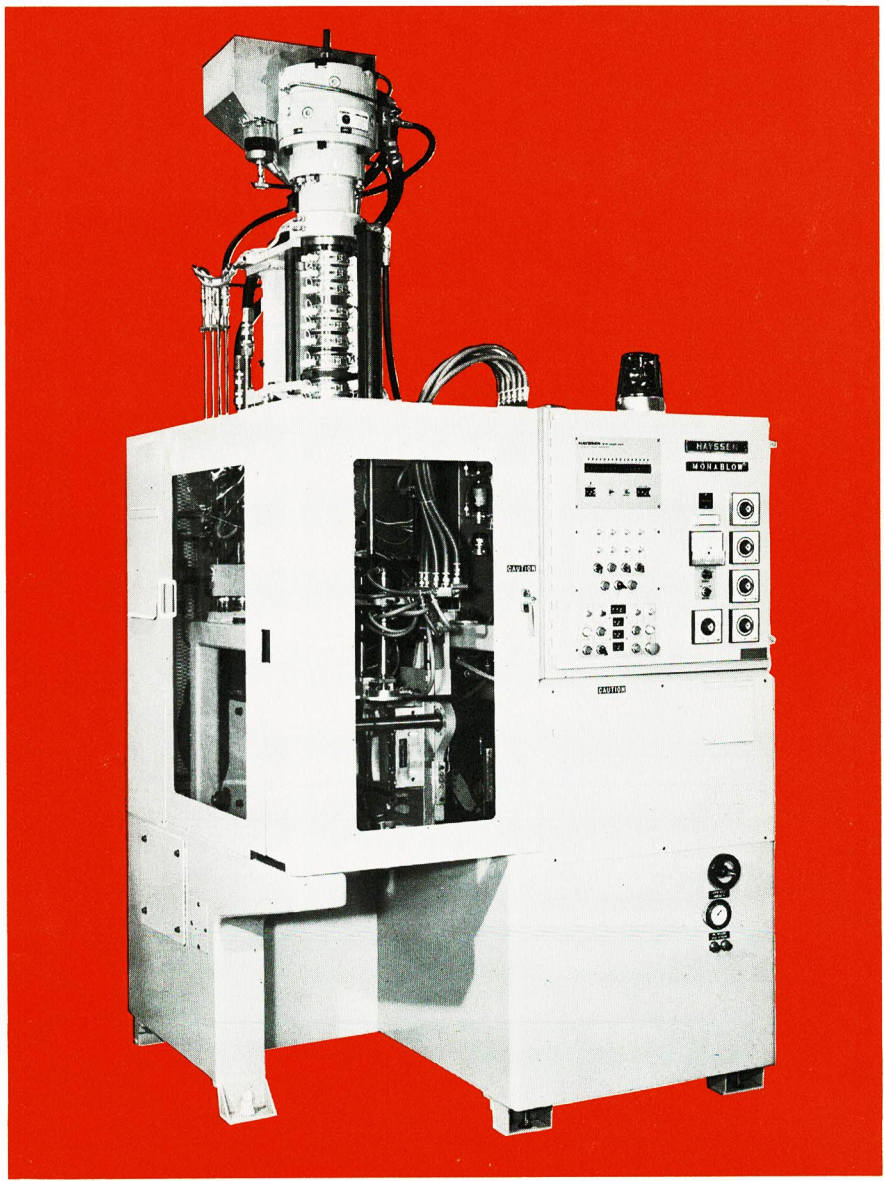
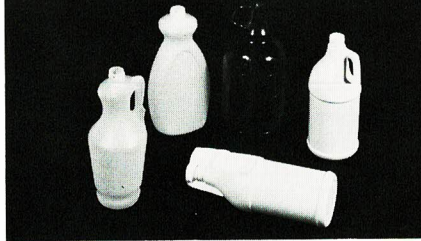
Single parison, with optional in line trimming (Up to 7" diameter)



Dual parison — standard operation (Up to 5¼" wide)



Dual parison — with optional in line trimming (Up to 5¼" wide)



HAYSSSEN®

Monablow 2150

STANDARD FEATURES

- Extrusion rate—up to 105 lbs./hour
- Neck trim circuitry
- Bottom detabbing circuitry
- Pre-blow
- Bimetallic extruder barrel
- Choice of standard cold cutoff knife or optional hot knife
- Time proportioning solid state heat controls
- Vickers hydraulic (or equivalent)
- Cycle counter
- Safety alarm

OPTIONAL EQUIPMENT

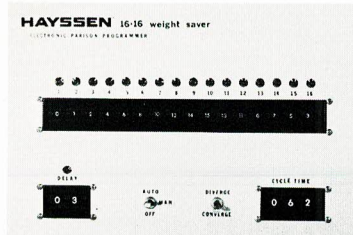
- 16 x 16 Hayssen "WEIGHT-SAVER" parison programmer
- Oriented discharge
- Adjacent to the mold in-line finishing

ORIENTED DISCHARGE

This optional feature presents the fully finished bottle, upright, to the user's takeaway conveyor, permitting automation of and/or simple interface with live storage, flame treating, decorating, filling or packing.

ACCEPTS EXISTING MOLDS

Most molds, designed for in-mold finishing are easily adapted for production in the Monablow 2150. Many molds producing product requiring secondary finishing can be easily modified to eliminate semi automatic finishing with the optional in-line finishing feature. Troublesome reaming operations can be eliminated by preforming necks in the mold.



ELECTRONIC PROGRAMMING

The Hayssen 16 x 16 "Weight-Saver" changes the wall thickness of the parison during the extrusion cycle to distribute material more evenly, and reduce the amount of resin used in each product. 16 segments of programming, combined with a delay and programming cycle timer, permit programming of the entire parison length. (Or a selected portion of parison length.) 16 different weight settings are available in each of the 16 programming segments. Pneumatic positioning input coupled to a simple hydraulic actuator eliminates the need for exceptionally fine hydraulic filters, assuring high uptime.

Easy to understand and simple to use, a change from convergent to divergent tooling is accomplished by the flip of a switch. Timers and weight settings are digital, insuring ease of recording and listing on set up and operation instructions.

The simplicity and low cost of the Hayssen 16 x 16 "Weight-Saver" enables every blowmolder to enjoy the economies afforded by close parison control.

MADE IN U.S.A.

Hayssen offers a totally U.S.-built machine in the series 2150 MONABLOW. It uses components which are available in the United States. Servicing is performed by Hayssen's worldwide technical staff, thus providing single-manufacturer responsibility.

SIMPLE, RUGGED, DEPENDABLE

For maximum accessibility, all services are connected above the machine base.

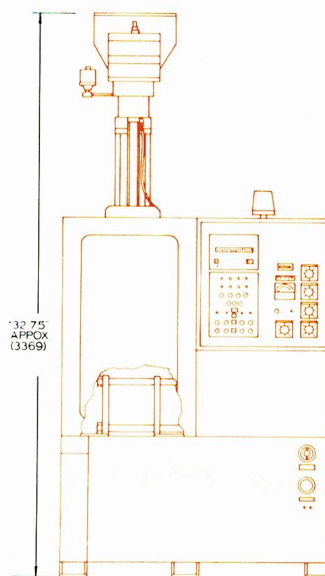
The hydraulic oil tank has a heat exchanger, oil level and temperature gauge. There is a multiple port water manifold to feed several zones for mold cooling. Pneumatic strainer, pressure regulator, and oiler are accessible without need to remove base covers. All hydraulic directional valves are mounted on a manifold block readily accessible for maintenance and repair. All pneumatic valves and solenoids are contained in one control console. High voltage equipment is housed in a NEMA 12 control enclosure with safety interlock main disconnect switch. Should a jam occur in the mold area a safety alarm feature will stop the operation and avoid possible damage to the equipment. Motors are dual voltage squirrel cage type, directly coupled to variable displacement pumps for extruder speed and platen pressure adjustment.

SPECIFICATIONS

HAYSSEN MONABLOW 2150

Mold Unit:	ENGLISH	METRIC
Platen	14½" x 14½"	368-368 mm
Max. daylight	18½"	470 mm
Min. daylight	10"	254 mm
Clamp Stroke	8½"	216 mm
Extruder:		
Screw Diameter	2"	50.8 mm
Screw L/D Ratio	24:1	
Screw Speed		
	Variable PE 20-120	
	PVC 20-80	
Output:		
Approx. PE up to	105 lbs./hour	47 kg/hour
PVC up to	105 lbs./hour	47 kg/hour
Hydraulic Operating Pressure:		
Extruder	up to 1500 PSI	85 Atm.
Mold Unit	up to 750 PSI	53 Atm.
Air:		
	4 CFM @ 80 PSI	115 liters/min. @ 5.6 kg/cm
Water: (Exclusive of Mold Cooling)		
	6 gal./min. @ 60°F	12 liters/min. @ 15°C
Electrical:		
Heaters		
Barrel	3 x 2100 w	
Head	1 x 1000 w	
Tip	1 x 1000 w	
Voltage	220/3/60	
	Standard	
	Other available	
Horsepower:		
Extruder Drive	20 HP	
Mold Indexing	5 HP	
Weight:		
Shipping Weight	5760 lbs.	2612 kg
Net	6350 lbs.	2880 kg

Printed in U.S.A.
FORM NO. PF-504-3373



Illustrations and specifications are subject to change without notice. Any dimensions not to scale and approximate. Machines shown without guards are for illustrative purposes only. Guards are supplied and must be in place before operation. Sales are subject to prevailing terms and conditions of sale.

