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APPLICATIONS FOR SELF-ALIGNING INSERTABLE TOP BLOCKS

The self-aligning top blocks were designed to extend the life of your shear steel and blow pin neck tooling, improve the quality of the shear at the top inside diameter of your bottle neck finish, and maintain a clean parting line match in the neck finish area of the bottles being made. Most blow molds are manufactured with pins and bushings mounted in the bodies of the molds to control the alignment between the two halves of the mold set. When these mold pins and bushings start to wear, the mold halves move slightly from side to side creating a mismatch at the parting line of the blowmolded part. It is recommended that these mold body pins and bushings be changed every (6) months. This requires that the mold set be removed from the machine clamp, replacing the pins and bushings, and remounting the molds in the clamp.

Problems created by worn mold pins and bushings.

When this mismatch occurs it can begin to cause premature wear on the shear steels and blow pins. This is because the small .001" to .002" design gap between these two wear parts is artificially closed to nothing when there is any mismatch at all between the two halves of the mold set. When this mismatch occurs you may get an uneven shear at the inside diameter of the neck finish of the bottle. This will show up as patches of fuzz around the inside of the bottle neck finish. Also, when this mismatch occurs you may start to see a mismatch at the parting line of the neck area of your bottles. This will cause either vertical or horizontal steps in the neck finish at the parting line of the neck finish.

Solution to the problem.

The self-aligning top blocks have their own set of pins and bushings mounted in them to keep the two halves of the top blocks in alignment with each other, regardless of the condition of the pins and bushings in the body of the mold set. These top block pins and bushings can be changed without removing the molds from the clamp of the machine, but instead by just removing the top blocks from the molds. The self-aligning top blocks are designed to move independent of the mold bodies so that they may be kept in alignment regardless of the condition of the mold pins and bushings. Since the alignment of the body of the molded bottle is less critical than the alignment of the neck finish area, you can focus your maintenance efforts where they are most needed. By keeping fresh alignment pins and bushings in the top blocks of your molds, you can maintain a higher quality neck finish on your bottle products and extend the life of your neck tooling components.