

<p align="center"><b>Blow Molding</b> Group Module: 18</p>	<p>TEL 204: Polymer Molding &amp; Forming Department of Technology</p>	<p>Student Name: (PRINT)</p>
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**Overview:**

Blow molding produces hollow products such as bottles and jugs. Thermoplastic is heated, extruded as a parison, and clamped into a split mold. Air is then blown down into the parison forcing the plastic to the outside of the mold cavity.



**Module Grade:**

Mold Alignment (20)	Wall Thickness & Structure (20)	Fully Formed Part (20)	Trim & Finish (20)	Lessons Learned (20)
Instructor Signature:			Date:	Grade:

**Molding Procedures:**

1. Wear safety glasses.
2. Wear gloves and do not touch hot molds, hot plastic, hot molder surfaces.
3. Preheat molder to 350 – 380 degrees.
4. Load the hopper. Use only 1” of material as it is easier to see what is happening.
5. Pack the cylinder by activating the plunger. If necessary, use a plastic welding rod or scrap thermoplastic (never wood or metal) to stuff the material down into the barrel.
6. Form the parison. Let it go past the bottom of the mold.
7. Activate the handle to clamp the mold.
8. Apply blowing pressure (20 – 40 psi).
9. Remove and trim the pinch-offs when hot using a utility knife.

**Lessons Learned:**

List the most important lessons learned from this polymer module.

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**Notes**