

# Model CS-1

## ROCHELEAU MODEL CS-1

Continuous Extrusion  
Blow Molding Machine



- ◆ Oriented bottle take away with deflash punch station
- ◆ Fully adjustable hydraulic finish station allows precise control for rounds, ovals, and off-set neck finishes
- ◆ Full proportional valve hydraulics
- ◆ Simple control panel for operator input
- ◆ File storage of timers and speed controls allows for quick mold changeovers



The Rocheleau Model CS-1 Blow Molder is designed for continuous bottle production with calibrated neck finish. Competitive cycle rates and fast mold changes make the CS-1 a versatile performer, either as a dedicated machine or for short-run jobs.

Tiebarless clamp design accommodates oriented bottle take away and in-line trimming. 100% unobstructed access to molding area facilitates fast mold changes. Open, rugged layout simplifies preventative maintenance and machine set-up.

Low maintenance hydraulic power unit with easily accessible components. Full proportional hydraulics provide accurate control for extruder speed, clamping, calibration, and shuttle.

File storage for multiple job changes, including all timer settings and speed settings for all machine functions.

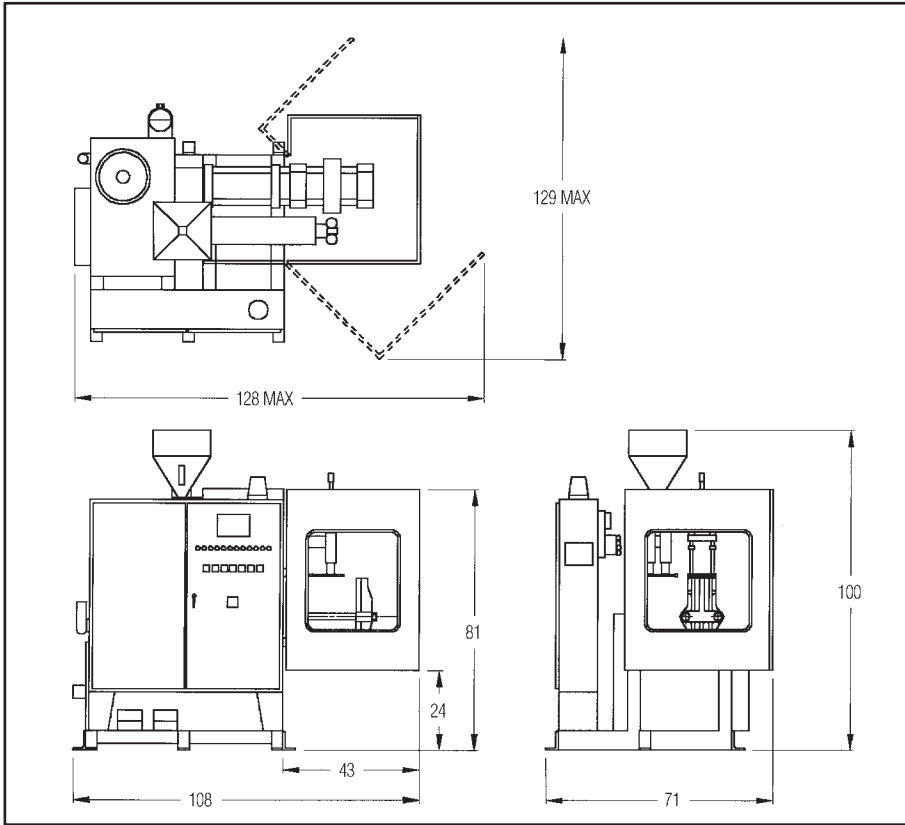


*Rocheleau Tool & Die Co., Inc.*

117 Industrial Road, Fitchburg, Massachusetts 01420 USA

(978) 345-1723 ♦ Fax (978) 345-5972 ♦ E-mail: [steven@rocheleautool.com](mailto:steven@rocheleautool.com) ♦ [www.rocheleautool.com](http://www.rocheleautool.com)

# CS-1 SPECIFICATIONS

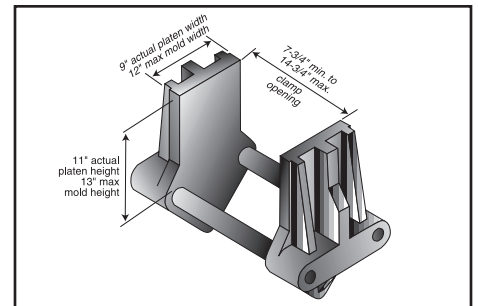


## HYDRAULIC - MODULAR POWER UNIT

- ◆ Dual pressure compensating pumps, one for extruder drive, one for machine functions
- ◆ Recirculator pump for continuous oil filtration and cooling
- ◆ 100 gallon reservoir with level/temperature safety sensor
- ◆ Full proportional valve controls
- ◆ 2,000 PSI maximum system pressure

## EXTRUDER

- ◆ 2.0" (50 mm) diameter 24/1 ratio (L/D) screw, Stellite flights
- ◆ Bi-metallic barrel
- ◆ Continuous high torque hydraulic motor screw drive, 0-130 RPM
- ◆ 120 lbs/hour (55 kg) HDPE output
- ◆ Stainless steel hopper, 75 lb. capacity
- ◆ Hydraulic extruder lift with air-operated hot knife for parison cutting
- ◆ Optional feed screws for PVC and other special resins



## CLAMP

- ◆ 2.5" bore x 7" stroke hydraulic cylinder, 5 tons force
- ◆ 7.75" minimum mold shut height
- ◆ 7" maximum mold daylight
- ◆ Adjustable mold daylight
- ◆ Rapid closing with deceleration control

## ELECTRICAL

- ◆ 40 HP, 1800 RPM, 230/460 volt, 3 phase, 60 Hz motor
- ◆ Solid state programmable controller
- ◆ Solid state touchpad data access unit
- ◆ 220 volt heater bands, 10.9 Kw heater load, single head
- ◆ 3-zone extruder temperature controls, fan cooling
- ◆ Individual die head temperature controls, variac nozzle controls
- ◆ 150 full load amps @ 230 volts, approximately 95 running amps

## GENERAL

- ◆ 6,000 pounds net weight
- ◆ 5 tons chilled water required, molds and machine
- ◆ 20 CFM @ 100 PSI compressed air required

## OTHER STANDARD EQUIPMENT

- ◆ File storage for multiple job setups
- ◆ Deflash punch actuator and transfer nest mounting brackets
- ◆ RPM indicator for extruder speed
- ◆ Manifold mounted air solenoid valves
- ◆ Main line coalescent air filter
- ◆ Warning beacon for machine safeties
- ◆ Mold safety bottle jam detection
- ◆ Two eight-station water manifolds
- ◆ Fully guarded with electrical interlock for operator safety
- ◆ Hopper magnet
- ◆ Machine mounting pads

## CS-1 PRODUCTION CAPABILITY

	D	X	X	X
X	-	5" (127 mm)	3.375" (85.7 mm)	2.36" (60 mm)
D	5" (127 mm)	4.25" (108 mm)	3" (76 mm)	1.75" (45 mm)
H	11" (280 mm)	11" (280 mm)	11" (280 mm)	11" (280 mm)

Standard head centers listed. Systems may be modified to accommodate your specific requirements.

Notice: The company reserves the right to incorporate any changes in design without obligation to make these changes on units previously sold.