Parison Heads

The behaviour of the melt as it flows from the extruder through the die plays a vital role in creating the parison and quality product. A well-designed head will ensure there are no imbalances in the melt flow through the head that will create variations in the parison wall.

The center flow head provides a smooth and direct path for the plastic melt. The melt is directed from the extruder directly over the torpedo, keeping the melt flow balanced and pressure consistent. This prevents material from dwelling in sections of the head and degrading, assisting in faster purging and colour changes.

In the center flow head, the center pin is fixed to the torpedo. The die will move to control the die gap between the pin and the die. A brass bushing ring is installed to accommodate the movement of the die. The tolerance between the brass ring and the outer section of the head is such that it will prevent the plastic from leaking but is free enough to allow the die to move.

Balancing the flow so that each parison extrudes the same amount of plastic is critical in multi-parison heads. Typically, our heads are balanced when shipped from the factory. However, if an imbalance occurs, individual chokes in the head's splitter section restrict the plastic flow to each parison.

Our center flow heads are capable of processing the following materials.

HDPE, LDPE, HMPE, PP, PVC and PET

With our heads, you have the following options,

3 layer

Deco layer

Visi-Stripe

A chart of the common heads we have produced.

|  |  |
| --- | --- |
| Number of Parisons | Center Distance |
| 1 | - |
| 2 | 165 |
| 2 | 300 |
| 3 | 75 |
| 3 | 100 |
| 3 | 250 |
| 4 | 150 |