

ABSTRACT OF THE DISCLOSURE

A novel method enabling stretch blow molding in a temperature range preferable for polyethylene, capable of releasing at a surface temperature suited to both releasing
5 of a preform and subsequent stretch blow molding, by disconnecting the core die and the preform in advance by the use of pressure of gas.

This is for injection molding a predetermined preform by filling an injection mold with molten polyethylene,
10 releasing the preform from the cavity die and core die of the injection mold while a mouth portion of the preform is held by the lip die, and transferring the preform into a blow die to stretch blow mold into a hollow molded product of thin wall. Gas is forcedly entered into the boundary of the core
15 die and the preform, before releasing the preform from the injection mold, to isolate the inside wall of the preform from the core die. Releasing is effected while the inside of the preform is not completely cooled and is still at high temperature, and in a temperature range in which the surface
20 temperature of the preform right after releasing is 80 to 90 deg. C. The step of stretch blow molding is performed within the time interval before the surface temperature of the preform which is elevated by the internal heat of the preform reaches 120 deg. C.