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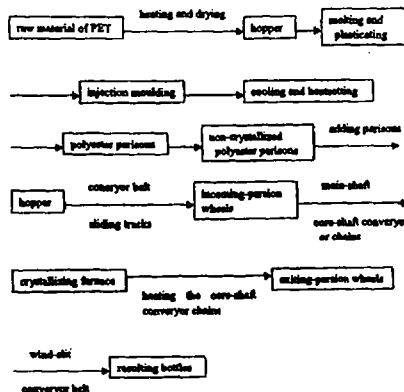
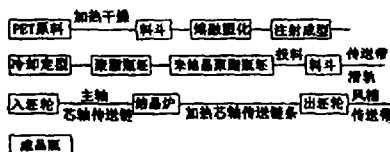
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(54) Title: THE CRYSTALLIZED NECK OF POLYESTER BEER BOTTLE AND THE MANUFACTURING THEREOF

(54) 发明名称: 聚酯啤酒瓶结晶型瓶口及其制造工艺



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(57) Abstract: The present invention discloses a crystallized neck of polyester beer bottle. The crystallized neck has no thread, and the length of the crystallized part of the neck is 0.5-35mm. For manufacturing this neck, before crystallizing, the non-crystallized polyester parison is kept in the air-conditioned environment for 24-72 hours, and the crystallizing furnace is preheated for two hours or more. The non-crystallized polyester parison is placed into a hopper, and conveyed onto incoming-parison wheels via a conveyor, the neck part of the bottle parison is then transferred by core-shaft conveyor chains into the crystallizing furnace to be heated and crystallized at high temperature, at the same time, preventing the non-crystallized part of the bottle body from being affected by high temperature using a cooling isolate plate. The polyester bottle parison having a crystallized neck is conveyed out by exiting-parison wheels, and transferred onto the cooling conveyor to be cooled naturally and be heatset. The use of the crystallizing neck of the polyester beer bottle parison and the manufacturing method thereof according to the invention can improve effectively the heat resistance of the neck of polyester beer bottle and the stability of size when heated, so that satisfactory sealing effect can be achieved during beer-filling, and the quality of the beer can be ensured.

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(57) 摘要

一种聚酯啤酒瓶结晶型瓶口，所述瓶口部分为无螺纹的瓶口，其瓶口的结晶长度在 0.5-35 mm 范围内。为了制造上述结晶型瓶口，在结晶前，使未结晶的聚酯瓶坯在空调环境下存放 24-72 小时，还使结晶炉预热两个小时或更长时间。将未结晶的聚酯瓶坯放入料斗，经过传送带被送至入坯轮，再由芯轴传送链条使瓶坯的瓶口部分被送入结晶炉内进行高温加热、结晶，并通过冷却隔离板使坯身的未结晶部分不受高温影响。瓶口结晶的聚酯瓶坯经出坯轮送出，转入冷却输送带进行自然冷却、定型。采用本发明的聚酯啤酒瓶结晶型瓶口及其制造工艺，有效地提高了聚酯啤酒瓶瓶口的耐热性能和受热时尺寸的稳定性，使其能在啤酒的灌装应用中达到良好的密封效果，安全可靠，保证被罐啤酒的质量。