

**METHOD OF MOLDING LARGE CONTAINERS BY THE PROCESS OF
STRETCH BLOW MOLDING**
ABSTRACT OF THE DISCLOSURE

There is provided a method of molding a large container including the steps of preparing a preform from an injection-molded, thick-wall closed-end parison by repeatedly and intermittently applying an air blow pressure to the parison and releasing the air blow pressure therefrom, and stretch blow molding the preform to a thin-wall large container.

The closed-end parison is released from a mold immediately after a skin layer keeping a parison shape is formed on the surface of the closed-end parison having a high inner temperature, and is then molded to a preform with a preform mold heated to a predetermined temperature, while the surface temperature of the parison is increased by the inner temperature. The preform kept at a stretch blow molding temperature is stretch blow molded into a blow mold to produce a large container.

This Sheet Has Been Replaced



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