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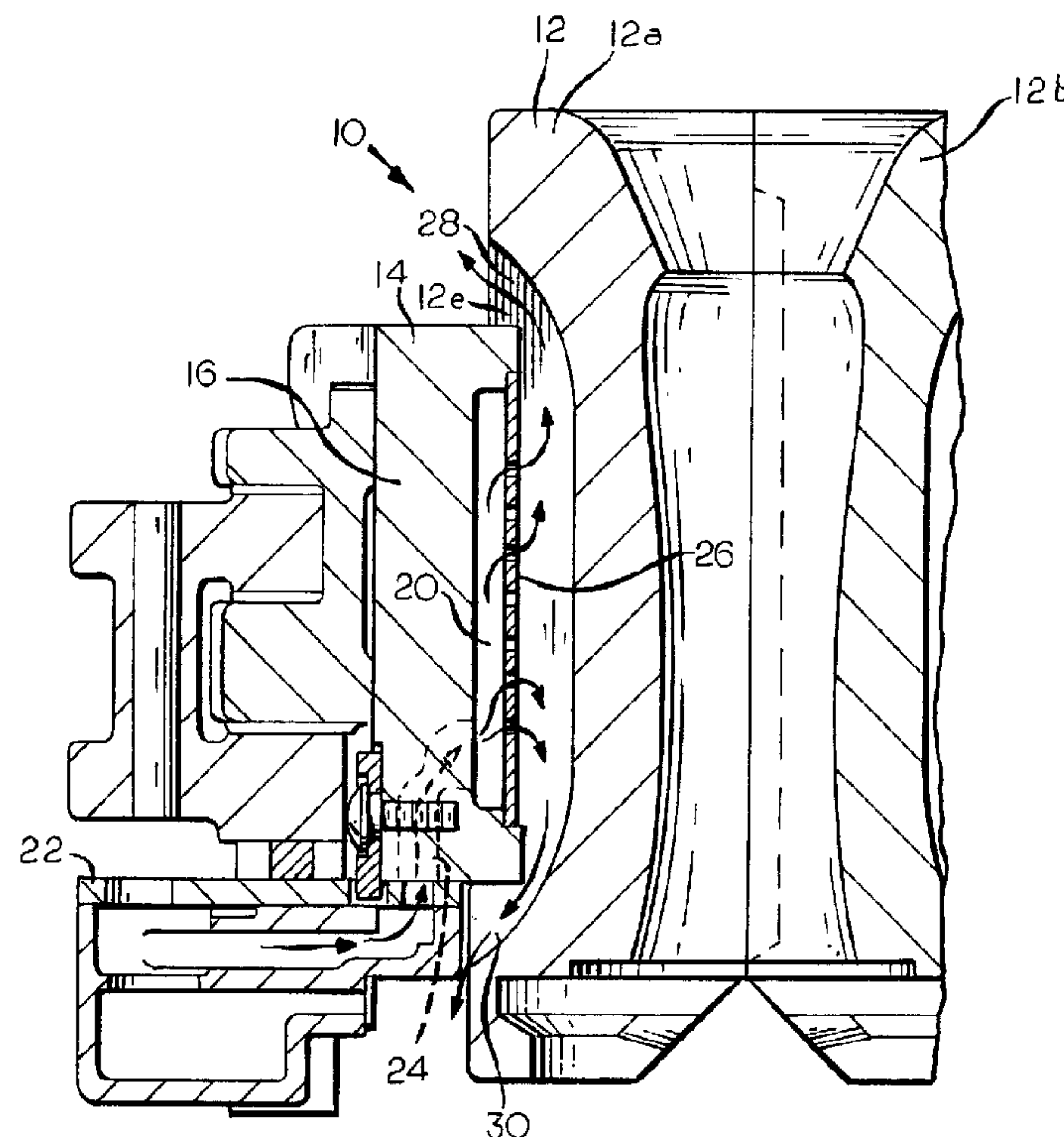
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(54) Title: MOLD ASSEMBLY FOR GLASS ARTICLES



(57) Abrégé/Abstract:

A mold assembly (10; 40) for molding a hollow glass article comprising a mold (12) that is made up of a separable pair of mold elements (12a, 12b; 42) and a mold holder (14; 44) that surrounds a portion of the mold of substantial axial length. The mold is separable from the mold holder, and the exterior of each mold segment is provided with a plurality of cooling fins (12e; 42e). The mold holder is made up of a separable pair of mold holder sections (16, 18; 46), and each mold holder section has a fluid flow passage (20; 50) extending therethrough. The fluid flow passage is radially open to permit fluid flowing therethrough to flow inwardly against the fins of an adjacent mold element. Each mold holder section has a perforated screen (26; 56) affixed thereto to vary the distribution of the flow of fluid from the mold holder section against the fins of the adjacent mold element.

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Abstract of the Disclosure

A mold assembly (10; 40) for molding a hollow glass article comprising a mold (12) that is made up of a separable pair of mold elements (12a, 12b; 42) and a mold holder (14; 44) that surrounds a portion of the mold of substantial axial length.

5 The mold is separable from the mold holder, and the exterior of each mold segment is provided with a plurality of cooling fins (12e; 42e). The mold holder is made up of a separable pair of mold holder sections (16, 18; 46), and each mold holder section has a fluid flow passage (20; 50) extending therethrough. The fluid flow passage is radially open to permit fluid flowing therethrough to flow inwardly against the fins of

10 an adjacent mold element. Each mold holder section has a perforated screen (26; 56) affixed thereto to vary the distribution of the flow of fluid from the mold holder section against the fins of the adjacent mold element.

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Mold Assembly for Glass Articles

Field of the Invention

This invention relates to a mold assembly for use in forming hollow glass articles on a forming machine of the individual section ("I.S.") type. More particularly this invention relates to a mold assembly of the foregoing character that provides positive, indirect cooling of the article being molded in the mold assembly.

Background of the Invention

Hollow glass articles, such as bottles and jars, when molded by a forming machine of the I.S. type, are molded in two steps. In the first step, a preform of the finished container, which is usually called a blank or a parison, is molded by an annular mold made up of a pair of mating blank mold sections. Upon the completion of the blank molding step, the blank mold sections separate and the blank or parison is transferred to another mold station, often called the blow mold station, where it is blown into its final shape by another annular mold that is made up of another mating pair of mold sections. At the conclusion of the blow mold process, the mating sections of the blow mold are separated, and the container is removed from the forming machine for further processing.

The glass gob that is formed into a parison in the blank mold of an I.S. machine is sufficiently hot to be capable of being shaped into a blank and, thus, possesses a high level of latent heat. Much of this heat must be removed before the container is removed from the blow mold of the forming machine, however, so that the finished container will be sufficiently rigid to undergo further processing without any further change in its shape. Thus, much heat must be removed from the container being formed, both during the blank molding step and the blow molding step, and unless the heat is removed at a rapid rate, the productivity of the forming machine is unduly limited. The problem of heat removal from the molds of an I.S. forming machine at a suitable rate is especially important at the blank mold station because the surface area of the parison is quite small due to the small diameter of the parison, which limits the rate at which heat can be removed, and the amount of heat to be

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removed is quite high due to the larger wall thicknesses of the parison in comparison to the wall thicknesses of a finished container.

Various prior artisans have addressed problems encountered in cooling glass articles being formed by an I.S. machine, as disclosed by U.S. Patents 3,887,350 (Jenkins), 4,657,573 (Jones), 4,668,269 (Cantu-Garcia et al.), 4,690,703 (Kulig), 4,783,212 (Loffler) and 5,364,437 (Bolin). The problems with the aforesaid and other prior art approaches to mold cooling of I.S. machine molds is that they add considerably to the complexity, and thus the cost, of the forming machine molds, each set of which is especially designed for only a single type of product. Thus, it is advantageous to incorporate as much of the required mold cooling structure in other structure of an I.S. molding machine that does not need to be changed every time a set of molds is replaced to permit the machine to manufacture containers of a different type, size or design.

Brief Description of the Invention

According to the present invention there is provided a mold assembly for a glass forming machine of the I.S. type. The mold assembly includes an annular mold, which is made up of a mating pair of mold sections, whose internal surface, when the mold sections are joined end to end, defines the external shape of a glass article to be formed in an internal cavity of such annular mold, either the final shape of a glass article in the case of a blow mold or the shape of a preform of such article in a blank mold. The exterior of each of the mold sections is provided with a circumferential plurality of radially projecting, axially extending spaced apart ribs to extend the surface of the mold sections to thereby increase the rate at which latent heat can be removed from the molten glass article within the mold.

The mold assembly also includes a split mold holder for holding the mold sections of a mold, as heretofore described. The mold holder, which is suitable for use with a variety of molds, surrounds the mold and directs air or other cooling fluid

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radially inwardly against the ribs on the exterior of the mold sections from radially open, axially extending flow passages. A split, perforated screen is applied to the interior of each of the sections of the mold holder and controls the distribution of the flow of cooling fluid against the mold. Thus, by controlling the pattern of the perforations in the perforated screen, it is possible to vary the rate of cooling of the mold sections, circumferentially and axially, to equalize the rate of cooling of the glass article in the mold, notwithstanding variations in the thickness or shape of the glass article, which effects the rate at which latent heat is to be removed from different locations of the glass article.

Because the sections of the mold holder, and the perforated screen sections that are attached to them, can be used with a variety of molds, the fabrication costs of the molds are reduced in comparison to costs of molds whose coolant flow passages are contained in the molds themselves.

Accordingly, it is an object of the present invention to provide an improved mold assembly for a glass forming machine. More particularly, it is an object of the present invention to provide a mold assembly of the foregoing character with improved indirect cooling of a molten glass article being formed therein. Even more particularly, it is an object of the present invention to provide a mold assembly of the foregoing character of reduced mold structural complexity.

For a further understanding of the present invention and the objects thereof, attention is directed to the drawing and the following description thereof, to the detailed description of the preferred embodiment and to the appended claims.

Brief Description of The Drawing

Fig. 1 is a perspective view of a mold assembly according to a preferred embodiment of the adaption of the present invention to the blank mold station of an I.S. glass forming machine;

Fig. 2 is a plan view, partly in section and at an enlarged scale, of the mold assembly of Fig. 1;

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Fig. 3 is fragmentary elevational view, in cross section and at an enlarged scale, of the mold assembly of Fig. 1;

Fig. 4 is an elevational view of a mold section, from the inside or internal cavity looking outwardly, of a mold assembly according to a preferred embodiment of the adaptation of the present invention to the blow mold station of an I.S. glass forming machine;

Fig. 5 is a top plan view of the mold section shown in Fig. 4;

Fig. 6 is a sectional view taken on line 6-6 of Fig. 4.

Fig. 7 is a bottom plan view of the mold section shown in Figs. 4-6;

Fig. 8 is a sectional view taken on line 8-8 of Fig. 5; and

Fig. 9 is a sectional view taken on line 9-9 of Fig. 6.

Detailed Description of the Preferred Embodiment

A mold assembly according to the preferred embodiment of the present invention is identified generally by reference numeral 10 in Fig. 1, and is made up of an annular mold 12, which is illustrated as being suitable for use in forming a parison of a glass container. The mold assembly 10 also includes an annular mold holder 14, which encloses a substantial portion of the axial length of the mold 12 and is a part of an I.S. glass container forming machine or at least is a part that does not need to be replaced when the mold 12 is replaced.

The annular mold 12 is made up of generally semi-cylindrical mold elements 12a, 12b, which, when joined end to end during a molding operation, substantially enclose a glass article being molded in a cavity therein. The mold elements 12a, 12b are separable from one another at the conclusion of a molding step, to permit a molded article to be removed therefrom, as is known in the art. In that regard, each of the mold elements 12a, 12b is provided with a tongue 12c and a groove 12d, which are diametrically opposed to one another, to permit the mold elements 12a, 12b to be precisely aligned with one another during the molding operation. Each of the mold

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elements 12a, 12b is also provided with a circumferentially disposed, radially projecting and axially extending series of spaced apart fins 12e, which assist in the cooling of a glass article being formed in the mold 12 to make the glass article more rigid and self-supporting than it would otherwise be at its required, elevated molding temperature.

The mold holder 14 is made up of generally semi-cylindrical holder sections 16, 18, which are positioned substantially end to end during a molding step but are separable from one another at the conclusion of a molding step when the mold elements 12a, 12b separate from one another to remove a molded article therefrom. Each of the holder sections 16, 18 has a generally semi-cylindrical flow passage 20 extending axially therethrough. The passage 20, which is radially open on its interior, serves to permit cooling air or other coolant, from a source to be hereinafter described in greater detail, to flow against the fins 12e of the mold sections 12a, 12b to assist in the indirect cooling of a glass article being formed within the mold 12.

Cooling air flows into the flow passage 20 of the mold holder sections 16, 18 from a plenum 22 at the bottom of the mold holder 14 through a circumferentially spaced apart series of openings 24. From the flow passages 20 the cooling air flows radially inwardly against the mold sections 12a, 12b through generally semi-cylindrical, perforated screens 26 that are affixed to the interior of the mold holder sections 16, 18. The perforations in the perforated screens 26 are sized and spaced to vary the cooling air flow distribution vertically, and circumferentially if desired, with respect to the exteriors of the mold sections 12a, 12b to equalize the rate of cooling of the article in the mold 12, notwithstanding variations in the cooling load due to localized variations in the diameter or wall thickness of the glass article.

The mold holder sections 16, 18 of the mold holder 14 have less axial extent than the mold sections 12a, 12b and are centered with respect to the mold elements 12a, 12b. Thus, the cooling air from the mold holder 14 can exit from the exterior of the mold elements 12a, 12b through openings 28, 30 at the top and bottom, respectively, of the mold holder 14, in the orientation illustrated in Fig. 3.

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The ends of mold holder sections 16, 18 are disengageably secured to diametrically opposed pairs of vertically extending connectors 32, 34 by cap screws 36. The connectors 32, 34 have radially inwardly projecting tabs 32a, 32b and 34a, 34b respectively, that are received in slots of the mold elements 12a, 12b to accurately
5 circumferentially position the mold holder sections 16, 18 with respect to the mold elements 12a, 12b. The tabs 32a, 32b, and 34a, 34b also engage the free ends of the screens 26 to accurately circumferentially position the screens 26 with respect to the mold holder sections 16, 18, respectively. Further, the fins 12e of the mold elements 12a, 12b have radially outwardly projecting portions 12e¹, 12e¹¹ at the top
10 and bottom, respectively, of each of the fins 12e. The portions 12e¹, 12e¹¹ have shoulders that engage the top and bottom of the mold holder sections 16, 18, respectively, to accurately axially position the mold holder sections 16, 18 with respect to the mold elements 12a, 12b, respectively.

Figs. 4-9 illustrate an assembly 40 that is made up of a mold section 42
15 contained within a section 46 of a mold holder 44. It is to be understood that the assembly 40 is annular in configuration during a molding operation with the mold section 42 joined end to end with a like mold section, not shown. Likewise, the mold holder 44 is annular in configuration during a molding operation, with the mold holder section 46 being joined end to end with a like mold holder section, also not
20 shown. In any case, the mold assembly 40 is shown as being of a type suitable for use in an I.S. machine in performing the final, or blow, molding step on a molten glass parison of the type that has previously been formed in a parison molding assembly 10, as heretofore shown and described. Because the assembly 40 is designed for use at the blow mold station of an I.S. machine, whereas the mold assembly 10 is designed
25 for use at the parison mold station of such a machine, the inside diameter of the mold section 42, often referred to as the cavity, will be substantially larger than that of the annular mold 12 of the mold assembly 10, and the wall thickness of a glass article in engagement with the mold section 42 will be substantially less than that in engagement with the annular mold 12.

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The mold section 42 is provided with a circumferentially disposed and axially extending spaced apart series of fins 42e that project outwardly from the mold section 42 to extend the outer surface of the mold section 42, and thereby increase the rate at which heat can be transferred from the glass article being blow molded in the mold assembly 40.

The heat from the glass article that has transferred to the fins 42e is positively transferred away from the fins 42e by forced air cooling, and in that regard the mold holder section 46 is provided with a generally semi-cylindrical flow passage 50 extending axially therethrough. The flow passage 50 receives cooling air through an inlet 52, and is radially open on its interior to permit cooling air to flow radially outwardly from the flow passage 50 against the fins 42e of the mold section 42. A perforated screen 56, which is generally semi-cylindrically shaped, is affixed to the interior of the mold holder section 46. The perforations in the perforated screen 56 are sized and spaced to vary the cooling air flow of distribution vertically, and circumferentially if desired, to equalize the rate of cooling of an article being molded in the mold assembly 40, notwithstanding variations in cooling load due to localized variations in the diameter or wall thickness of the glass article.

As is best shown in Figs. 8 and 9, the mold holder section 46 has less axial extent than the mold section 42. The mold section 42 is vertically centered with respect to the mold holder section 46 by providing the mold section 42 with an outwardly facing groove 42d that receives an inwardly projecting tongue 46a of the mold holder section 46, and further by providing the mold section 42 with a downwardly projecting flange 42f that seats against an uppermost surface 46b of the mold holder section 46. The mold section 42 is disengageably secured to the mold holder section 46 by a vertical series of spaced apart cap screws 66 (Fig. 8) that extend through the mold holder section 46 to be threadably received in the mold section 42.

To assist in the proper blowing of a glass article in the mold section 42 against the interior of the mold section 42, vacuum assist is provided to help draw the molten glass article against the inside surface of the mold section 42. To that end, a

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5 diametrically opposed pair of vertical vacuum slots 70 is provided in the mold section 42, and each of the vacuum slots 70 is connected to a source of vacuum, not shown, by means of a vacuum tap 68. The vacuum in the vacuum passage 70 is being imposed on the bottom of an article being molded in the mold section 42 by a circumferentially spaced apart series of generally radially extending vacuum passage extensions 70a. The vacuum slots 70 are provided with openings 72 at the bottom thereof to ensure that the air contained within each vacuum slot 70 does not become stagnant.

10 The best mode known by the inventors for carrying out the present invention as of the filing date hereof has been shown and described herein, but it will be apparent to those skilled in the art that suitable modifications, variations, and equivalents may be made without departing from the scope of the invention, such scope being limited solely by the terms of the following claims and the legal equivalents thereof.

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The embodiments of the invention in which an exclusive property or privilege is claimed are defined as follows:

1. A mold assembly for molding a hollow glass article at an elevated temperature, said mold assembly comprising:

5 an annular mold having an internal cavity, said annular mold being formed by a pair of separable mold elements, said mold elements being positioned end to end during a molding step, each of said mold elements having a plurality of axially extending fins on an external surface thereof, outer tips of each of said plurality of fins of each of said mold elements defining a curved surface;

10 an annular mold holder surrounding at least a substantial axial length portion of said annular mold, said annular mold holder being formed by a pair of separable mold holder sections, said mold holder sections being positioned substantially end to end during a molding step, each of said mold holder sections having a fluid flow passage extending generally axially therethrough, each fluid flow passage being open to permit fluid flowing therethrough to flow outwardly therefrom
15 against the fins of an adjacent mold element to assist in cooling a hollow glass article in said annular mold; and

20 of each of said plurality of fins serving to control the rate and pattern of fluid flowing from said one of said mold holder sections against the fins of said adjacent mold element.

2. A mold assembly according to Claim 1 and further comprising:
plenum means carried by said annular mold holder for delivering
cooling fluid to the fluid flow passage of each of the mold holder sections of said
annular mold holder.

25 3. A mold assembly according to Claim 1 and further comprising:
first and second pairs of connectors, the connectors of each of said pairs of connectors being secured to the opposite free ends of one of said annular mold holder sections, each of said connectors having an inwardly projecting tab;

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each of said mold elements having a pair of inwardly projecting
recesses;

the inwardly projecting tab of each pair of connectors being received in
a recess of one of said pair of mold elements to accurately circumferentially position
5 each pair of connectors and the mold holder section that is secured to it with respect to
an adjacent one of said mold elements.

4. A mold assembly according to Claim 3 wherein:
at least one of the fins carried by each of said pair of mold elements
has spaced apart upper and lower radially enlarged portions, said radially enlarged
10 portions trapping an adjacent one of said mold holder sections to accurately axially
position said each of said pair of mold elements with respect to said adjacent one of
said mold holder sections.

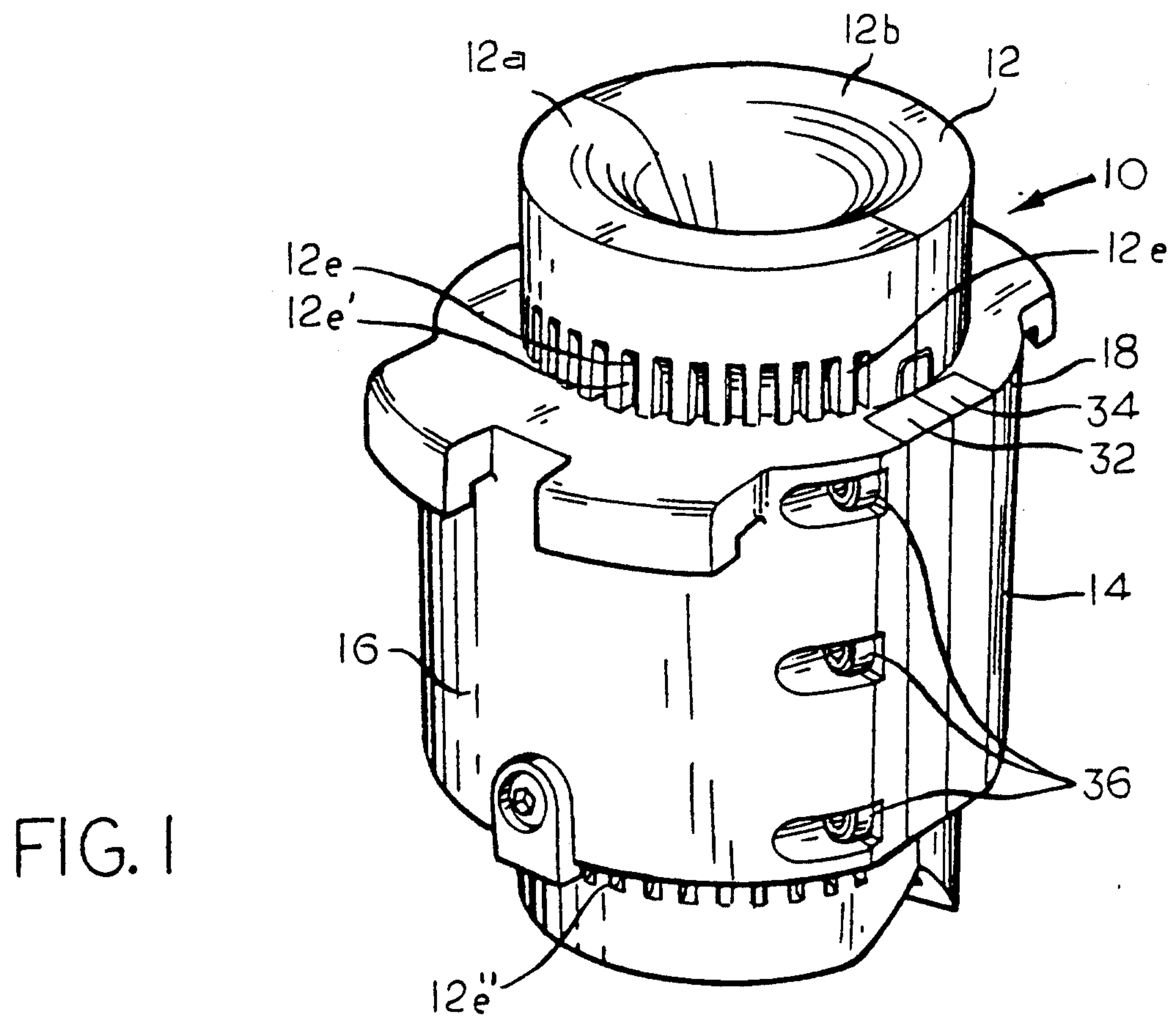
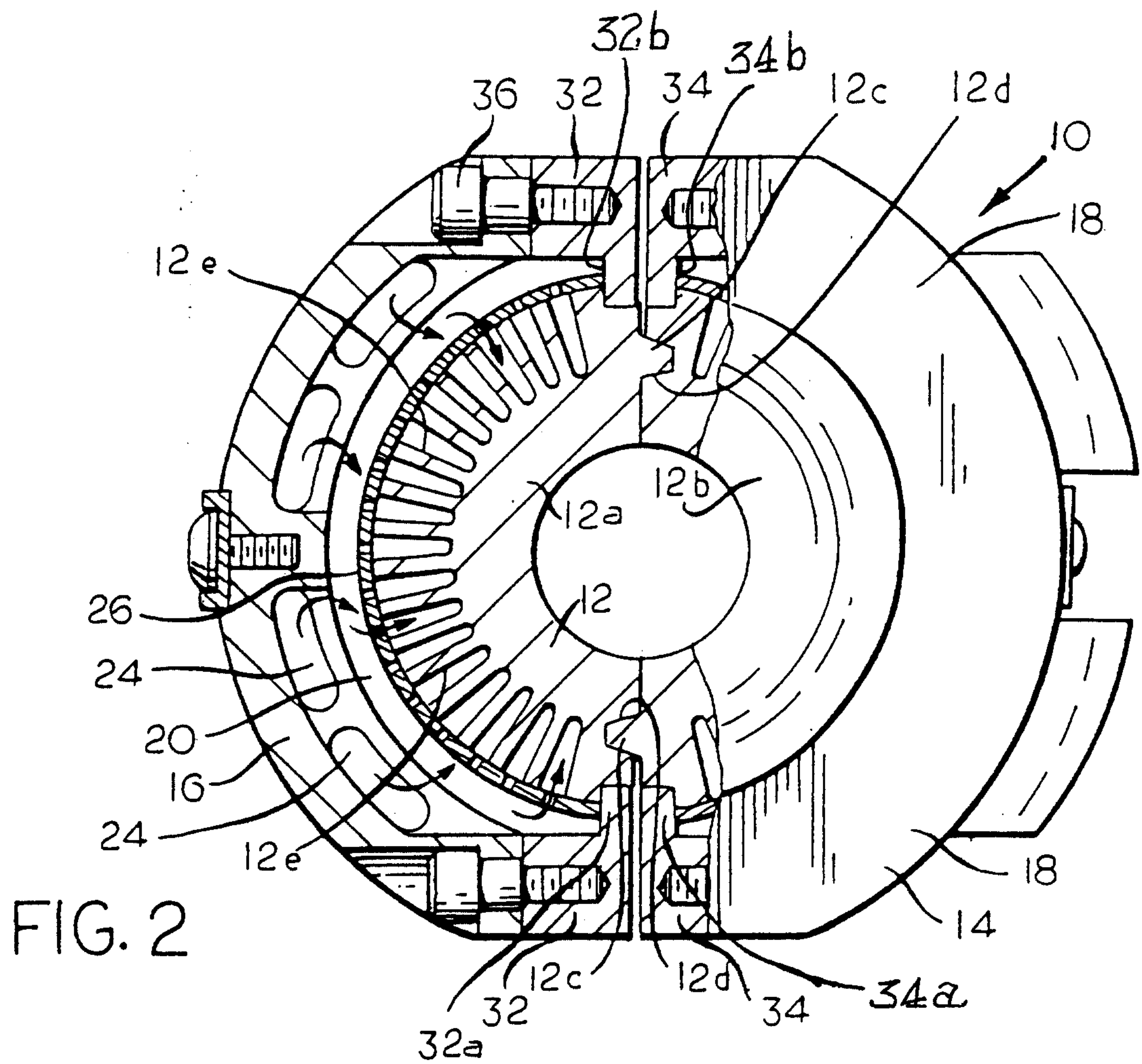
5. A mold assembly according to Claim 1 wherein:
each of the pair of separable mold elements is substantially semi-
15 cylindrical in configuration;
each of the pair of separable mold holder sections is substantially semi-
cylindrical in configuration; and
the fluid flow passage in each mold holder section is substantially
semi-cylindrical in shape.

20 6. A mold assembly according to claim 1 and further comprising:
threaded fastener means extending through each of said mold holder
sections, said fastener means being threadably received in an adjacent one of said
mold sections to the mold holder section through which said fastener means extends.

25 7. A mold assembly according to Claim 6 wherein one of said mold
holder sections and said mold sections has a groove that faces toward an adjacent one
of the other of said mold holder sections and said mold sections, and wherein the
other of said mold holder sections and said mold sections has a tongue that extends
toward an adjacent one of said mold holder sections and said mold sections, said
tongue being received in said groove to accurately axially position said one of said

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mold holder sections and said adjacent one of said mold sections with respect to one another.



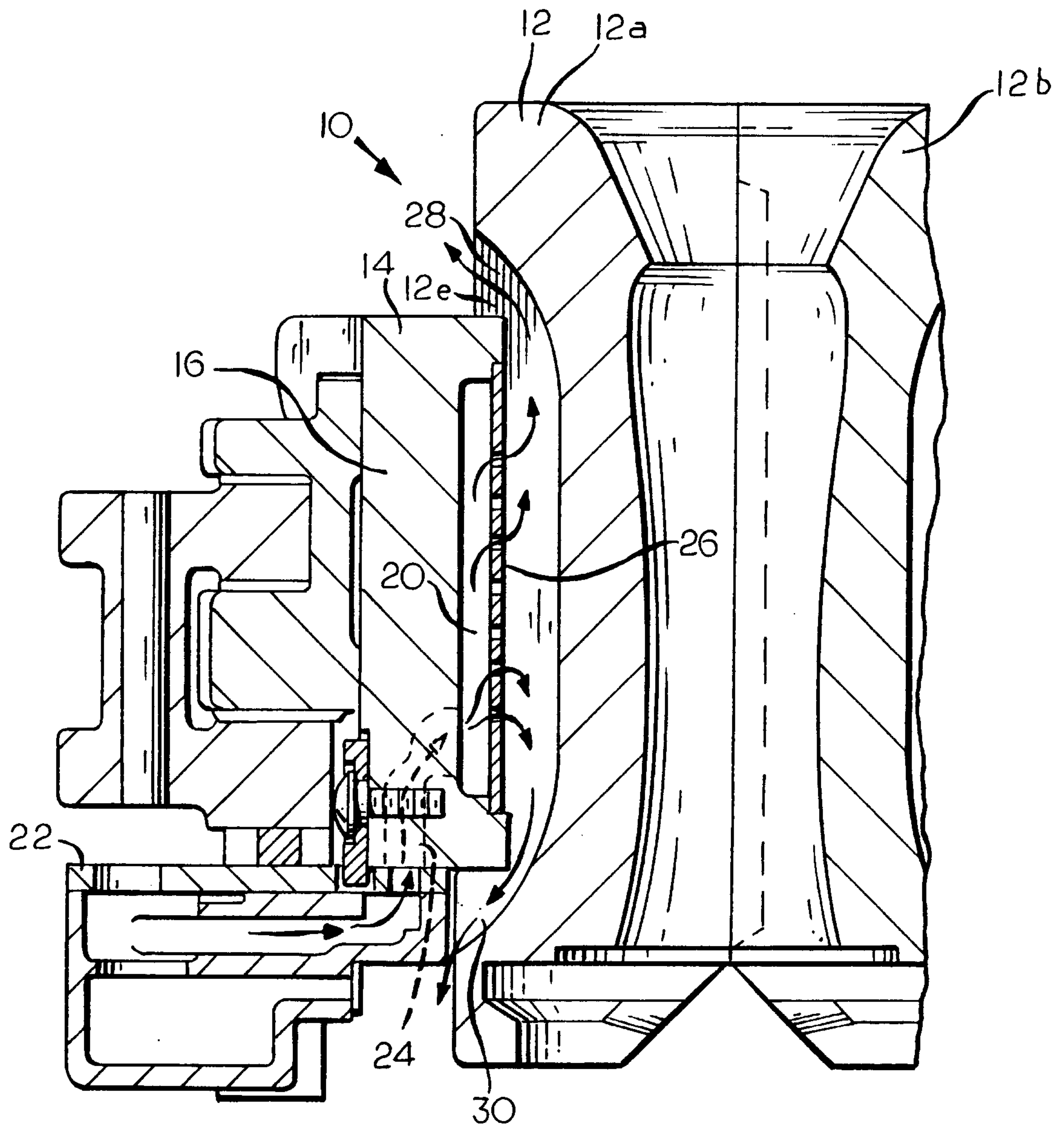


FIG. 3

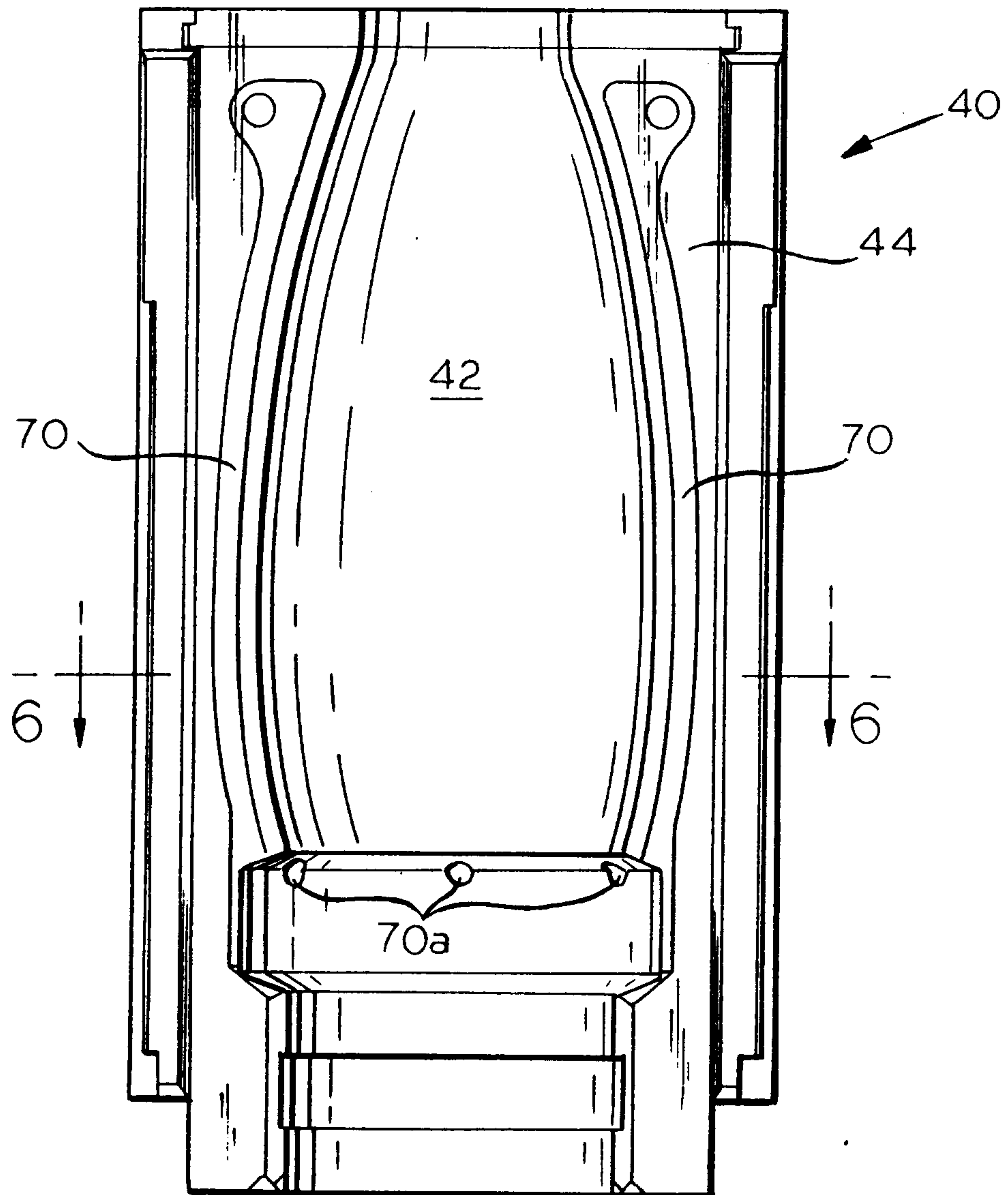


FIG. 4

FIG. 5

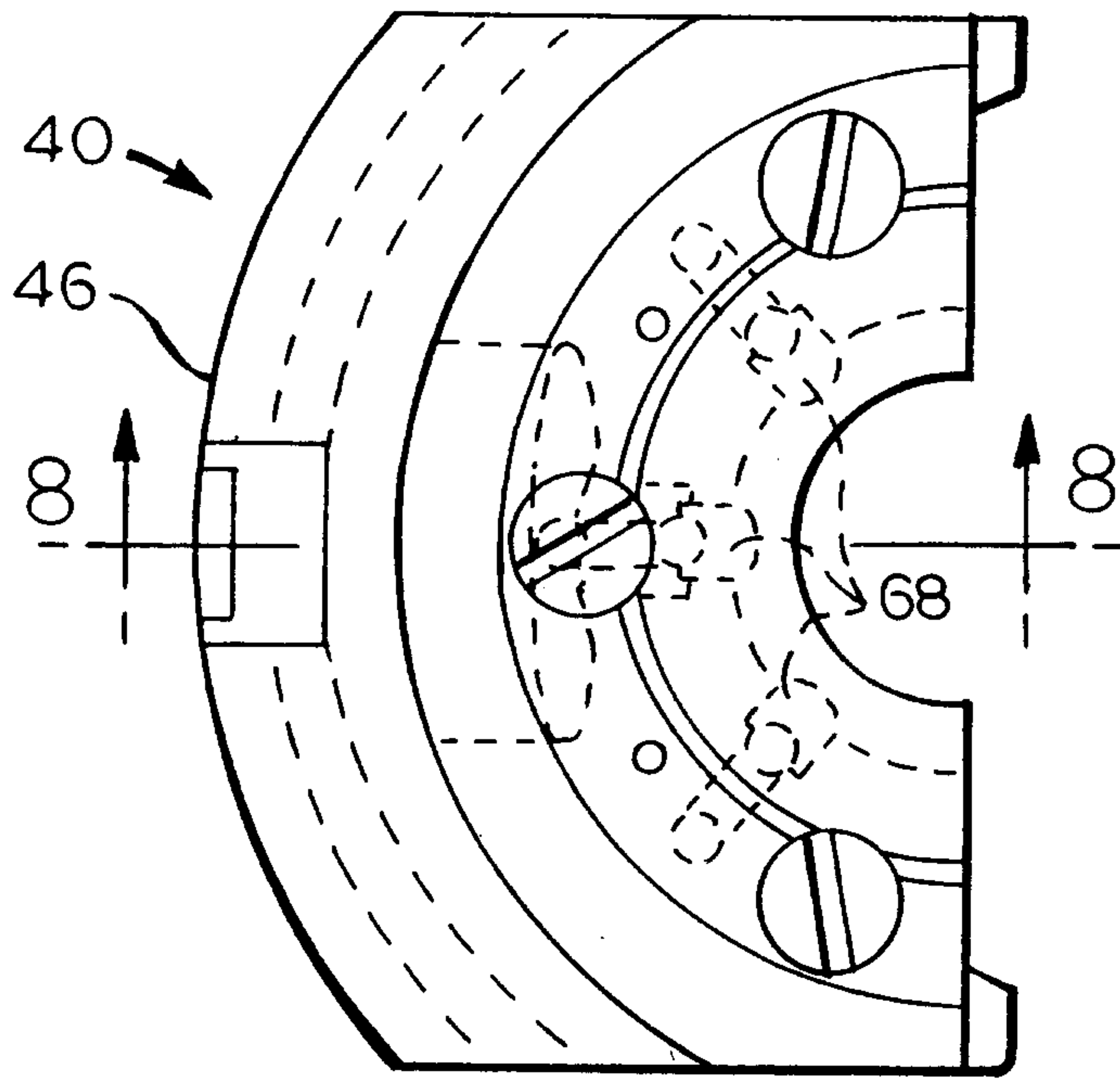


FIG. 6

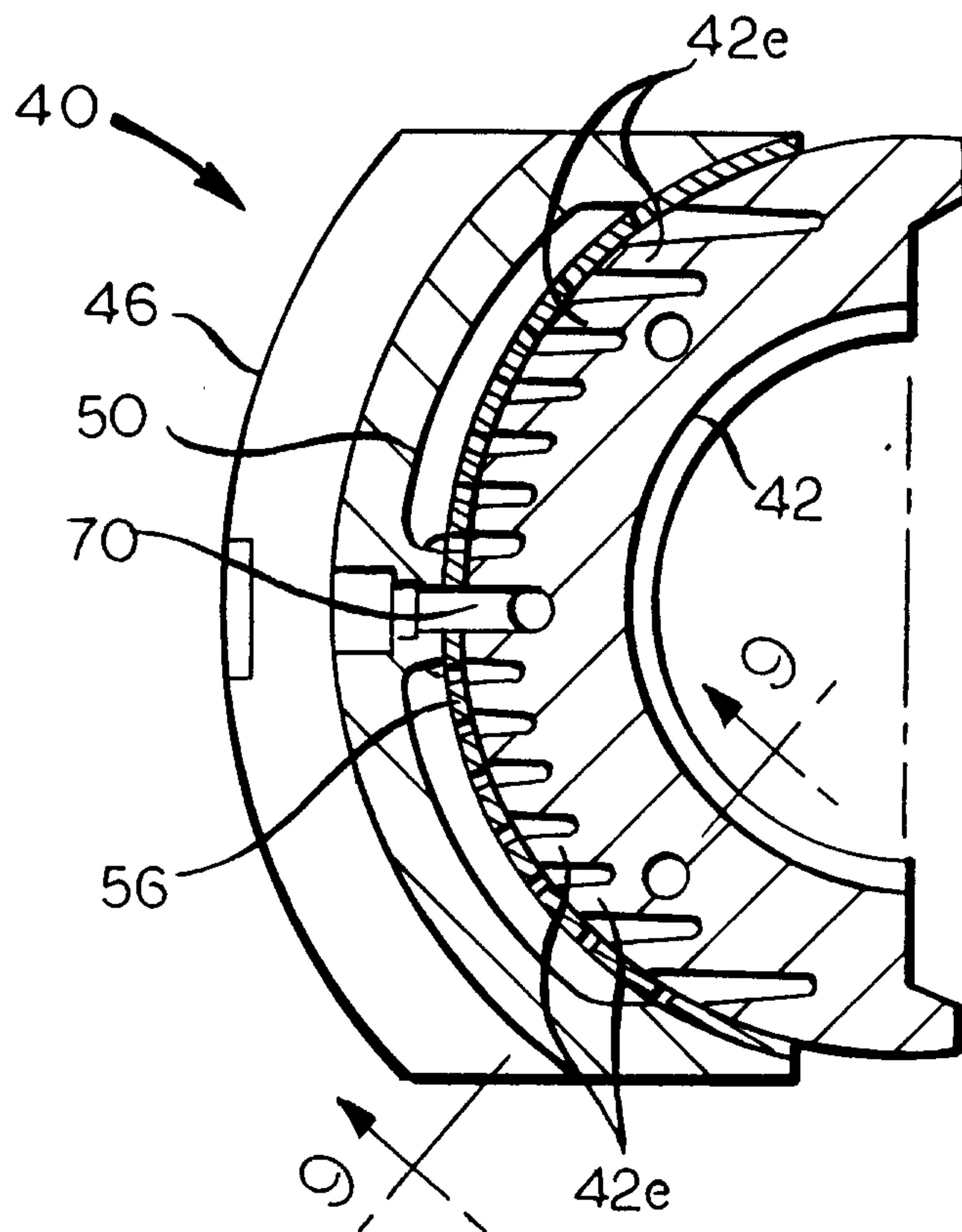


FIG. 8

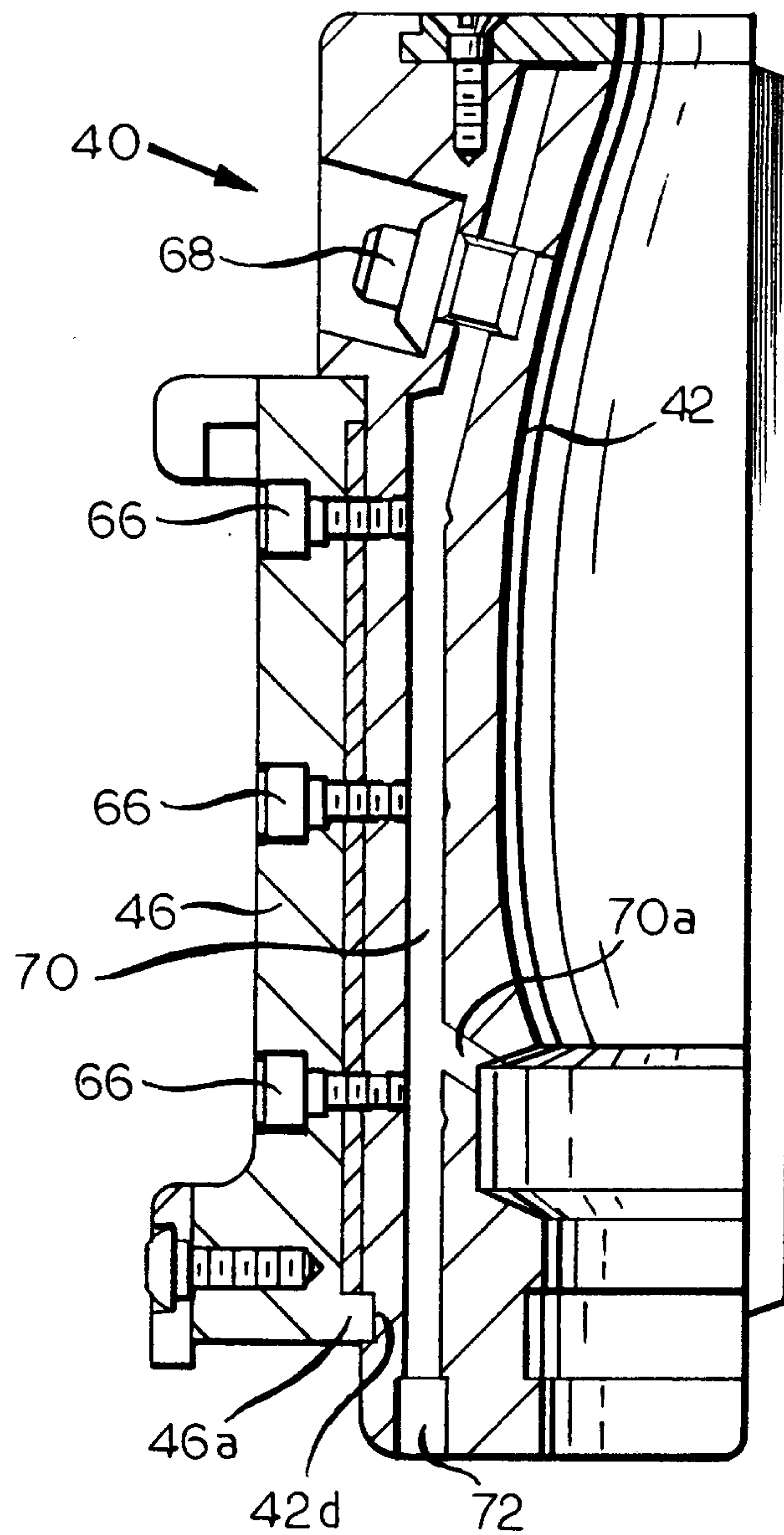
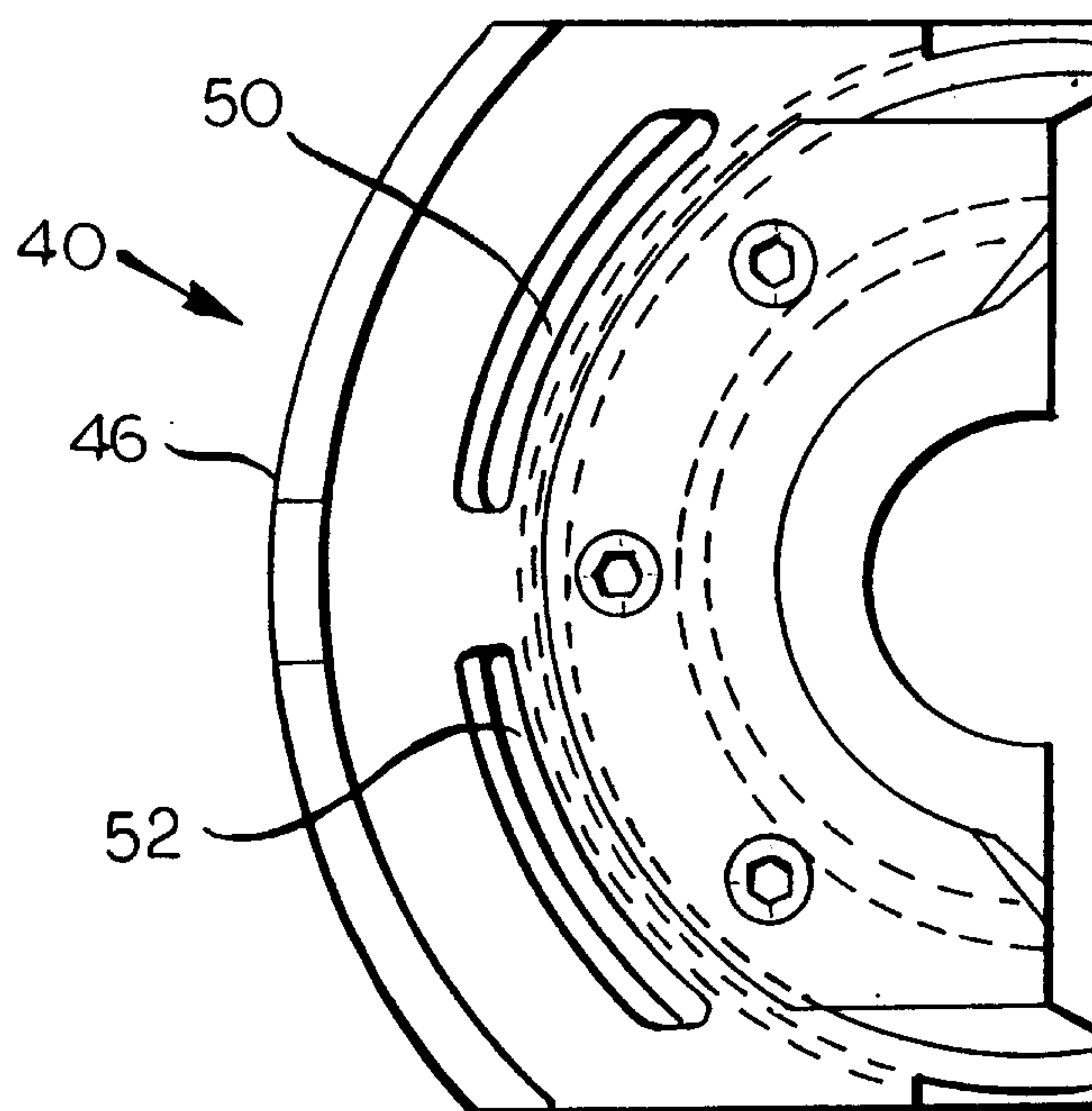


FIG. 7



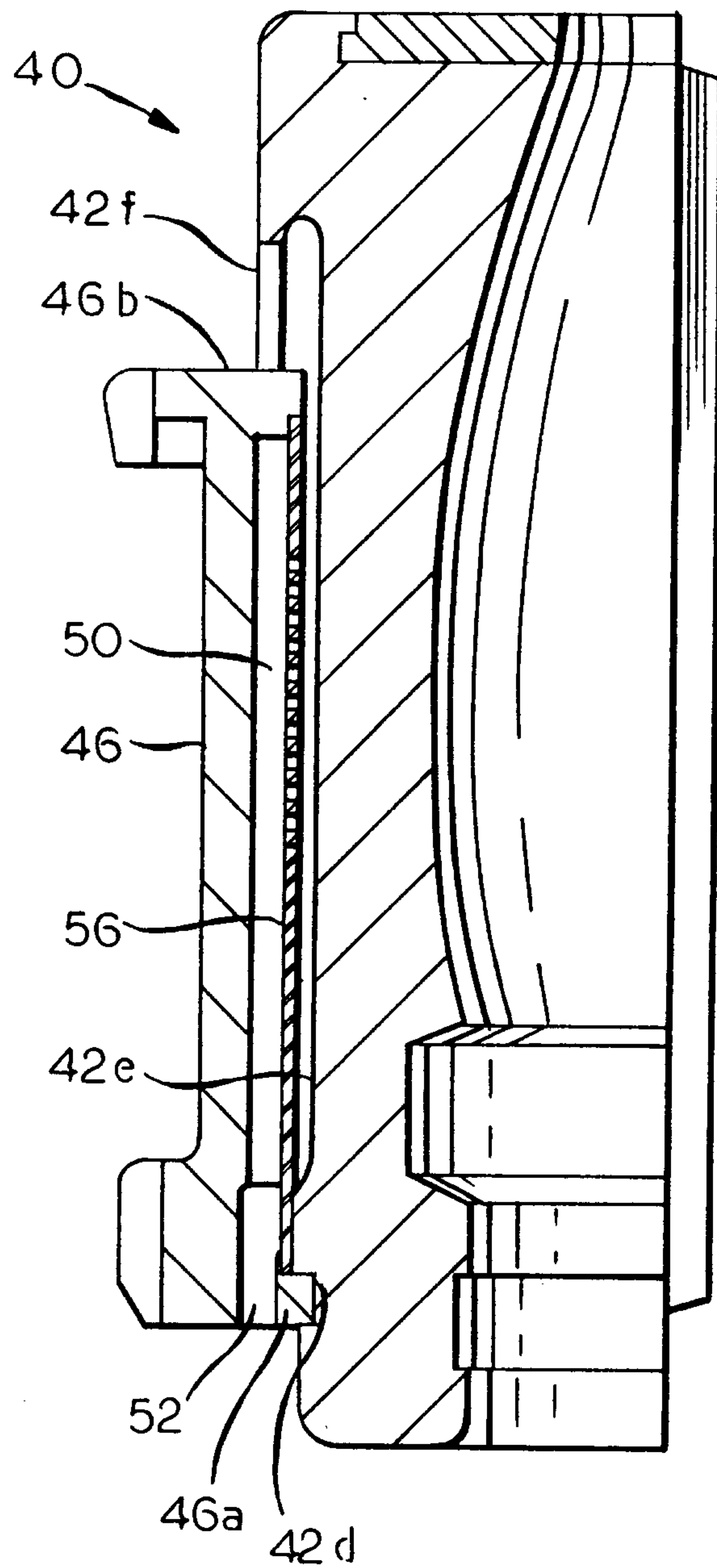


FIG. 9

