

Method for manufacturing plastic preforms (10) by injection moulding, consisting of sub-preforms (11, 12) injected at the same time, wherein ($\Phi 1$) the injection mould (3) containing the injected composite preform (10) and secondary sub-preform (12) is 1st closed, and a gripper (4) provided with a set of receiving members (16) is set in a standby position (A) aside from the mould (3); in a 2nd step ($\Phi 2$) the mould (3) is opened, wherein each primary core (33) bears an injected composite preform (10), and the secondary core (33') a secondary inner preform (12); the gripper (4) is then driven ($\Phi 3$) in motion between the standby position (A) and a take-over position (D), wherein the injected preforms (10, 12) are cooled and taken over from the core side (31) by the gripper (4) by means of suction means (6); wherein the gripper (4) is further moved ($\Phi 4$) into a further operating position (C), in which it places the received secondary inner preforms (12) onto the respective primary cores (33) and continues to hold said preforms (11), with formation of integrated preforms (10) which are expelled to a discharge unit.