



INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(51) International Patent Classification ⁶ :
B21F 27/00, C21D 9/02, B21F 35/00

A1

(11) International Publication Number: WO 98/53933

(43) International Publication Date: 3 December 1998 (03.12.98)

(21) International Application Number: PCT/US98/11355

(22) International Filing Date: 29 May 1998 (29.05.98)

(30) Priority Data:
08/868,120 30 May 1997 (30.05.97) US

(71) Applicant: SIMMONS COMPANY [US/US]; Suite 600, One Concourse Parkway, Atlanta, GA 30328 (US).

(72) Inventors: MAULDIN, Michael, W.; 340 Main Street, Hiram, GA 30141 (US). KUCHEL, Bernard, W.; 2470 Bermuda Road, Stone Mountain, GA 30087 (US).

(74) Agents: RADEN, James, B. et al.; Jones, Day, Reavis & Pogue, 77 West Wacker Drive, Chicago, IL 60601-1692 (US).

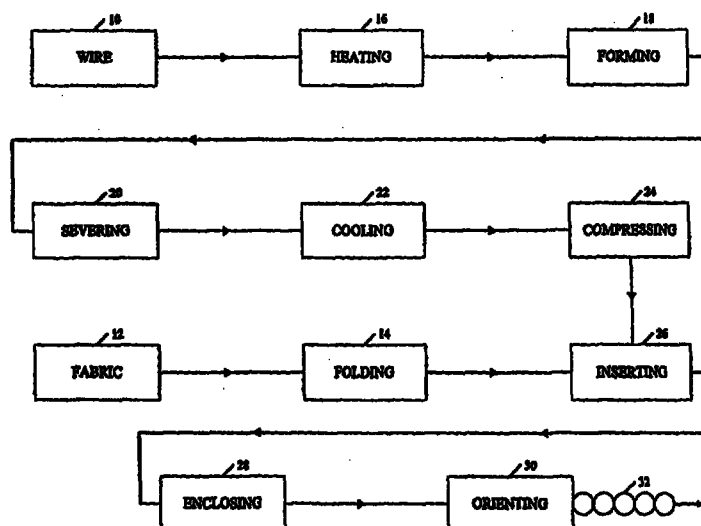
(81) Designated States: AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, CA, CH, CN, CU, CZ, DE, DK, EE, ES, FI, GB, GE, GH, GM, GW, HU, ID, IL, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MD, MG, MK, MN, MW, MX, NO, NZ, PL, PT, RO, RU, SD, SE, SG, SI, SK, SL, TJ, TM, TR, TT, UA, UG, UZ, VN, YU, ZW, ARIPO patent (GH, GM, KE, LS, MW, SD, SZ, UG, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, ML, MR, NE, SN, TD, TG).

Published

With international search report.

Before the expiration of the time limit for amending the claims and to be republished in the event of the receipt of amendments.

(54) Title: METHOD AND APPARATUS FOR MANUFACTURING COIL SPRINGS



(57) Abstract

A method and apparatus for forming a length of connected, pocketed coil springs to be used in mattresses and the like where wire (10) from a supply source is heated (16) to between 450 and 500 degrees Fahrenheit by an induction heater before the wire is coiled. Thereafter, the wire is hot coiled (18), severed (20) and cooled (22) below a temperature where a permanent set might occur from further processing of the spring. Thereafter, the spring is compressed (24) in preparation for its insertion (26) into a space provided by stretchable fabric from a supply reel. The fabric (12) is folded (14) on itself to provide the space. The temperature of the spring must also be sufficiently low to contact the fabric without causing burns or other damage. After insertion of a compressed spring into the space, the fabric is ultrasonically welded (28) to create individual but connected pockets for each spring. Thereafter, the springs are oriented (30) to allow each spring to expand thereby creating the length of connected, pocketed coil springs.