

Description

The present invention relates to an apparatus for manufacturing a heat-shrinkable resin tube by expansion while limiting the expansion in the longitudinal direction to a minimum.

The apparatus for producing a heat-shrinkable tube is roughly classified into a batch type and a continuous type. Since batch type ones are poor in efficiency and yield, continuous type ones are more widely used nowadays. On the latter type, resin tube is continuously formed by expansion into a heat-shrinkable tube while being fed.

As disclosed in U.S. Patent 3370112, Japanese Patent Publication 55-6045 and Japanese Unexamined Patent Publication 60-187531, a prior art continuous type apparatus comprises a heating tank or pipe for heating a resin tube to a temperature above the softening point, a pressure reduction tank or a sizing die for expanding the heated tube until it touches the inner wall of a molding pipe or die. The expanded tube is cooled and kept as it is.

With such a prior art apparatus, a resin tube tends to expand considerably in the longitudinal direction by the friction with the die. The tube thus expanded will shrink in the longitudinal direction when heated thereafter. This will lower its commercial value.

The higher the feed rate of the tube, the larger the expansion of the tube in the longitudinal direction will be. Thus, the feed rate was limited to a low speed about within 2 - 10 m/min. This will result in poor working efficiency.

Japanese Unexamined Patent Publication 60-187531 discloses an apparatus having a molding die made of a porous material through which a refrigerant is supplied to a tube expanded by heating. With this arrangement, the tube can be cooled effectively and the friction between the tube and the die is reduced. But the abovesaid problem is not fully solved.

An apparatus as described in the preamble portion of claim 1 is known from DE-A-3310614. At a distance ahead of the die a lubricating unit supplies a lubricating fluid to the periphery of the tube, and a film of the lubricating fluid is formed on the tube and carried with the tube through the die and is separated and collected at the outlet end of the die. The tank surrounding the die is filled with a cooling fluid which cools the die without having direct contact with the tube. The efficiency of the cooling is not optimum.

It is an object of the invention to provide an apparatus as defined in the preamble of claim 1 which provides a very efficient combined cooling and lubricating of the tube during expansion.

The object is solved by an apparatus as defined in claim 1. The dependent claims relate to

further features of preferred embodiments of the invention.

The cooling fluid supplied from the pre-cooling unit or from both the pre-cooling unit and the jacket serves to lubricate the contact surface between the die and the resin tube while flowing therebetween. Thus, the resin tube can pass through the die with a substantially decreased frictional resistance which will otherwise cause the tube to be expanded in the longitudinal direction.

Since the bore in the die is in communication through the holes in the wall of the die with the tank in the pressure reducing/cooling unit kept under reduced pressure, the resin tube is put under reduced pressure so as to be sucked to expand. The cooling fluid also serves as a seal to keep the interior of the tank under vacuum. This will allow the tube to be expanded more stably. Also, since a larger suction force can be applied to the tube, the working efficiency will be improved.

The cooling fluid supplied to the tube before it is introduced into the die will be replaced with the cooling fluid in the tank while passing through the die, thus allowing the tube to be cooled effectively while subjected to expansion.

A resin tube has heretofore been cooled not before expansion but after expansion because it has been believed that cooling the tube before expansion would cause such problems as insufficient expansion or uneven wall thickness of the tube. According to the present invention, the feed rate of the cooling fluid from the pre-cooling unit is controlled with the heat transfer rate of the tube taken into consideration, so that the tube will be kept at a temperature above its softening point before expansion and will be cooled gradually while being subjected to expansion to a temperature below the softening point by the end of the expansion step. This will prevent insufficient expansion or an uneven wall thickness of the tube.

The cooling fluid in the jacket, which is distributed through the holes in the wall of the die into its bore, also serves to enhance the tube cooling effect. This arrangement is especially effective when expanding a large-diameter tube at a high speed.

The cooling fluid in the tank of the pressure reducing/cooling unit might experience a gradual rise in temperature if the apparatus is operated continuously for long hours at a high speed. To prevent this, the cooling fluid may be fed into the tank forcibly from any other source than the pre-cooling unit or the jacket.

The apparatus according to the present invention can produce at a high speed a high-quality heat-shrinkable tube while keeping the expansion in the longitudinal direction to a minimum. This will be apparent from the results of the experiments shown

below.

The working efficiency will be improved further if the internal pressure of the tube is increased while the tube is being expanded. This means that the tube may be expanded not only by a suction force but also by increasing the internal pressure of the tube.

With a prior art apparatus of this type, a large-diameter tube could not be fed at a speed of more than several meters per minute because of a large friction with the die due to a large surface area of the tube and because of a low cooling rate. According to the present invention, a cooling fluid is supplied to the tube at the intermediate portion of the die to improve the cooling effect as well as lubricating effect. Thus a large-diameter tube can be fed at a considerably high speed.

As a result, the tube production cost is reduced to a minimum. Further, it is not necessary to allow for longitudinal shrinkage of the tube when reheating. This will improve the working efficiency to a great degree and allow the tube to be produced less expensively.

Other features and objects of the present invention will become apparent from the following description taken with reference to the accompanying drawings, in which:

Fig. 1 is a sectional view of the first embodiment of the present invention, and

Fig. 2 is a similar view of the second embodiment.

Now referring to Fig. 1, an apparatus according to the present invention comprises a heating tank 1 containing a heater 2 and a heating medium 3 where a resin tube A is heated to a temperature above the softening point, supply rollers 4 for the resin tube A, take-up rollers 5 for a heat-shrinkable tube A' made from the tube A, and an expansion molding unit 6 which characterises the present invention. The molding unit 6 comprises a pre-cooling unit 7, a die 8 and a pressure reducing/cooling unit 9.

The pre-cooling unit 7 is provided at the inlet side of the die 8 and is in the form of an annular chamber adapted to surround the resin tube A. It is provided with an inlet port 7a through which a cooling fluid 10 is supplied continuously into the chamber. The cooling fluid in the chamber is adapted to be discharged against the outer periphery of the resin tube A through radial holes 7b formed in the inner periphery of the annular chamber.

The die 8 has a center bore 8a through which the resin tube A passes and is formed with a plurality of radial through holes 8b extending from the bore 8a to the outer periphery of the die 8. The bore 8a has its outlet side 8c open to the inside of a pressure reduction tank 11. The through holes 8b

should have a small diameter and be formed uniformly over the entire circumference of the die 8 so as to apply a suction force to the resin tube A uniformly over its entire circumference.

The pressure reducing/cooling unit 9 comprises the pressure reduction tank 11 surrounding the die 8 and containing a cooling fluid 10. The tank 11 has a vacuum port 11a through which a vacuum is normally applied to the interior of the tank 11. Thereby, the liquid 10, which has absorbed the heat of the resin tube, is discharged out of the tank through a liquid outlet 11b. If the temperature of the cooling fluid 10 rises, a fresh liquid has to be fed into the tank through a supply port 11c. The cooling fluid discharged from the port 11b is cooled in a refrigerator (not shown) and returned into the tank 11 and the pre-cooling unit 7.

As shown in Fig. 2, a jacket 12 may be mounted around the intermediate portion of the die 8 to supply the cooling fluid 10 continuously toward the tube A through its supply port 12a. The cooling fluid in the jacket 12 is then discharged into the bore 8a through some of the holes 8b formed in the die 8. The cooling fluid 10 should be fed into the jacket 12 by means of e.g. a pump. The cooling rate of the tube can be controlled by adjusting the feed rate of the cooling fluid.

We made tubes by use of the apparatus according to the present invention. The experiment results are shown below.

[EXPERIMENT 1]

A tube used in this experiment is 1 mm in the inner diameter and 0.45-0.5 mm in wall thickness and made of polyethylene crosslinked by electron radiation.

The heating tank 1 was filled with ethylene glycol solution. The liquid was heated by a heater 2 to 150 - 160° C.

Pressurized air was introduced into the resin tube A from one end thereof with the other end sealed until the internal pressure reached 0.4-0.5 kg/cm². This resin tube A was passed through the heating tank 1 to heat it and then introduced from its leading end into the pre-cooling unit 7 and the die 8. The cooling fluid 10 at 0° C was supplied from the pre-cooling unit 7 through the holes 7b at the rate of 480 cc/min. The power of a vacuum pump was set so that the degree of vacuum in the tank 11 will be 650 - 700 mmHg. As the cooling fluid 10, an antifreezing mixture of water and ethylene glycol was used.

The resin tube A was fed into the apparatus at the rate of 55 meters per minute by the rollers 4. The tube A' thus expanded was drawn out at the rate of 50 meters per minute by the rollers 5.

The resulting heat-shrinkable tube A' was 3 mm in the inner diameter and 0.2 - 0.3 mm in the wall thickness. When the tube A' was subjected to heat shrinkage by heating it to 125 C, its inner diameter and wall thickness changed to 1.2 mm and 0.5 - 0.55 mm, respectively. But its length changed scarcely after heating. Namely, the length after heating was 99 - 100 mm with respect to 100 mm before heating.

[EXPERIMENT 2]

A tube used in this experiment is 9 mm in the inner diameter and 0.75 - 0.8 mm in the wall thickness and made of polyethylene crosslinked by electron radiation. The heating tank 1 was filled with glycerine solution, which was heated to 150 - 160 C by the heater 2.

Pressurized air was introduced into the tube A in the same manner as in EXPERIMENT 1 until its internal pressure rised to 0.01 kg/cm². The tube was heated in the heating tank 1 and then fed into and drawn out of the pre-cooling unit 7 and the die 8 from its leading end.

From the pre-cooling unit 7, an antifreezing mixture of water and glycerine, was supplied at the rate of 150 cc per minute. The degree of vacuum in the tank 11 was adjusted to 400 - 450 mmHg.

The resin tube A was fed into the apparatus at the rate of 21 meters per minute by the rollers 4. The tube A' thus expanded was drawn out at the rate of 20 meters per minute.

The resulting heat-shrinkable tube A' was 21 mm in the inner diameter and 0.35 - 0.45 mm in the wall thickness. When the tube A' was subjected to heat shrinkage by heating it to 125 C, its inner diameter and wall thickness changed to 9.1 mm and 0.8 - 0.9 mm, respectively. But its length changed scarcely after heating. Namely, the tendency of the tube to be stretched lengthwise during expansion is kept very small as with the tube made in EXPERIMENT 1.

[EXPERIMENT 3]

A tube used in this experiment is made of polyolefin crosslinked by electron radiation and has an inner diameter of 11.3 mm and a wall thickness of 0.9 - 0.95 mm.

The heating tank 1 of the apparatus shown in Fig. 2 was filled with ethylene glycol solution which was heated to 150 - 160 C by the heater 2.

Pressurized air was injected into the tube from one end thereof with the other end sealed until its internal pressure rised to 0.01 - 0.02 kg./cm². The tube was passed through the heating tank 1 to heat it. Then it was introduced from its leading end into the pre-cooling unit 7 and the die 8. The cooling

fluid kept at 0°C was supplied from the pre-cooling unit 7 at the rate of 500 cc/min. The cooling fluid 10 kept at 0°C was also supplied into the jacket 12 at the rate of 2000 cc/min. The power of the vacuum pump was set so that the degree of vacuum in the tank 11 will be 650 - 700 mmHg. As the cooling fluid, a mixture of water and ethylene glycol was used.

The resin tube A was fed into the apparatus at the rate of 21.9 meters per minute. The tube A' thus expanded was drawn out of it at the rate of 20 meters per minute.

The resulting heat-shrinkable tube A' was 26.7 mm in the inner diameter and 0.37 - 0.50 mm in the wall thickness. Then the tube A' was subjected to heat shrinkage by heating it to 125 C. The tube thus made was 11.5 mm in the inner diameter and 0.9 - 1.0 mm in the wall thickness. Its length after heating was 99 - 100 mm with respect to a unit length before heating of 100 mm. This means that the tube scarcely underwent a change of length by heating.

Claims

1. An apparatus for manufacturing a heat-shrinkable resin tube (A'), comprising a heating means (1,2,3) for heating the resin tube (A) to a temperature above its softening point; means for supplying a fluid to the outer periphery of said resin tube (A) heated by said heating means; a pressure reducing/cooling means (9) having a tank (11) filled with a cooling fluid (10); and a die (8) mounted in said tank (11) and immersed in said cooling fluid (10); said die (8) having a center bore (8a) through which said resin tube (A) fed from said pre-cooling means passes and a plurality of radial holes (8b) extending from said center bore (8a) of said die and being kept under reduced pressure, whereby continuously expanding said resin tube (A) with a suction force applied thereto and forming it with said die (8) while passing it through said center bore (8a) of said die (8) kept under reduced pressure and cooling it by the action of the cooling fluid, characterized in that said means for supplying a fluid is a pre-cooling means (7) arranged at the inlet end of the die (8) and having means for discharging cooling fluid against the outer periphery of the resin tube (A), and said radial holes (8b) extend from the center bore (8a) to the outer periphery of the die (8) into said tank (11) filled with cooling fluid which is kept under reduced pressure, whereby the cooling fluid from said pre-cooling means (7) flows between the die (8) and the resin tube (A) into the center bore (8a) of the die (8) and through the

The resulting heat-shrinkable tube A' was 3 mm in the inner diameter and 0.2 - 0.3 mm in the wall thickness. When the tube A' was subjected to heat shrinkage by heating it to 125 C, its inner diameter and wall thickness changed to 1.2 mm and 0.5 - 0.55 mm, respectively. But its length changed scarcely after heating. Namely, the length after heating was 99 - 100 mm with respect to 100 mm before heating.

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Pressurized air was introduced into the tube A in the same manner as in EXPERIMENT 1 until its internal pressure rised to 0.01 kg/cm². The tube was heated in the heating tank 1 and then fed into and drawn out of the pre-cooling unit 7 and the die 8 from its leading end.

From the pre-cooling unit 7, an antifreezing mixture of water and glycerine, was supplied at the rate of 150 cc per minute. The degree of vacuum in the tank 11 was adjusted to 400 - 450 mmHg.

The resin tube A was fed into the apparatus at the rate of 21 meters per minute by the rollers 4. The tube A' thus expanded was drawn out at the rate of 20 meters per minute.

The resulting heat-shrinkable tube A' was 21 mm in the inner diameter and 0.35 - 0.45 mm in the wall thickness. When the tube A' was subjected to heat shrinkage by heating it to 125 C, its inner diameter and wall thickness changed to 9.1 mm and 0.8 - 0.9 mm, respectively. But its length changed scarcely after heating. Namely, the tendency of the tube to be stretched lengthwise during expansion is kept very small as with the tube made in EXPERIMENT 1.

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A tube used in this experiment is made of polyolefin crosslinked by electron radiation and has an inner diameter of 11.3 mm and a wall thickness of 0.9 - 0.95 mm.

The heating tank 1 of the apparatus shown in Fig. 2 was filled with ethylene glycol solution which was heated to 150 - 160 C by the heater 2.

Pressurized air was injected into the tube from one end thereof with the other end sealed until its internal pressure rised to 0.01 - 0.02 kg/cm². The tube was passed through the heating tank 1 to heat it. Then it was introduced from its leading end into the pre-cooling unit 7 and the die 8. The cooling

fluid kept at 0°C was supplied from the pre-cooling unit 7 at the rate of 500 cc/min. The cooling fluid 10 kept at 0°C was also supplied into the jacket 12 at the rate of 2000 cc/min. The power of the vacuum pump was set so that the degree of vacuum in the tank 11 will be 650 - 700 mmHg. As the cooling fluid, a mixture of water and ethylene glycol was used.

The resin tube A was fed into the apparatus at the rate of 21.9 meters per minute. The tube A' thus expanded was drawn out of it at the rate of 20 meters per minute.

The resulting heat-shrinkable tube A' was 26.7 mm in the inner diameter and 0.37 - 0.50 mm in the wall thickness. Then the tube A' was subjected to heat shrinkage by heating it to 125 C. The tube thus made was 11.5 mm in the inner diameter and 0.9 - 1.0 mm in the wall thickness. Its length after heating was 99 - 100 mm with respect to a unit length before heating of 100 mm. This means that the tube scarcely underwent a change of length by heating.

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1. An apparatus for manufacturing a heat-shrinkable resin tube (A'), comprising a heating means (1,2,3) for heating the resin tube (A) to a temperature above its softening point; means for supplying a fluid to the outer periphery of said resin tube (A) heated by said heating means; a pressure reducing/cooling means (9) having a tank (11) filled with a cooling fluid (10); and a die (8) mounted in said tank (11) and immersed in said cooling fluid (10); said die (8) having a center bore (8a) through which said resin tube (A) fed from said pre-cooling means passes and a plurality of radial holes (8b) extending from said center bore (8a) of said die and being kept under reduced pressure, whereby continuously expanding said resin tube (A) with a suction force applied thereto and forming it with said die (8) while passing it through said center bore (8a) of said die (8) kept under reduced pressure and cooling it by the action of the cooling fluid, characterized in that said means for supplying a fluid is a pre-cooling means (7) arranged at the inlet end of the die (8) and having means for discharging cooling fluid against the outer periphery of the resin tube (A), and said radial holes (8b) extend from the center bore (8a) to the outer periphery of the die (8) into said tank (11) filled with cooling fluid which is kept under reduced pressure, whereby the cooling fluid from said pre-cooling means (7) flows between the die (8) and the resin tube (A) into the center bore (8a) of the die (8) and through the



radial holes (8b) into the tank (11).

2. An apparatus as claimed in claim 1, further comprising means for applying a pressure inside the resin tube (A).
3. An apparatus as claimed in claim 1, further comprising a jacket (12) mounted around the outer periphery of said die (8) to cover at least one of said radial holes (8b) and means (12a) for supplying additional cooling fluid from outside of said tank (11) through said jacket (12) and, said radial holes (8b) into the center bore (8a) of the die and from there into said tank (11).

Patentansprüche

1. Vorrichtung zur Herstellung eines wärmschrumpfenden Kunststoffschlauches (A') mit Heizmitteln (1, 2, 3) zum Erhitzen des Kunststoffschlauches (A) auf eine Temperatur über seinem Erweichungspunkt; Mittel zum Zuführen einer Flüssigkeit zum Außenumfang des von den Heizmitteln erhitzten Kunststoffschlauches (A); eine Druckerniedrigungs/Kühleinrichtung (9) mit einem mit Kühlflüssigkeit (10) gefüllten Tank (11); und einer in dem Tank (11) angeordneten und in die Kühlflüssigkeit (10) eingetauchten Matrize (8), die eine Mittelbohrung (8a), durch die der von einer Vorkühleinrichtung zugeführte Kunststoffschlauch (8) hindurchtritt, und eine Vielzahl von Radiallöchern (8b) aufweist, die von der Mittelbohrung (8a) der Matrize ausgehen und unter erniedrigtem Druck gehalten sind, wodurch der Kunststoffschlauch (8) bei seinem Durchgang durch die Mittelbohrung (8a) der unter reduziertem Druck gehaltenen Matrize (8) kontinuierlich durch eine auf ihn ausgeübte Saugkraft aufgeweitet und in der Matrize (8) geformt wird und durch die Wirkung der Kühlflüssigkeit gekühlt wird, dadurch gekennzeichnet, daß die Mittel zum Zuführen einer Flüssigkeit aus einer Vorkühleinrichtung (7) bestehen, die am Eingangsende der Matrize (8) angeordnet ist und Mittel zum Aufbringen von Kühlflüssigkeit gegen den Außenumfang des Kunststoffschlauches (8) aufweist, und daß sich die radialen Löcher (8b) von der Mittelbohrung (8) zum Außenumfang der Matrize (8) in den mit unter reduziertem Druck gehaltener Kühlflüssigkeit gefüllten Tank (11) erstrecken, wodurch die Kühlflüssigkeit von der Vorkühleinrichtung (7) zwischen der Matrize (8) und dem Kunststoffschlauch (A) in die Mittelbohrung (8a) der Matrize (8) und durch die radialen Löcher (8b) in den Tank

(11) fließt.

2. Vorrichtung nach Anspruch 1, die ferner Mittel zum Aufbringen eines Drucks innerhalb des Kunststoffschlauches (A) aufweist.
3. Vorrichtung nach Anspruch 1, die ferner einen Kühlmantel (12) aufweist, der derart um den Außenumfang der Matrize (8) angeordnet ist, daß er mindestens eines der Radiallöcher (8b) überdeckt, und Mittel (12a) zum Zuführen von zusätzlicher Kühlflüssigkeit von außerhalb des Tankes (11) durch den Kühlmantel (12) und die radialen Löcher (8b) in die Mittelbohrung (8a) der Matrize und von dort in den Tank (11).

Revendications

1. Dispositif pour la fabrication d'un tube thermocontractable en matière plastique (A'), comprenant des moyens de chauffage (1,2,3) pour chauffer le tube de résine (A) à une température supérieure à son point de ramollissement ; des moyens de distribution d'un fluide sur la périphérie extérieure dudit tube de matière plastique (A) chauffé par lesdits moyens de chauffage ; des moyens de réduction de pression/refroidissement (9) comportant une cuve (11) remplie avec un fluide de refroidissement (10) ; et une filière (8) montée dans la dite cuve (11) et immergée dans ledit fluide de refroidissement (10) ; ladite filière (8) ayant un alésage central (8a), dans lequel passe ledit tube de matière plastique (A) venant desdits moyens de prérefroidissement, et une pluralité de trous radiaux (8b) qui partent dudit alésage central (8a) de ladite filière et sont maintenus sous pression réduite, de manière à dilater de façon continue ledit tube de matière plastique (A) par application d'une force de succion à l'extérieur du tube, à former le tube avec ladite filière (8) pendant le passage du tube dans ledit alésage central (8a) de ladite filière (8) maintenue sous pression réduite, et à refroidir le tube par l'action du fluide de refroidissement, caractérisé en ce que lesdits moyens de distribution d'un fluide sont des moyens de prérefroidissement (7) disposés à l'extrémité d'entrée de la filière (8) et comportant des moyens de sortie du fluide de refroidissement contre la périphérie extérieure du tube de matière plastique (A), et en ce que lesdits trous radiaux (8b) partent de l' alésage central (8a) jusqu'à la périphérie extérieure de la filière (8) et débouchent dans ladite cuve (11) remplie avec le fluide de refroidissement qui est main-



tenu sous pression réduite, de sorte que le fluide de refroidissement venant desdits moyens de prérefroidissement (7) s'écoule entre la filière (8) et le tube de matière plastique (A), arrive dans l'alésage central (8a) de la filière (8), passe dans les trous radiaux (8b) et arrive dans la cuve (11).

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2. Dispositif suivant la revendication 1, comprenant en outre des moyens d'application d'une pression à l'intérieur du tube de matière plastique (A).

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3. Dispositif suivant la revendication 1, comprenant en outre une chemise (12) montée autour de la périphérie extérieure de ladite filière (8), de manière à couvrir au moins un desdits trous radiaux (8b), et des moyens (12a) d'amenée de fluide de refroidissement additionnel à partir de l'extérieur de ladite cuve (11), à travers ladite chemise (12) et lesdits trous radiaux (8b), dans l'alésage central (8a) de la filière et, de là, dans ladite cuve (11).

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