

FENDER

BACKGROUND OF THE INVENTION

The present invention relates to a fender designed to protect a vessel by reducing the impact of the docking
5 vessel through absorption of the kinetic energy thereof.

A fender 9 conventionally used in the art is exemplified by a circle-type fender made of one piece rubber material having a sectional shape as shown in Fig.20A. The circle-type fender 9 includes: a first
10 bumper member 91 formed in a cylindrical shape of a constant outside diameter and constructed such that one end of the cylindrical body defines a distal end 9a of the fender 9 and serves as a fixing portion for fixing an impact receiving plate (not shown) directly coming
15 into contact with a vessel; and a second bumper member 92 formed in a hollow conical shape wherein one end thereof is connected to the other end of the cylindrical body of the first bumper member 91 while the other end thereof defines a fix portion to be fixed to a fixing
20 surface Q on a dock and wherein the latter end thereof has a greater outside diameter than the former end thereof. Indicated at 93 is a flange actually functioning to fix the fix portion of the second bumper member 92 to the fixing surface Q.

25 When receiving a compressive force from the docking

vessel, the fender 9 is compressively deformed as described below. First, the fender 9 develops a reaction force against the compressive force. When the fender can no more withstand the compressive force, it starts to buckle at an outer periphery of a connection portion CP between the first bumper member 91 and the second bumper member 92 and at an inner periphery of a buckling position BP of the second bumper member 92. Subsequently, as shown in Fig.20B, the whole body of the fender 9 is deformed into a tightly folded shape with an outer periphery 91a of the first bumper member 91 and an outer periphery 92a of the second bumper member 92 as well as areas 92b, 92c above and below the buckling position BP on the inner periphery of the second bumper member 92 coming into contact with each other. Then, the tightly folded fender 9 with no more portion to be buckled forms a single rubber mass which is further compressively deformed.

If this process is expressed by a distortion-reaction force characteristic curve plotting the amount of distortion of the compressed fender 9 relative to the reaction force developed in the fender 9, a solid curved line of Fig.21 is obtained. Specifically, a line portion between the origin O and Maximum Point A corresponds to a period between a normal state shown in Fig.20A and a

state just before the fender starts to buckle, yielding to the compressive force. During this period, the compressed fender 9 develops the reaction force, trying to restore itself to its initial shape. The reaction force increases as the amount of distortion becomes greater. Upon buckling, however, the fender 9 loses most of the reaction force. Hence, the reaction force declines during the time that the fender 9 is crushed into the state of Fig.20B. This time period corresponds to a line portion between Maximum Point A and Minimum Point C of the characteristic curve. In the state of Fig.20B, the whole body of the fender 9 behaves as a single rubber mass as mentioned supra, developing the reaction force again. Therefore, the reaction force substantially linearly rises from Minimum Point C.

The practically useful range of the fender 9 with such a characteristic curve is limited to a range between the origin O and a point B representing the same level of reaction force as Maximum Point A. The useful range as expressed in terms of distortion is limited to the range of not more than D. This is because a distortion in excess of D means an excessive reaction force which, in turn, will cause damage to the vessel or to the fender 9 itself. The amount of energy that the fender 9 can absorb through distortion D within the allowed range is

represented by an area S_1 of a region enclosed by the characteristic curve represented by the solid line, a horizontal axis O-D, and a vertical line B-D.

It is generally thought idealistic that the fender
5 is capable of absorbing such an amount of energy that corresponds to the combination of the above area S_1 and an area S_2 of a region enclosed by the characteristic curve and a horizontal line A-B. However, the fender is actually capable of absorbing energy of an amount reduced
10 by that represented by the area S_2 , thus reduced in the energy absorption efficiency.

In this connection, study has been made to increase the energy-absorption capacity of the fender 9. For instance, it is contemplated to increase thicknesses T_1
15 and T_2 of the first and second bumper members 91, 92, as shown in Fig.22A, thereby to increase the reaction forces of the bumper members 91, 92 against compression.

Unfortunately, this approach has the following problem. With a smaller distortion than in the case of
20 Figs.20A, 20B, the fender 9 is buckled into a completely folded state, as shown in Fig.22B, wherein the outer periphery 91a of the first bumper member 91 and the outer periphery 92a of the second bumper member 92 as well as the areas 92b, 92c above and below the buckling position
25 BP on the inner periphery of the second bumper member

92 come into contact with each other, leaving no more portion to be buckled. That is, with a smaller distortion than in the case of Fig.20B, the buckled fender 9 starts to behave as the single rubber mass.

5 As indicated by a dash-single-dot curved line in Fig.23, this results in a smaller distortion D' than the distortion D in the case of Figs.20A, 20B, the distortion D' corresponding to the reaction force which, after buckling, starts to re-increase and reaches a point B'
10 representing the same level as Maximum Point A' . That is, a width of a constant load area in which the fender is principally involved in the energy absorption, or the range A-B between Maximum Point A and the point B of the characteristic curve is reduced to a range $A'-B'$. Thus,
15 the fender is reduced in the energy-absorption capacity after buckling.

Therefor, the arrangement of Fig.22A suffers a problem that despite the increased size corresponding to the increased thickness as described above, the fender
20 cannot attain the increased energy-absorption capacity corresponding to the size increase or any increase in the energy-absorption capacity at all.

SUMMARY OF THE INVENTION

A first object of the invention is to provide a novel
25 fender capable of approximating a distortion-reaction

force characteristic curve within an allowed range of distortion to an idealistic curve representing a substantially constant value of reaction force after the maximum point.

5 A second object of the invention is to provide a novel fender capable of presenting the greatest possible energy-absorption capacity within the allowed range of distortion.

 According to the invention of Claim 1, a fender for
10 absorbing the impact of a vessel, formed of rubber and fixed to a fixing surface of a dock as having an impact receiving plate secured to a distal end of its body, the fender comprising: a first bumper member formed in a cylindrical shape of a constant outside diameter and
15 defining at one end of the cylindrical body thereof a fixing portion for the impact receiving plate; a second bumper member connected at one end to the other end of the cylindrical body of the first bumper member, defining at the other end thereof a fix portion to be fixed to
20 the fixing surface, formed in a hollow conical shape with its latter end greater in outside diameter than its former end, and buckling radially outwardly upon receiving a compressive force from the vessel thereby absorbing the impact of the vessel; and a step formed
25 along an outer periphery of a connection portion between

the two bumper members, the step defined by the former end of the second bumper member having a greater outside diameter than the latter end of the first bumper member.

By virtue of a step 14 on the outer periphery of
5 the connection portion between two bumper members 11, 12, such as shown in Figs. 1 and 2A for example, the fender of Claim 1 can accomplish the increase in the aforesaid distortion D, as compared with the conventional fender 9 without the step on the outer periphery of the
10 connection portion CP. Specifically, the provision of the step 14 provides a configuration wherein an outer periphery 11a of the first bumper member 11 is somewhat recessed from an outer periphery 12a of the second bumper member 12. As a result, when the fender is buckled, a
15 greater distortion D than in the conventional fender 9 is involved in bringing the outer peripheries 11a, 12a into contact with each other, as shown in Fig. 2B.

As shown in Fig. 20B, the conventional fender 9 in the buckled state contains a cavity CV between the bent
20 bumper members 91, 92. The cavity CV is responsible for a greater decline of the reaction force after Maximum Point A. That is, a deformation involved in crushing the cavity CV is added to the normal deformation by buckling as mentioned supra, so that the fender 9 encounters the
25 correspondingly increased amount of deformation after

buckling. This results in the greater decline of the reaction force after Maximum Point A. In contrast, the arrangement of Claim 1 is adapted to reduce or totally eliminate the cavity between the bent members 11, 12 by virtue of a corner of the step 14 caught in the cavity, as shown in Fig.2B. Thus, the decline of the reaction force after Maximum Point A is reduced.

According to the arrangement of Claim 1, the synergy between these effects not only approximates the characteristic curve as close as possible to the idealistic curve but also enables further increase in the energy-absorption capacity and the energy absorption efficiency of the fender.

According to the invention of Claim 2, the fender of Claim 1 is characterized in that the first bumper member and the second bumper member share the same inside diameter at the connection portion and that a ratio T_1/T_2 is in the range of 0.8 to 0.9, T_1 denoting a thickness of the first bumper member, T_2 denoting a thickness of the second bumper member.

If the ratio T_1/T_2 is less than 0.8, the thickness T_2 of the second bumper member 12 is relatively increased. This may result in a similar problem to that occurred in the case of Figs.22A, 22B. Specifically, areas 12b, 12c above and below the buckling position BP on an inner

periphery of the second bumper member 12 are brought into contact with each other by a smaller distortion and hence, the allowed distortion D is decreased. This leads to a reduced energy-absorption capacity after buckling.

5 If the ratio T_1/T_2 exceeds 0.9, the step 14 may have an insufficient dimension for adequately offering the effect of Claim 1. Specifically, when caught in the cavity between the bent of the first and second bumper members 11, 12, the step 14 may not be effective enough
10 to reduce or totally eliminate the cavity. Thus, the decline of the reaction force after Maximum Point A cannot be reduced enough. Or the step 14 may not be effective enough to increase the distortion involved in bringing the outer peripheries 11a, 12a of the bumper
15 members 11, 12 into contact with each other. Thus, the distortion D cannot be increased enough.

In contrast, the arrangement of Claim 2 is not likely to encounter these problems, further enhancing the effects of Claim 1.

20 According to the invention of Claim 3, the fender of Claim 1 is characterized in that a ratio H_1/H_0 is in the range of 0.1 to 0.3, H_1 denoting an axial height of the cylindrical body of the first bumper member, H_0 denoting an overall height of the fender with respect
25 to the axis of the cylindrical body.

According to the invention of Claim 4, the fender of Claim 3 is characterized in that an angle θ_1 between the fixing surface and a generatrix of the conical body of the second bumper member is in the range of 70 to 80°.

5 If the overall height H_0 and the outside diameter D_1 of the first bumper member 11 are constant, the height H_1 and the angle θ_1 have a correlation. That is, as the height H_1 of the first bumper member 11 accounts for the greater proportion of the overall height H_0 , the angle
10 θ_1 becomes the smaller, as shown in Fig.8. On the other hand, the angle θ_1 increases with decrease in the proportion of the height H_1 as shown in Fig.9.

 If the height H_1 is below the above range or if the angle θ_1 exceeds the above range, the reaction force at
15 buckling is increased because the height H_2 of the second bumper member 12 has a relatively increased proportion of the overall height H_0 . At the same time, the energy-absorption capacity as a whole is increased because the distortion of the fender involved in bringing
20 the second bumper member 12 into a buckling process or the distortion thereof involved in buckling the second bumper member to limit is increased. Considering the characteristics of the fender, however, such a fender cannot serve a useful function because a width of a
25 constant load area, that is, a range of the

characteristic curve between Maximum Point A and the point B where the first bumper member 11 is in charge of the load is too small.

If the height H_1 exceeds the above range or if the angle θ_1 is below the above range, the reaction force at buckling is decreased because the height H_2 of the second bumper member 12 has a relatively decreased proportion of the overall height H_0 . At the same time, the distortion of the fender involved in bringing the second bumper member 12 into the buckling process or the distortion thereof involved in buckling the second bumper member to limit is decreased. Hence, the energy-absorption capacity as a whole tends to decrease.

In contrast, the arrangements of Claims 3 and 4 are not likely to encounter these problems, further enhancing the effects of Claim 1.

According to the invention of Claim 5, a fender for absorbing the impact of a vessel, formed of rubber and fixed to a fixing surface of a dock as having an impact receiving plate secured to a distal end of its body, the fender comprises: a first bumper member formed in a cylindrical shape of a constant outside diameter and defining at one end of the cylindrical body thereof a fixing portion for the impact receiving plate; a second bumper member connected at one end to the other end of

the cylindrical body of the first bumper member, defining at the other end thereof a fix portion to be fixed to the fixing surface, formed in a hollow conical shape with its latter end greater in outside diameter than its former end, and buckling radially outwardly upon receiving a compressive force from the vessel thereby absorbing the impact of the vessel; and a projection having a constant width and formed along a buckling position on an inner periphery of the second bumper member.

According to the arrangement of Claim 5, the second bumper member 12 is buckled and clamp a projection 15 from top and bottom, as shown in Fig.4C while the clamped projection 15 develops a counterforce against a compressive force applied thereto by being buckled. That is, the projection 15 contributes the counterforce against the buckling of the second bumper member 12. This results in an increased reaction force which the buckled second bumper member 12 exhibits against the compressive force.

On the inner periphery of the second bumper member 12, the areas 12b, 12c above and below the projection 15 are in somewhat recessed from the projection 15. This also results in an increased distortion of the buckled fender which is involved in bringing the areas 12b, 12c

into contact with each other.

Thus, the synergy between these effects increases the energy-absorption capacity of the fender as a whole.

According to the invention of Claim 6, the fender
5 of Claim 5 is characterized in that a ratio W_1/W_2 is in the range of 3/6 to 6/3, W_1 denoting a distance from the buckling position to an upper side of the projection along an axis of the conical body of the second bumper member, W_2 denoting a distance from the buckling position
10 to a lower side of the projection along the axis of the conical body.

If the ratio W_1/W_2 is less than 3/6, the upper side of the projection 15 is so close to the buckling position BP of the second bumper member 12 that the second bumper
15 member 12 buckles only along the upper side of the projection 15 as shown in Fig.12C for example. If the ratio W_1/W_2 is in excess of 6/3, the lower side of the projection 15 is so close to the buckling position BP of the second bumper member 12 that the second bumper
20 member 12 buckles only along the lower side of the projection 15 as shown in Fig.13C for example. In either cases, the buckled second bumper member 12 cannot clamp the projection 15 from top and bottom well, thus, the effect of Claim 5 may not be fully attained.

25 In contrast, the arrangement of Claim 6 is not

likely to encounter these problems, further enhancing the effects of Claim 5.

According to the invention of Claim 7, the fender of Claim 6 is characterized in that a distance W_1+W_2 between the upper side and the lower side of the projection along the axis of the conical body is in the range of 20 to 40% of a height H_2 of the second bumper member along the axis of the conical body.

If the distance W_1+W_2 , representative of the width of the projection 15 is less than 20% of the height H_2 , the projection 15 may not provide the adequate effects of Claim 5. Specifically, the projection 15 may be too small to afford the aforesaid effect to increase the reaction force of the second bumper member 12 as it is buckled. If the distance W_1+W_2 is in excess of 40% of the height H_2 , a similar result to that of the increased thickness of the whole body of the second bumper member 12 is produced. This leads to the same problem as in the case of Figs. 22A, 22B, decreasing the energy-absorption capacity after buckling.

In contrast, the arrangement of Claim 7 is not likely to encounter these problems, further enhancing the effects of Claim 5.

According to the invention of Claim 8, the fender of Claim 7 is characterized in that the projection is

of a trapezoidal shape in section and has a projection height T_3 from the inner periphery of the second bumper member in the range of 5 to 15% of the thickness T_2 of the second bumper member.

5 If the height T_3 of the projection 15 of the trapezoidal sectional shape is less than 5% of the thickness T_2 of the second bumper member, the projection 15 may be too low to afford an adequate effect to increase the reaction force of the second bumper member 12 as it
10 is buckled. It is also likely that the projection 15 is not effective enough to increase the distortion of the buckled fender involved in bringing the areas 12b, 12c above and below the projection 15 into contact with each other. That is, the provision of the projection 15 may
15 not contribute the adequate effect. If the height T_3 of the projection 15 exceeds 15% of the thickness T_2 of the second bumper member, an excessive distortion of the fender may be involved in bringing the areas 12b, 12c into contact with each other, the areas 12b, 12c located
20 above and below the projection 15 on the inner periphery of the second bumper member 12. As a result, the fender is excessively distorted when both the areas 12b, 12c contact each other so that the reaction force rises sharply after this point of time, i.e., after the point
25 C on the reaction force characteristic curve. That is,

the fender is excessively compressed so that damage to the vessel or the fender itself may result.

In contrast, the arrangement of Claim 8 is not likely to encounter these problems, further enhancing the effects of Claim 5.

According to the invention of Claim 9, the fender of Claim 7 is characterized in that the projection is of a triangular shape in section and has a projection height T_1 from the inner periphery of the second bumper member in the range of 15 to 20% of the thickness T_2 of the second bumper member. Given the same width and height, the projection 15 of the triangular sectional shape has a smaller sectional area than the projection of the trapezoidal sectional shape. Accordingly, the projection is designed to have a greater projection height T_1 in order to accomplish the same degree of working effect as the projection of the trapezoidal sectional shape.

If the projection of the triangular sectional shape has a projection height T_1 of less than 15% of the thickness T_2 of the second bumper member 12, the projection 15 may be too low to afford an adequate effect to increase the reaction force of the second bumper member 12 as it is buckled. It is also likely that the projection 15 is not effective enough to increase the

distortion of the buckled fender involved in bringing the areas 12b, 12c above and below the projection 15 into contact with each other. That is, the provision of the projection may not contribute the adequate effect. If
5 the height T_1 of the projection 15 exceeds 20% of the thickness T_2 of the second bumper member, an excessive distortion of the fender may be involved in bringing the areas 12b, 12c into contact with each other, the areas 12b, 12c located above and below the projection 15 on
10 the inner periphery of the second bumper member 12. The fender is excessively distorted when both the areas 12b, 12c contact each other so that the reaction force rises sharply after this point of time, i.e., after the point C on the reaction force characteristic curve. That is,
15 the fender is excessively compressed so that damage to the vessel or the fender itself may result.

In contrast, the arrangement of Claim 9 is not likely to encounter these problems, further enhancing the effects of Claim 5.

20 According to the invention of Claim 10, the fender of Claim 5 further comprises a step along an outer periphery of a connection portion between the two bumper members, the step defined by the former end of the second bumper member having a greater outside diameter than the
25 latter end of the first bumper member.

According to the arrangement of Claim 10, the synergy between the effects of the arrangements of Claims 1 and 5 not only provides the characteristic curve even closer to the idealistic curve but also enables further increase in the energy-absorption capacity and the energy absorption efficiency of the fender.

An analogous arrangement to the inventive arrangement is disclosed in Japanese Unexamined Patent Publication No.11(1999)-222833 which suggests the provision of a step on an outer periphery of a circle-type fender. However, this step is not provided at the connection portion between the first and the second bumper members but at a midportion of the second bumper member, which is far below the connection portion. Disposed at such a place, the step does not operate the same way as the aforementioned step of the invention. Therefore, the above fender cannot offer the working effect equivalent to that of the invention. Hence, this prior art is not construed as disclosing nor suggesting the present invention.

Japanese Unexamined Patent Publication No.7(1995)-229129 discloses a circle-type fender provided with a projection on its inner periphery. However, the projection is not disposed on the buckling position of the fender, as shown in Fig.8, contained in

this official gazette. The projection is disposed in a manner that the buckling position is positioned on a boundary between the projection and a smaller-thickness portion adjoining thereto. Therefore, this fender is no
5 more than an equivalent to the aforementioned comparative examples of Figs.12A-12C and 13A-13C, being unable to offer the same working effect as the invention. Hence, this prior art is not construed as disclosing nor suggesting the present invention.

10 Further, Japanese Examined Utility Publication No.49(1974)-15516 discloses a fender, the whole body of which is formed in a cylindrical shape of a constant outside diameter. This prior-art fender has an arrangement wherein the cylindrical body is formed with
15 a projection at its buckling position. However, this prior art never teaches that the whole body of the fender consists of a first cylindrical bumper member of a constant outside diameter and a second bumper member of a hollow conical shape, nor that the projection is
20 disposed on the buckling position of the second bumper member. Hence, this prior art is not construed as disclosing nor suggesting the present invention.

BRIEF DESCRIPTION OF THE DRAWINGS

Fig.1 is a partially cutaway perspective view
25 showing a fender according to one embodiment of the

invention;

Fig.2A is a vertical sectional view showing the fender of Fig.1 in a normal, uncompressed state, whereas Fig.2B is an enlarged vertical sectional view showing the fender compressed into a buckled state;

Fig.3 is a partially cutaway perspective view showing a fender according to another embodiment of the invention;

Fig.4A is a vertical sectional view showing the fender of Fig.3 in a normal, uncompressed state, Fig.4B is an enlarged sectional view showing a projection which is a principal part of the fender, and Fig.4C is an enlarged vertical sectional view showing the fender compressed into a buckled state;

Fig.5A is a vertical sectional view showing a fender according to another embodiment in a normal, uncompressed state, Fig.5B is an enlarged sectional view showing a projection which is a principal part of the fender, and Fig.5C is an enlarged vertical sectional view showing the fender compressed into a buckled state;

Fig.6A is a vertical sectional view showing a fender according to another embodiment of the invention in a normal, uncompressed state, whereas Fig.6B is an enlarged sectional view showing a projection which is a principal part of the fender;

Fig.7A is a vertical sectional view showing a fender of Example 2 in a normal, uncompressed state whereas Fig.7B is an enlarged vertical sectional view showing the fender compressed into a buckled state;

5 Fig.8A is a vertical sectional view showing a fender of Example 3 in a normal, uncompressed state whereas Fig.8B is an enlarged vertical sectional view showing the fender compressed into a buckled state;

10 Fig.9A is a vertical sectional view showing a fender of Example 4 in a normal, uncompressed state whereas Fig.9B is an enlarged vertical sectional view showing the fender compressed into a buckled state;

15 Fig.10A is a vertical sectional view showing a fender of Comparative Example 2 in a normal, uncompressed state whereas Fig.10B is an enlarged vertical sectional view showing the fender compressed into a buckled state;

Fig.11 is a graph representing compressibility-reaction force characteristic curves of the fenders of Examples 1-4 and Comparative Examples 1-2;

20 Fig.12A is a vertical sectional view showing a fender of Comparative Example 4 in a normal, uncompressed state, Fig.12B is an enlarged sectional view showing a projection, and Fig.12C is an enlarged vertical sectional view showing the fender compressed into a
25 buckled state;

Fig.13A is a vertical sectional view showing a fender of Comparative Example 5 in a normal, uncompressed state, Fig.13B is an enlarged sectional view showing a projection, and Fig.13C is an enlarged vertical
5 sectional view showing the fender compressed into a buckled state;

Fig.14 is a graph representing compressibility-reaction force characteristic curves of the fenders of Examples 5-6 and Comparative Examples 1, 3-5;

10 Fig.15A is a vertical sectional view showing a fender of Example 8 in a normal, uncompressed state whereas Fig.15B is an enlarged sectional view showing a projection;

Fig.16A is a vertical sectional view showing a
15 fender of Example 9 in a normal, uncompressed state whereas Fig.16B is an enlarged sectional view showing a projection;

Fig.17A is a vertical sectional view showing a fender of Example 10 in a normal, uncompressed state
20 whereas Fig.17B is an enlarged sectional view showing a projection;

Fig.18A is a vertical sectional view showing a fender of Comparative Example 6 in a normal, uncompressed state whereas Fig.18B is an enlarged sectional view
25 showing a projection;

Fig.19 is a graph representing compressibility-reaction force characteristic curves of the fenders of Examples 7-10 and Comparative Example 6;

Fig.20A is a vertical sectional view showing a conventional fender in a normal, uncompressed state whereas Fig.20B is an enlarged sectional view showing the fender compressed into a buckled state;

Fig.21 is a graph representing a distortion-reaction force characteristic curve of the fender of Fig.20A;

Fig.22A is a vertical sectional view showing another conventional fender in a normal, uncompressed state whereas Fig.22B is an enlarged vertical sectional view showing the fender compressed into a buckled state; and

Fig.23 is a graph representing distortion-reaction force characteristic curves of the fenders of Figs.20A and 22A.

DESCRIPTION OF PREFERRED EMBODIMENTS

Fig.1 is a partially cutaway perspective view showing a fender 1 according to one embodiment of the invention. Fig.2A is a vertical sectional view of the above fender 1.

The fender 1 comprises:

a first bumper member 11 formed in a cylindrical

shape of a constant outside diameter D_1 , one end of the cylindrical body defining a distal end 1a of the fender 1 and serving as a fixing portion for an impact receiving plate (not shown) directly coming into contact with a vessel;

5 a second bumper member 12 connected at one end to the other end of the cylindrical body of the first bumper member 11, defining at the other end thereof a fix portion to be fixed to a fixing surface Q of a dock, and formed
10 in a hollow conical shape with its latter end greater in outside diameter than its former end; and

a step 14 formed along an outer periphery of a connection portion between the two bumper members and defined by the former end of the second bumper member
15 12 having a greater outside diameter than the latter end of the first bumper member 11. Indicated at 13 is a flange actually functioning to secure the fix portion of the second bumper member 12 to the fixing surface Q. The flange 13 is formed with through holes 13a penetrated
20 by fixing bolts (not shown). Although not illustrated, the flange 13 may have a reinforcement member, such as of a steel plate, embedded therein for the reinforcement purpose. Further, the first bumper member 11 may have a reinforcement member, such as of a steel plate,
25 embedded in the former end thereof, i.e., the distal end

1a of the fender 1 for the purposes of reinforcement and mounting of the impact receiving plate.

The first bumper member 11 and the second bumper member 12 are designed to share the same inside diameter D_3 at the connection portion. In this design, a ratio T_1/T_2 between a thickness T_1 of the first bumper member 11 and a thickness T_2 of the second bumper member 12 is preferably in the range of 0.8 to 0.9, the ratio defining the width of the step 14. The reason for this is mentioned in the foregoing. In order to further enhance the aforesaid working effect of the step 14, the step of the wider width is more preferred. That is, the ratio T_1/T_2 closer to 0.8 is more preferred.

A ratio H_1/H_0 between a height H_1 of the first bumper member 11 and an overall height H_0 of the fender 1, which is equal to a combined height of the first and the second bumper members 11, 12, is preferably in the range of 0.1 to 0.3. An angle θ_1 between a generatrix of the cone of the second bumper member 12 and the fixing surface Q is preferably in the range of 70 to 80°. The reasons for this are also mentioned in the foregoing. The ratio H_1/H_0 ranging from 0.22 to 0.27 and the angle θ_1 ranging from 70 to 75° are more preferred in the light of a more preferred fender featuring a suitable reaction force characteristic as a useful fender and a great energy

absorption.

The fender 1 is fabricated as follows. A mold is charged with an unvulcanized rubber compound and a plate-like reinforcement member to be embedded in one end of the first bumper member 11 and in the flange, as required. The mold has a shape corresponding to the shape of the fender 1. The rubber compound is heated under pressure for vulcanization.

Fig.3 is a partially cutaway perspective view showing a fender 1 according to another embodiment of the invention. Fig.4A is a vertical sectional view of the above fender 1 whereas Fig.4B is an enlarged sectional view of a projection 15 which is a principal part of the fender 1.

The fender 1 comprises:

a first bumper member 11 formed in a cylindrical shape of a constant outside diameter D_1 , one end of the cylindrical body defining a distal end 1a of the fender 1 and serving as a fixing portion for an impact receiving plate (not shown) directly coming into contact with a vessel;

a second bumper member 12 connected at one end to the other end of the cylindrical body of the first bumper member 11, defining at the other end thereof a fix portion to be fixed to a fixing surface Q of a dock, and formed

in a hollow conical shape with its latter end greater in outside diameter than its former end; and

a projection 15 having a constant width and formed along a buckling position BP on an inner periphery of the second bumper member 12. Similarly to the foregoing embodiment, the second bumper member 12 is provided with the flange 13 at its latter end for securing the fender to the fixing surface Q. The flange 13 is formed with the through holes 13a penetrated by the fixing bolts (not shown). Although not shown in the figure, the flange 13 may have the reinforcement member, such as of a steel plate, embedded therein for the reinforcement purpose. Further, the reinforcement member, such as of a steel plate, may also be embedded in the former end of the first bumper member 11, i.e., the distal end 1a of the fender 1 for the purposes of reinforcement and fixing of the impact receiving plate.

The projection 15 may preferably have a ratio W_1/W_2 in the range of $3/6$ to $6/3$, W_1 denoting a distance from the buckling position BP of the second bumper member 12 to an upper side of the projection 15, W_2 denoting a distance from the buckling position BP to a lower side of the projection 15. The ratio W_1/W_2 defines the position of the projection. A distance W_1+W_2 between the upper side and the lower side of the projection 15 is

preferably in the range of 20 to 40% of the height H_2 of the second bumper member 12. The distance W_1+W_2 defines the width of the projection 15. The reasons for this are mentioned in the foregoing. In order to further enhance
 5 the aforesaid working effect of the projection 15, the ratio W_1/W_2 more preferably ranges from 4/5 to 5/4 and the distance W_1+W_2 more preferably ranges from 25 to 35% of the height H_2 .

The projection 15 is formed in a trapezoidal shape
 10 in section. The projection 15 may preferably have a projection height T_1 from the inner periphery of the second bumper member 12 in the range of 5 to 15% of the thickness T_2 of the second bumper member 12. The reason for this is also mentioned in the foregoing. The
 15 projection height T_1 is more preferably in the range of 7 to 9% of the thickness T_2 from the standpoint of further enhancing the aforesaid working effect of the projection 15.

Fig.5A is a vertical sectional view showing a fender
 20 1 according to a still another embodiment of the invention. Fig.5B is an enlarged sectional view of the projection 15 which is the principal part of the fender 1.

The fender of this embodiment differs from the
 25 arrangement of Figs.4A, 4B in that the projection has

a triangular sectional shape rather than the trapezoidal shape. Other parts are the same as those of the foregoing embodiments and represented by the same reference characters, respectively.

5 The projection 15 with the triangular sectional shape may preferably have a projection height T_1 from the inner periphery of the second bumper member 12 in the range of 15 to 20% of the thickness T_2 of the second bumper member 12. The reason for this is also mentioned in the
10 foregoing. The projection height T_1 is more preferably in the range of 16 to 18% of the thickness T_2 from the standpoint of positively preventing the damage to the vessel or to the fender itself and of further enhancing the aforesaid working effect of the projection 15.

15 Fig. 6A is a vertical sectional view showing a fender 1 according to another embodiment of the invention. Fig. 6B is an enlarged sectional view showing a projection 15 which is the principal part of the fender 1.

 The fender 1 of this embodiment is characterized
20 by inclusion of both the step 14 and the projection 15. The synergistic effect of the two portions contributes a characteristic curve even closer to the ideal curve and further increases the energy-absorption capacity and the energy absorption efficiency of the fender. Other
25 parts are the same as those of the foregoing embodiments

and represented by the same reference characters, respectively.

It is preferred that the respective parts have the same dimensions, shapes and the like as those of the
5 forgoing embodiments.

That is, the first and second bumper members 11, 12 are designed to share the same inside diameter D_3 at the connection portion between the two members 11, 12. In this design, the ratio T_1/T_2 between the thickness T_1
10 of the first bumper member 11 and the thickness T_2 of the second bumper member 12 is preferably in the range of 0.8 to 0.9, the ratio defining the width of the step 14. Particularly, the ratio closer to 0.8 is more preferred.

The ratio H_1/H_0 between the height H_1 of the first
15 bumper member 11 and the overall height H_0 of the fender 1 is preferably in the range of 0.1 to 0.3 and more preferably of 0.22 to 0.27. The second bumper member 12 may have the angle θ_1 between the generatrix of the cone body and the fixing surface Q preferably in the range
20 of 70 to 80° and more preferably of 70 to 75°.

The ratio W_1/W_2 between the distance W_1 from the buckling position BP of the second bumper member 12 to the upper side of the projection 15 and the distance W_2 from the buckling position BP to the lower side of the
25 projection 15 is preferably in the range of 3/6 to 6/3,

and more preferably of $4/5$ to $5/4$.

The distance W_1+W_2 between the upper side and the lower side of the projection 15 is preferably in the range of 20 to 40%, and more preferably of 25 to 35% of the height H_2 of the second bumper member 12.

The projection 15 is formed in a trapezoidal shape in section. The projection 15 may preferably have the projection height T_1 from the inner periphery of the second bumper member 12 in the range of 5 to 15% and more preferably of 7 to 9% of the thickness T_2 of the second bumper member 12.

The projection 15 may have a triangular sectional shape, the illustration of which is dispensed with. Such a projection 15 may have the projection height T_1 from the inner periphery of the second bumper member 12 in the range of 15 to 20% and more preferably of 16 to 18% of the thickness T_2 of the second bumper member 12.

It is to be noted that the arrangement of the fender of the invention is not limited to the embodiments described in the foregoing but various changes and modifications may be made thereto within the scope and spirits of the invention.

EXAMPLES

The invention will be described in more detail by way of reference to the following examples and

comparative examples.

Example 1

A circle-type fender 1 was fabricated as follows. The following materials were charged in a mold and heated
5 under pressure for vulcanizing a rubber base material. Thus was obtained the fender having the general appearance shown in Fig.1 and the sectional shape shown in Fig.2A as well as dimensions and an angle listed in Table 1.

- 10 A rubber compound: a rubber base material comprising a rubber mixture containing natural rubber and butadiene rubber in a weight ratio of 6:4;

A reinforcement member in one end of the first bumper member 11: a disk-like steel plate having a thickness
15 of 28 mm and an outside diameter of 650 mm and including a through hole of inside diameter of 270 mm at its center; and

A reinforcement member in the flange 13: a disk-like steel plate having a thickness of 28 mm and an outside
20 diameter of 1470 mm and including a through hole of inside diameter of 710 mm at its center.

TABLE 1

T_1	220mm
T_2	244mm
T_1/T_2	0.9
H_0	1000mm
H_1	250mm
H_1/H_0	0.25
θ_1	72.5°
D_1	680mm
D_2	1500mm

Example 2

The same rubber compound and two types of reinforcement members as in Example 1 were used to fabricate a circle-type fender 1 having the sectional shape of Fig.7A as well as dimensions and an angle listed in Table 2.

TABLE 2

T_1	220mm
T_2	275mm
T_1/T_2	0.8
H_0	1000mm
H_1	250mm
H_1/H_0	0.25
θ_1	72.5°
D_1	680mm
D_2	1500mm

Example 3

10 The same rubber compound and two types of

reinforcement members as in Example 1 were used to fabricate a circle-type fender 1 having the sectional shape of Fig.8A as well as dimensions and an angle listed in Table 3.

5 TABLE 3

T_1	220mm
T_2	244mm
T_1/T_2	0.9
H_0	1000mm
H_1	300mm
H_1/H_0	0.30
θ_1	70.0°
D_1	680mm
D_2	1500mm

Example 4

The same rubber compound and two types of reinforcement members as in Example 1 were used to fabricate a circle-type fender 1 having the sectional shape of Fig.9A as well as dimensions and an angle listed in Table 4.

10

TABLE 4

T_1	220mm
T_2	244mm
T_1/T_2	0.9
H_0	1000mm
H_1	100mm
H_1/H_0	0.10
θ_1	80.0°
D_1	680mm
D_2	1500mm

Comparative Example 1

The same rubber compound as in Example 1 and the following two reinforcement members were used to fabricate a circle-type fender 1 having the conventional sectional shape shown in Fig.20A as well as dimensions and an angle listed in Table 5.

A reinforcement member in one end of the first bumper member 11: a disk-like steel plate having a thickness of 28 mm and an outside diameter of 670 mm and including a through hole of inside diameter of 270 mm at its center; and

A reinforcement member in the flange 13: the same steel plate as in Example 1

TABLE 5

T_1	230mm
T_2	230mm
T_1/T_2	1.0
H_0	1000mm
H_1	250mm
H_1/H_0	0.25
θ_1	72.5°
D_1	700mm
D_2	1500mm

Comparative Example 2

The same rubber compound as in Example 1 and the following two reinforcement members were used to fabricate a circle-type fender 1 having the sectional shape of Fig.10A as well as dimensions and an angle listed in Table 6.

A reinforcement member in one end of the first bumper member 11: a disk-like steel plate having a thickness of 28 mm and an outside diameter of 690 mm and including a through hole of inside diameter of 270 mm at its center; and

A reinforcement member in the flange 13: the same steel plate as in Example 1

TABLE 6

T_{11}	240mm
T_{12}	216mm
T_2	240mm
T_{11}/T_2	1.0
T_{12}/T_2	0.9
H_0	1000mm
H_1	250mm
H_1/H_0	0.25
θ_1	72.5°
D_1	720mm
D_2	1500mm

Table 7 tabulates principal dimensions of the above examples and comparative examples.

TABLE 7

	Thickness(mm)			Height(mm) $H_0=1000$		Angle θ_1 (degree)
	T_1	T_2	T_1/T_2	H_1	H_1/H_0	
Ex.1	220	244	0.9	250	0.25	72.5
Ex.2	220	275	0.8	250	0.25	72.5
Ex.3	220	244	0.9	300	0.30	70.0
Ex.4	220	244	0.9	100	0.10	80.0
C.Ex.1	230	230	1.0	250	0.25	72.5
C.Ex.2	$T_{11}:240$ $T_{12}:216$	240	1.0 0.9	250	0.25	72.5

5 Compressive Test

The fenders of the above examples and comparative examples were each examined as follows. The former end of the first bumper member was mounted to a movable head of a 500 ton hydraulic press via a spacer analogous to

the impact receiving plate, the spacer having the same diameter as the first bumper member and a thickness of 200 mm. The flange on the latter end of the second bumper member was fixed to a stationary head of the hydraulic
 5 press. The fender was compressed by the hydraulic press to determine the distortion (compressibility)-reaction force characteristic. The compressibility was determined by the following expression:

$$\text{Compressibility}(\%) = (H_0 - H_0') / H_0 \times 100$$

10 where H_0 denotes the overall height of the fender in initial shape and H_0' denotes the overall height of the compressed fender. The results are shown in the graph of Fig.11.

As seen from Fig.11, the fender 9 of Comparative
 15 Example 1, as the conventional example, had a small compressibility of 60% representing the distortion D at the time when the reaction force, re-increased again, reached the point B representing the same level of reaction force at Maximum Point A. The following was
 20 found by continuing the observation of how the compressed fender deformed. After buckling, the fender 9 of Comparative Example 1 assumed the position of Fig.20B with a smaller distortion than the Examples to be described later, the position wherein the outer
 25 peripheries 91a, 92a of both the members 91, 92 came into

contact with each other. This was because the outer peripheries 91a, 92a defined one continuous, step-free surface.

It was also found that the fender 9 of Comparative Example 1 presented a small percentage reaction force of 87.5% at Minimum Point C based on the reaction force at Maximum Point A, thus suffering a great decline in the reaction force after buckling, i.e., after Maximum Point A. The examination of a sectional shape of the buckled fender revealed that, as shown in Fig.20B, the fender contained a large cavity CV between the bent members 91, 92.

The fender 9 of Comparative Example 2 was also determined to have a small compressibility of 58% representative of the distortion D, the fender wherein the first bumper member 91 was formed in a conical shape with one end having a greater diameter than the other end, the former end having a greater thickness T_{11} than that T_{12} of the latter end. The following was found by continuing the observation of how the compressed fender deformed. After buckling, the fender 9 of Comparative Example 2 assumed the position of Fig.10B with a smaller distortion than the Examples to be described later, the position wherein the outer peripheries 91a, 92a of both the members 91, 92 came into contact with each other.

This was because the outside diameter of the first bumper member 91 was not constant but increased toward its former end, although the outer peripheries 91a, 92a included the step.

5 It was also found that the fender 9 of Comparative Example 2 presented a percentage reaction force of 97.0% at Minimum Point C based on the reaction force at Maximum Point A, thus having a small decline in the reaction force after buckling, i.e., after Maximum Point A. The
10 examination of a sectional shape of the buckled fender revealed that a corner of a step 94 formed between the outer peripheries 91a, 92a of the members 91, 92 was caught in the buckled portion, eliminating the cavity thereat.

15 In contrast, all the fenders 1 of Examples 1-4 were determined to have great compressibilities of 62 to 67% representative of the distortion D. The following was found by continuing the observation of how the compressed fender deformed. After buckling, the fenders 1 of the
20 Examples assumed positions, as shown in Figs. 2B, 7B, 8B and 9B, with greater distortions than Comparative Examples 1-2, the positions wherein the outer peripheries 11a, 12a of both the members 11, 12 came into contact with each other.

25 It was also found that all the fenders 1 of the

Examples had percentage reaction forces at Minimum Point C of 92.5 to 97.5% based on the reaction force at Maximum Point A, thus presenting small declines in the reaction force after buckling, i.e., after Maximum Point A. The examination of sectional shapes of the buckled fenders revealed that a corner of the step 14 formed between the outer peripheries 11a, 12a of the members 11, 12 was caught in the buckled portion, eliminating the cavity thereat.

10 A comparison of Examples 1, 3 and 4 showed the following tendencies, these Examples having the same ratio T_1/T_2 but different ratios H_1/H_2 and angles θ_1 . With increase in the ratio H_1/H_2 and with decrease in the angle θ_1 , the overall energy-absorption capacity tends to decline. On the other hand, as the ratio H_1/H_2 decreases and the angle θ_1 increases, the constant load area for the first bumper member 11 becomes smaller. The results are tabulated in Table 8.

TABLE 8

	Reaction force drop at Min. Point C (%) *1	Compressibility (%) representing distortion D
Ex.1	92.5	63
Ex.2	95.0	65.5
Ex.3	97.5	65
Ex.4	96.5	62.5
C.Ex.1	87.5	60
C.Ex.2	97.0	58

*1: percentage reaction force based on the reaction force at Maximum Point A

Example 5

5 A circle-type fender 1 was fabricated as follows. The following materials were charged in a mold and heated under pressure for vulcanizing a rubber base material. Thus was obtained the fender having the general appearance shown in Fig.3 and the sectional shape shown
10 in Figs.4A, 4B as well as dimensions and an angle listed in Table 9. A projection 15 was of a trapezoidal shape in section, having dimensions listed in Table 10.

A rubber compound: a rubber base material comprising a rubber mixture containing natural rubber and butadiene
15 rubber in a weight ratio of 6:4;

A reinforcement member in one end of the first bumper member 11: a disk-like steel plate having a thickness of 28 mm and an outside diameter of 670 mm and including a through hole of inside diameter of 270 mm at its center;

and

A reinforcement member in the flange 13: a disk-like steel plate having a thickness of 28 mm and an outside diameter of 1470 mm and including a through hole of inside diameter of 730 mm at its center.

TABLE 9

T_1	230mm
T_2	230mm
T_1/T_2	1.0
H_0	1000mm
H_1	250mm
H_2	750mm
H_1/H_0	0.25
θ_1	72.5°
D_1	700mm
D_2	1500mm

TABLE 10

H_3	375mm
T_3	20mm
$T_3/T_2 \times 100$	8.7%
W_1	100mm
W_2	125mm
W_3	50mm
W_4	50mm
W_1/W_2	4/5
W_1+W_2	225mm
$(W_1+W_2)/H_2 \times 100$	30.0%

Example 6

The same rubber compound and two types of

reinforcement members as in Example 5 were used to fabricate a circle-type fender 1 having the sectional shape shown in Figs.5A, 5B as well as dimensions and an angle listed in Table 11. A projection 15 was of a triangular shape in section, having dimensions listed in Table 12.

TABLE 11

T_1	230mm
T_2	230mm
T_1/T_2	1.0
H_0	1000mm
H_1	250mm
H_2	750mm
H_1/H_0	0.25
θ_1	72.5°
D_1	700mm
D_2	1500mm

TABLE 12

H_3	375mm
T_3	40mm
$T_3/T_2 \times 100$	17.4%
W_1	100mm
W_2	125mm
W_1/W_2	4/5
W_1+W_2	2.25mm
$(W_1+W_2)/H_2 \times 100$	30.0%

Comparative Example 3

10 The same rubber compound and two types of

reinforcement members as in Example 5 were used to fabricate a circle-type fender 1 having the conventional sectional shape shown in Fig.22A as well as dimensions and an angle listed in Table 13.

5 TABLE 13

T_1	265mm
T_2	265mm
T_1/T_2	1.0
H_0	1000mm
H_1	250mm
H_2	750mm
H_1/H_0	0.25
θ_1	72.5°
D_1	770mm
D_2	1500mm

Comparative Example 4

The same rubber compound and two types of reinforcement members as in Example 5 were used to fabricate a circle-type fender 1 having a sectional shape shown in Figs.12A, 12B as well as dimensions and an angle listed in Table 14. A projection 15 was of a trapezoidal shape in section, having dimensions listed in Table 15.

10

TABLE 14

T_1	230mm
T_2	230mm
T_1/T_2	1.0
H_0	1000mm
H_1	250mm
H_2	750mm
H_1/H_0	0.25
θ_1	72.5°
D_1	700mm
D_2	1500mm

TABLE 15

H_3	375mm
T_3	20mm
$T_3/T_2 \times 100$	8.7%
W_1	50mm
W_2	175mm
W_3	25mm
W_4	125mm
W_1/W_2	2/7
W_1+W_2	225mm
$(W_1+W_2)/H_2 \times 100$	30.0%

Comparative Example 5

The same rubber compound and two types of reinforcement members as in Example 5 were used to fabricate a circle-type fender 1 having a sectional shape shown in Figs. 13A, 13B as well as dimensions and an angle listed in Table 16. A projection 15 was of a trapezoidal shape in section, having dimensions listed in Table 17.

TABLE 16

T_1	230mm
T_2	230mm
T_1/T_2	1.0
H_0	1000mm
H_1	250mm
H_2	750mm
H_1/H_0	0.25
θ_1	72.5°
D_1	700mm
D_2	1500mm

TABLE 17

H_3	375mm
T_3	20mm
$T_3/T_2 \times 100$	8.7%
W_1	200mm
W_2	25mm
W_3	125mm
W_4	25mm
W_1/W_2	8/1
W_1+W_2	225mm
$(W_1+W_2)/H_2 \times 100$	30.0%

Principal dimensions of the above Examples, Comparative Examples and Comparative Example 1 are tabulated in Table

TABLE 18

	T_2	T_3	$T_3/T_2 \times 100$	H_3	W_1	W_2	W_1/W_2	W_1+W_2	$(W_1+W_2)/H_2 \times 100$
Ex.5	230	20	8.7	375	100	125	4/5	225	30.0
EX.6	230	40	17.4	375	100	125	4/5	225	30.0
CEX.1	230	-	-	375	-	-	-	-	-
CEX.3	265	-	-	375	-	-	-	-	-
CEX.4	230	20	8.7	375	50	175	2/7	225	30.0
CEX.5	230	20	8.7	375	200	25	8/1	225	30.0

The fenders of the above Examples and Comparative Examples were subjected to the aforesaid compressive test. The results are shown in the graph of Fig.14.

- 5 As seen from Fig.14, the fender 9 of Comparative Example 3 having a greater thickness of the first and second bumper members 91, 92 than those of Comparative Example 1 had an increased percentage reaction force of 119% at Maximum Point A based on that of Comparative
- 10 Example 1. It was found, however, that the fender 9 of Comparative Example 3 had a small compressibility of 53% representative of the distortion D. The following was found by continuing the observation of how the compressed fender was deformed. After buckling, the fender 9 of
- 15 Comparative Example 3 assumed the position of Fig.22B with a smaller distortion than Comparative Example 1 and the Examples to be described later, the position wherein the areas 92b, 92c above and below the buckling position BP on the inner periphery of the second bumper member

92 came into contact with each other. This was because, as mentioned supra, the second bumper member 92 was increased in thickness.

The fender 1 of Comparative Example 4 had the
5 projection shifted downward relative to the buckling position BP, had a percentage reaction force of 102% at Maximum Point A based on that of Comparative Example 1, showing little increase in the reaction force. It was also found that the fender 1 of Comparative Example 4
10 had a small compressibility of 58% representative of the distortion D. The examination of a sectional shape of the buckled fender 1 of Comparative Example 4 revealed that the fender was buckled along the upper side of the projection 15, as shown in Fig.12C.

15 The fender 1 of Comparative Example 5 had the projection shifted upward relative to the buckling position BP, had a percentage reaction force of 103% at Maximum Point A based on that of Comparative Example 1, showing little increase in the reaction force. It was
20 also found that the fender 1 of Comparative Example 5 had a small compressibility of 58% representative of the distortion D. The examination of a sectional shape of the buckled fender 1 of Comparative Example 5 revealed that the fender was buckled along the lower side of the
25 projection 15, as shown in Fig.13C.

In contrast, the fenders 1 of Examples 5, 6 both attained increased percentage reaction forces of 110% at Maximum Point A based on that of Comparative Example 1. It was also found that both the fenders of these 5 Examples had a great compressibility of 62 % representative of the distortion D. The examination of sectional forms of the buckled fenders 1 of Examples 5, 6 revealed that the fenders assumed a buckled position, as shown in Figs.4C and 5C, respectively, wherein the 10 second bumper member 12 buckled in a manner to clamp the projection 15. The following was found by continuing the observation of how the compressed fender deformed. After buckling, the fenders 1 of these Examples assumed the respective positions shown in Figs.4C and 5C with 15 a greater distortion D than the Comparative Examples because of the projection 15 clamped in the above manner, the position wherein the areas 12b, 12c above and below the projection 15 on the inner periphery of the second bumper member 12 came into contact with each other. The 20 results are tabulated in Table 19.

TABLE 19

	Increase of percentage reaction force at Max. Point A (%) *2	Compressibility (%) representing distortion D
Ex.5	110	62
Ex.6	110	62
C.Ex.1	100	60
C.Ex.3	119	53
C.Ex.4	102	58
C.Ex.5	103	58

*1: percentage reaction force based on the reaction force of Comparative Example 1 (100%)

Example 7

5 The same rubber compound as in Example 5 and the following two reinforcement members were used to fabricate a circle-type fender 1 having a sectional shape shown in Figs.6A, 6B as well as dimensions and an angle listed in Table 20. A projection 15 was of a trapezoidal shape in section, having dimensions listed in Table 21.

10 A reinforcement member in one end of the first bumper member 11: a disk-like steel plate having a thickness of 28 mm and an outside diameter of 650 mm and including a through hole of inside diameter of 270 mm at its center; and

15 A reinforcement member in the flange 13: the same steel plate as in Example 5

TABLE 20

T_1	220mm
T_2	244mm
T_1/T_2	0.9
H_0	1000mm
H_1	180mm
H_2	820mm
H_1/H_0	0.18
θ_1	75.0°
D_1	680mm
D_2	1500mm

TABLE 21

H_3	410mm
T_3	20mm
$T_3/T_2 \times 100$	8.2%
W_1	100mm
W_2	125mm
W_3	50mm
W_4	50mm
W_1/W_2	4/5
W_1+W_2	225mm
$(W_1+W_2)/H_2 \times 100$	27.4%

Example 8

The same rubber compound and two reinforcement
5 members as in Example 7 were used to fabricate a
circle-type fender 1 having a sectional shape shown in
Figs.15A, 15B as well as dimensions and an angle listed
in Table 22. A projection 15 was of a trapezoidal shape
in section, having dimensions listed in Table 23.

TABLE 22

T_1	220mm
T_2	244mm
T_1/T_2	0.9
H_0	1000mm
H_1	230mm
H_2	770mm
H_1/H_0	0.23
θ_1	75.0°
D_1	680mm
D_2	1500mm

TABLE 23

H_3	380mm
T_3	20mm
$T_3/T_2 \times 100$	8.2%
W_1	100mm
W_2	125mm
W_3	50mm
W_4	50mm
W_1/W_2	4/5
W_1+W_2	225mm
$(W_1+W_2)/H_2 \times 100$	29.2%

Example 9

The same rubber compound and two reinforcement
5 members as in Example 7 were used to fabricate a
circle-type fender 1 having a sectional shape shown in
Figs.16A, 16B as well as dimensions and an angle listed
in Table 24. A projection 15 was of a trapezoidal shape
in section, having dimensions listed in Table 25.

TABLE 24

T_1	220mm
T_2	244mm
T_1/T_2	0.9
H_0	1000mm
H_1	300mm
H_2	700mm
H_1/H_0	0.30
θ_1	70.0°
D_1	680mm
D_2	1500mm

TABLE 25

H_3	350mm
T_3	20mm
$T_3/T_2 \times 100$	8.2%
W_1	100mm
W_2	125mm
W_3	50mm
W_4	50mm
W_1/W_2	4/5
W_1+W_2	225mm
$(W_1+W_2)/H_2 \times 100$	32.1%

Example 10

The same rubber compound and two reinforcement
5 members as in Example 7 were used to fabricate a
circle-type fender 1 having a sectional shape shown in
Figs.17A,17B as well as dimensions and an angle listed
in Table 26. A projection 15 was of a trapezoidal shape
in section, having dimensions listed in Table 27.

TABLE 26

T_1	220mm
T_2	244mm
T_1/T_2	0.9
H_0	1000mm
H_1	100mm
H_2	900mm
H_1/H_0	0.10
θ_1	80.0°
D_1	680mm
D_2	1500mm

TABLE 27

H_3	450mm
T_3	20mm
$T_3/T_2 \times 100$	8.2%
W_1	100mm
W_2	125mm
W_3	50mm
W_4	50mm
W_1/W_2	4/5
W_1+W_2	225mm
$(W_1+W_2)/H_2 \times 100$	25.0%

Comparative Example 6

The same rubber compound and two reinforcement
 5 members as in Example 7 were used to fabricate a
 circle-type fender 1 having a sectional shape shown in
 Figs.18A, 18B as well as dimensions and an angle listed
 in Table 28. A projection 15 was of a trapezoidal shape
 in section, having dimensions listed in Table 29.

TABLE 28

T_1	220mm
T_2	244mm
T_1/T_2	0.9
H_0	1000mm
H_1	180mm
H_2	820mm
H_1/H_0	0.18
θ_1	75.0°
D_1	680mm
D_2	1500mm

TABLE 29

H_3	410mm
T_3	20mm
$T_3/T_2 \times 100$	8.2%
W_1'	35mm
W_2'	260mm
W_3'	110mm
W_4'	210mm

The principal dimensions of the above Examples and Comparative Example are tabulated in Table 30.

TABLE 30

	T_1	T_2	T_3	T_1/T_2	$T_3/T_2 \times$ 100	H_1	H_1/H_0	H_3	W_1	W_2	W_1/W_2	W_1+W_2	$(W_1+W_2)/H_2 \times$ 100
Ex7	220	244	20	0.9	8.2	180	0.18	410	100	125	4/5	225	27.4
Ex8	220	244	20	0.9	8.2	230	0.23	380	100	125	4/5	225	29.2
Ex9	220	244	20	0.9	8.2	300	0.30	350	100	125	4/5	225	32.1
Ex10	220	244	20	0.9	8.2	100	0.10	450	100	125	4/5	225	25.0
CEx6	220	244	20	0.9	8.2	180	0.18	410	(35)	(260)	-	(225)	(27.4)

The fenders of the above Examples and Comparative Example were subjected to the aforesaid compressive test. The results are shown in the graph of Fig.19.

As seen from Fig.19, the fender 1 of Comparative Example 6 had a small compressibility of 58% representative of the distortion D. The fender 1 of Comparative Example 6 had a percentage reaction force of 91% at Minimum Point C based on the reaction force at Maximum Point A, thus showing a small decline in the reaction force after buckling, i.e., after Maximum Point A.

In contrast, all the fenders 1 of Examples 7-10 were determined to have great compressibilities of 67 to 70% representative of the distortion D. The fenders 1 of Examples 7-10 had percentage reaction forces of 91 to 95% at Minimum Point C based on the reaction force at Maximum Point A, thus showing small declines in the reaction force after buckling, i.e., after Maximum Point A.

A comparison of the Examples showed that with increase in the ratio H_1/H_0 and with decrease in the angle θ_1 , the overall energy absorption tends to decline. On the other hand, as the ratio H_1/H_2 decreases and the angle θ_1 increases, the constant load area for the first bumper member 11 becomes smaller. The results are tabulated in

Table 31.

TABLE 31

	Reaction force drop at Min. point C (%) *1	Compressibility (%) representing distortion D
Ex.7	93	70
Ex.8	91	70
Ex.9	94	63
Ex.10	95	67
C.Ex.6	91	58

*1: percentage reaction force based on the reaction force

5 at Maximum Point A



CLAIMS:

1. A fender for absorbing the impact of a vessel, formed of rubber and fixed to a fixing surface of a dock as having an impact receiving plate secured to a distal
5 end of its body, the fender comprising:

a first bumper member formed in a cylindrical shape of a constant outside diameter and defining at one end of the cylindrical body thereof a fixing portion for the impact receiving plate;

10 a second bumper member connected at one end to the other end of the cylindrical body of the first bumper member, defining at the other end thereof a fix portion to be fixed to the fixing surface, formed in a hollow conical shape with its latter end greater in outside
15 diameter than its former end, and buckling radially outwardly upon receiving a compressive force from the vessel thereby absorbing the impact of the vessel; and

a step formed along an outer periphery of a connection portion between the bumper members, the step
20 defined by the former end of the second bumper member having a greater outside diameter than the latter end of the first bumper member.

2. The fender as claimed in Claim 1,

wherein the first bumper member and the second
25 bumper member share the same inside diameter at the



connection portion, and

wherein a ratio T_1/T_2 is in the range of 0.8 to 0.9, T_1 denoting a thickness of the first bumper member, T_2 denoting a thickness of the second bumper member.

5 3. The fender as claimed in Claim 1, wherein a ratio H_1/H_0 is in the range of 0.1 to 0.3, H_1 denoting an axial height of the cylindrical body of the first bumper member, H_0 denoting an overall height of the fender with respect to the axis of the cylindrical body.

10 4. The fender as claimed in Claim 3, wherein an angle θ_1 between the fixing surface and a generatrix of the conical body of the second bumper member is in the range of 70 to 80°.

5. A fender for absorbing the impact of a vessel,
15 formed of rubber and fixed to a fixing surface of a dock as having an impact receiving plate secured to a distal end of its body, the fender comprising:

a first bumper member formed in a cylindrical shape of a constant outside diameter and defining at one end
20 of the cylindrical body thereof a fixing portion for the impact receiving plate;

a second bumper member connected at one end to the other end of the cylindrical body of the first bumper member, defining at the other end thereof a fix portion
25 to be fixed to the fixing surface, formed in a hollow



conical shape with its latter end greater in outside diameter than its former end, and buckling radially outwardly upon receiving a compressive force from the vessel thereby absorbing the impact of the vessel; and

5 a projection having a constant width and formed along a buckling position on an inner periphery of the second bumper member.

6. The fender as claimed in Claim 5, wherein a ratio W_1/W_2 is in the range of 3/6 to 6/3, W_1 denoting a distance
10 from the buckling position to an upper side of the projection along an axis of the conical body of the second bumper member, W_2 denoting a distance from the buckling position to a lower side of the projection along the axis of the conical body.

15 7. The fender as claimed in Claim 6, wherein a distance W_1+W_2 between the upper side and the lower side of the projection along the axis of the conical body is in the range of 20 to 40% of a height H_2 of the second bumper member along the axis of the conical body.

20 8. The fender as claimed in Claim 7, wherein the projection is of a trapezoidal shape in section and has a projection height T_1 from the inner periphery of the second bumper member in the range of 5 to 15% of the thickness T_2 of the second bumper member.

25 9. The fender as claimed in Claim 7, wherein the



projection is of a triangular shape in section and has a projection height T_1 from the inner periphery of the second bumper member in the range of 15 to 20% of the thickness T_2 of the second bumper member.

- 5 10. The fender as claimed in Claim 5, further comprising a step along an outer periphery of a connection portion between the two bumper members, the step defined by the former end of the second bumper member having a greater outside diameter than the latter end of the first bumper
- 10 member.