CLAIMS

[Claim 1]

A method of manufacturing a vacuum thermal insulator, the method comprising:

directly enclosing a core formed of a fiber assembly with an enclosure formed of a laminate film having a gas barrier property;

compressing integrally the core and the enclosure by an external force;

forming a weld sealing portion along at least two sides facing each other of a periphery of the enclosure in a compressed state;

ceasing the compressing after the weld sealing portion is formed; and

depressurizing and sealing the inside of the enclosure after the compressing is ceased.

[Claim 2]

The method of claim 1, wherein in the compressed state, the core has a thickness of 1/10 or less of the thickness before compressing.

[Claim 3]

The method of claim 1 or 2, wherein the weld sealing portion is formed such that a distance from the core is 5 mm or less.

[Claim 4]

A thermal insulating box comprising a vacuum thermal insulator manufactured by the method of any one of claims 1 to 3.

[Claim 5]

A vacuum thermal insulator comprising a core formed of a fiber assembly, and an enclosure enclosing the core in an inside thereof, the inside being depressurized and sealed,

wherein the vacuum thermal insulator is manufactured by the method of any one of claims 1 to 3,

wherein the enclosure has a weld sealing portion at a periphery thereof,

the weld sealing portion is fixed along an outer contour of the core, and

a thickness of the core under an atmospheric pressure when the core is removed from the inside of the enclosure is 10 times or more of a thickness of the vacuum thermal insulator before the core is removed therefrom.

[Claim 6]

The vacuum thermal insulator of claim 5, wherein a distance between the weld sealing portion and the core is 5 mm or less on at least two sides facing each other of the periphery of the enclosure.

[Claim 7]

The vacuum thermal insulator of claim 5 or 6, wherein the fiber assembly is glass wool.

[Claim 8]

The vacuum thermal insulator of any one of claims 5 to 7, wherein the core does not contain a binding agent for binding the fiber assembly.

[Claim 9]

The vacuum thermal insulator of any one of claims 5 to 8, wherein a width of the weld sealing portion is 50 mm or more.

[Claim 10]

A thermal insulating box comprising the vacuum thermal insulator of any one of claims 5 to 9.