

Description

This invention relates to a process and apparatus for preparing self-sealing balloons.

Balloons in various shapes and sizes are sold for use at many social gatherings (eg. children's and Christmas parties) and are used in larger quantities at many promotional or sporting events. Traditionally, balloons are inflated either by blowing into them by mouth or by filling them with helium gas from a large cylinder. The neck of the balloon is then knotted to prevent gas escaping. The knotting operation requires dexterity and becomes all the more tiresome when large quantities of balloons need to be inflated and sealed at, for example, promotional events.

Furthermore, a gas-tight seal can never be achieved simply by tying a knot in the neck of a balloon, since there will always remain a minute passage through which gas can escape.

One known method of overcoming the problem of knotting balloons is to use a plug or spring clip. Spring clips are typically applied to the twisted end of the balloon's neck to pinch or squeeze the end thereby halting gas escape. However, irrespective of the force applied by the spring clip, minute passages still exist in the neck allowing gas to escape. Plugs on the other hand are inserted into the neck of the balloon, but these are unsatisfactory as they rely on a force fit which in turn requires very high manufacturing tolerances to provide a gas-tight seal. Furthermore, the use of plugs and spring clips is in general too expensive and too heavy to be of practical use.

It is now common to seal Mylar balloons by heat. The balloon's neck is subjected to hot pressing which locally melts the neck and forms a seal. This requires expensive machinery and is unsuitable for use with the normal elastomeric toy balloons, since these melt destructively under this treatment.

United States specifications, 4,560,360 (Isaacs *et al*) and 4,516,949 (Schwartz) describe a balloon sealing method in which a seal is made by bringing together opposed inner surfaces of the neck of a balloon which surfaces have previously been coated with a suitable adhesive. Premature sealing is prevented by means of an interior protective insert or strip. In both cases, a tube is inserted into the neck between the protective inserts to allow for the inflation of the balloon. Such balloons are expensive to manufacture since they require extra elements such as protective inserts or strips. Furthermore, considerable manual dexterity is required to remove the inserts or strips once a balloon is inflated.

British Patent Application GB-A-2200299 (published 3rd August 1988) describes a balloon which

can be easily sealed by the use of an adhesive, which can be prepared at low unit cost, which does away with the need for interior protective sheets and which can be adapted to all types of balloons. The balloon described in GB-A-2200299 has at least a portion of its neck turned inside out (i.e. everted) and at least an outer annular part of said portion coated with a contact adhesive such as an untreated latex.

The balloon described in GB-A-2200299 can be sealed after inflation simply by unfolding the neck of the balloon with a pulling action and by pinching the neck. The seal produced is entirely gas tight. The balloon does not require any protective strips, since contact adhesive is, in general, non-adhesive except with itself and premature sealing is prevented by the folding of the neck of the balloon. The balloon has the additional advantage in that it can be reused, since it is possible to break the seal by pulling the opposed surfaces of the neck apart.

US 3108396 also shows a balloon with a folded back portion of the neck which is coated with a pressure-sensitive adhesive. The balloon is sealed by unrolling the neck, and pressing the neck surfaces together.

The present invention provides an apparatus and a process whereby a manual worker, or a machine, can quickly and easily evert at least part of the neck of a balloon, as a preliminary step in the preparation of self-sealing balloons as described in GB-A-2200299.

According to a first aspect of the present invention there is provided a process for everting at least part of the neck of a balloon comprising the steps of

inserting at least an end portion of a mandrel into the neck of a balloon; and

pressing at least a portion of the neck against the mandrel whilst firstly moving the mandrel relative to the balloon in a direction into the balloon body and subsequently moving the mandrel relative to the balloon in a direction out from the balloon body.

The process may be applied to a balloon with a plain neck, but is especially suitable for conventional balloons provided with an annular collar at the open end of the balloon neck. The action of moving the mandrel in a direction into the balloon body causes the neck of the balloon to roll inwardly from the open end. Surprisingly, reversing the movement of the mandrel does not simply reverse the rolling of the neck, but everts the neck.

According to a second aspect of present invention there is provided an apparatus for everting at least part of the neck of a balloon comprising

a mandrel insertable within the neck of the balloon,

pressure applying means for pressing at least a portion of the neck against the mandrel, and means for moving the mandrel in a reciprocating fashion relative to the pressure applying means and in a direction at least along the axis of the mandrel.

Preferably, the pressure applying means comprises one or more biased plates. In a preferred arrangement, the pressure applying means comprises a pair of biased plates. Preferably, the plate is curved, so as to enable the mandrel to be easily located within the pressure applying means. A suitable biasing means may include a spring. An alternative pressure applying means comprises one or more inflatable collars which can surround a portion of the neck of the balloon when mounted on the mandrel.

The apparatus may be provided with means for applying, and optionally drying, a layer of a contact adhesive, such as, for example untreated latex, to at least an outer annular part of the everted neck of the balloon.

Preferably, the mandrel is rotatable about its longitudinal axis. Thus, the rotation of the mandrel will facilitate the application, and optional drying, of the contact adhesive to the everted neck of the balloon.

The apparatus can also be provided with means for inserting a tube within the neck portion of the balloon. The apparatus may be further provided with means for forming the tubes from sheets of suitable flexible material.

The purpose of the tubes is that they prevent the collapse of the necks during inflation and they also ease the folding down of the necks of the balloons during preparation. The tubes may be of a plastics material and may optionally be removed once the balloons are inflated. Plastics tubing is cheap and thus this part may be disposable.

Preferably, the tube extends out of the neck of the balloon. This prevents spittle affecting the contact adhesive, if the balloon is to be mouth inflated. The tube may also be easily removed if it extends out of the balloon. Such a tube is preferably provided with means adapted to form a substantially gas-tight connection with a gas source. Preferably, these means are one part of a bayonet fitting. This arrangement allows for a simple gas tight connection to be made to a suitable gas source such as a helium cylinder.

Preferably, the tube is inserted before the neck portion is everted. This may advantageously be achieved by placing a tube over the end of the mandrel, before the mandrel is inserted into the neck of the respective balloon.

The apparatus may have means for applying a removable protective strip to at least the outer annular portion of the everted neck which has an

applied layer of adhesive.

The removable protective strip prevents a collection of the balloons, when packaged loose together, from sticking together. The strip may simply be removed from the exterior of the balloon's neck prior to inflation. Alternatively, there may be provided an assembly comprising a plurality of balloons each having a tube extending out of its neck wherein the tubes are attached to, or integral with a common member at spaced apart intervals. For example, the tubes may form an integral injection moulded comb provided with frangible portions for the ready removal of individual balloons. An alternative assembly comprises a plurality of balloons, each having a tube extending out of its neck, wherein the balloons form a bandolier-type arrangement, which enables the balloons to be stored in cassette form for the ready removal of individual balloons.

The apparatus may be provided with two or more mandrels, each with respective pressure applying means, and means to move each mandrel in a reciprocating fashion relative to each pressure applying means and in a direction at least along the axis of each mandrel. The provision of such an apparatus enables a large quantity of self-sealing balloons to be prepared at a very low unit cost.

A preferred apparatus comprises a plurality of mandrels supported from a common, movable mandrel head; a plurality of pressure applying means supported on a common, movable block; means to apply a layer of self contact adhesive to at least part of the everted neck of each balloon; means to dry the layer of adhesive; means to secure each everted balloon to a removable protective strip; and means to package the secured, everted balloons in either a comb or a cassette form.

A specific embodiment of an apparatus and process according to the present invention is now described, by way of example only, with reference to the accompanying drawings in which:

Figure 1 is a side elevation of a balloon mounted by its neck on a mandrel for use in the process,

Figure 2 is a perspective view of pressure applying means for use in the process,

Figure 3 is a side elevation of pressure applying means for use in the process, with a mounted balloon located within,

Figure 4 is a side elevation of a balloon having a neck portion everted by the process, while still mounted on a mandrel.

Figure 5 is a side elevation of a balloon having a tube fitted within the everted neck portion of a balloon.

Figure 6 is a perspective view of a plurality of balloons, each mounted on a mandrel, prior to

their insertion into a corresponding number of pressure applying means, and

Figure 7 is a perspective view of the means for packaging balloons having everted neck portions.

Referring to the drawings the apparatus essentially comprises an elongate mandrel 1 and a pressure applying means generally shown as 3.

The mandrel 1 has a tapered end portion (not shown) on which can be mounted a balloon shown generally as 5 in the manner as shown in Figure 1. Balloon 5 has a neck 7 and a body 9. The end of the neck 7 is provided with an annular collar 10.

The pressure applying means 3 comprises a pair of curved plates 11, each pivoted at one end to a frame 13 by means of a suitable hinge 15. Between each of the hinges 15 and the frame 13 is a spring (not shown), which acts against each of the plates 11 and the frame 13. Onto each of the facing surfaces of plates 11 is affixed a thin rubber pad 17. The plates 11 are biased against each other, and thus define a nip 19 between the hinges 15, as shown in Figure 2.

In use, to evert at least a portion of the neck 7 of a balloon 5 the end portion of the mandrel 1 is inserted into the neck 7, in a direction towards the balloon body 9, until the balloon 5 is securely mounted on the mandrel 1 as shown in Figure 1. At this stage, the collar 10 is at a first position along the length of the mandrel 1.

The mandrel 1, with the mounted balloon 5, is then placed into the nip 19, defined by the curved plates 11 of the pressure applying means 3. The mandrel 1 is then moved in a direction towards the free ends of the plates 11. As a result of this movement the free ends of the plates 11 move apart and the rubber pads 17 press against the collar 10 of the mounted balloon 5 in the manner shown in Figure 3. It is apparent that this step can be conducted manually, or by means of a suitable, automated conveyor arrangement (not shown).

Whilst the pads 17 are firmly pressed against the balloon collar 10, the mandrel 1 is moved in a downwards direction, while frame 13 remains in a fixed position. During the initial downward movement, the collar 10 rolls into the neck 7. On a further downward movement, the outer surface of the neck 7 rolls over the collar 10, now within the neck 7. On yet a further downward movement, the outer surface of the neck 11 rolls over itself within the neck. As a result of the downward motion of the mandrel, the neck rolls over itself and so the mandrel advances into the balloon body 9. Thus collar 10 moves in a rolling motion up the mandrel, within the neck 7, to a second position along the length of the mandrel.

The movement of the mandrel is then stopped, and the mandrel is then moved in an upwards

direction, while frame 13 again remains in a fixed position.

During the upward motion of the mandrel 1, the folded neck of the balloon shown generally as 5 begins to fold over itself, as collar 10 rolls over the unfolded portion of the neck 7.

The collar 10 moves in a direction from the second position on the mandrel to the first, and in doing so causes the folded neck portion to evert, as shown in Figure 4.

When at least a part of the neck 7 has been suitably everted the mandrel with the mounted balloon is then moved out from and away from the pressing means. The everted portion of the neck 7 is now ready for the administration of a suitable contact adhesive (ie. an adhesive which bonds to itself), such as, for example, an untreated latex. When the adhesive has been dried by suitable means (not shown) the balloons are simply removed from the mandrel. The balloons are now prepared and ready for use.

It is apparent from the above description that the same eversion process (ie. of everting at least part of the neck of the balloon) can be achieved by fixing the position of the mandrel while allowing the pressing means to move in a reciprocating fashion.

A tube 21 may be fitted within the neck of the balloon as shown in Figure 5. The tube 21 will not only prevent collapse of the balloon neck during inflation, but also prevent spittle affecting the contact adhesive if the balloon is to be inflated by mouth.

One way of fitting a tube within an everted portion of a neck of a balloon is to mount a tube 21 onto the end portion of the mandrel 1, before the mandrel is inserted into the unfolded neck 7 of the balloon 5. In this way, by following the same process described above, at least part of the neck 7 folds and subsequently unfolds over itself along the length of the tube 21. Thus, the everted portion of the neck 7 is mounted on the tube 21, as generally shown in Figure 5.

It is apparent from the above description that the process for everting at least a part of the neck of a balloon can be performed either manually or by machine. However, if large quantities of balloons are required, it is preferable to have a machine which automates the process.

A suitable arrangement for preparing a number of balloons simultaneously is shown in Figure 6. The machine essentially comprises a plurality of juxtaposed mandrels 23, each supported from a common mandrel head 25, and a plurality of juxtaposed pressure applying means 27, each supported on a common block 29.

In use, a number of balloons are mounted onto the end of each respective mandrel 1, which may or may not have a mounted tube. The mandrel

head 25 then swings towards the pressure applying means 27, in the fashion shown in Figure 6, until the collar 10 of each balloon is firmly located between the pair of plates 5 of each pressure applying means. Either the mandrel head 25 or the block 29 then moves in an appropriate reciprocating fashion, as described above. The reciprocating motion causes at least a part of the neck of each balloon to evert in the manner described above.

Once at least part of each neck has been everted, the mandrel head 25 swings away from the pressure applying means. This causes each mounted balloon to disengage from its respective pressure applying means. The everted part of the neck of each balloon, while supported on the mandrel, is now ready for the application of a suitable adhesive, such as, for example, untreated latex.

The adhesive is applied to the everted necks whilst each balloon is rotated, and the adhesive is then dried by suitable means (not shown). It will be appreciated that this method of applying adhesive may be used with any balloon having an everted neck, however prepared. Once the adhesive has dried, each prepared balloon can be removed from its respective mandrel either manually or by machine. However, if large quantities of balloons are required, it is preferable to have a machine which automates this removal stage.

A suitable machine for automating the removal stage is shown in Figure 7. The machine essentially comprises a pair of clamping blocks 31, each having a plurality of recesses 33, and a first web 35 and a second web 37. Webs 35 and 37 run between the clamping blocks 31 in the manner shown in Figure 7.

In use, the mandrel head 25, supporting the prepared balloons, is lowered until the everted parts of the necks of the balloons are located between the webs 35 and 37. Clamping blocks 31 are then moved together, and in doing so the recesses 31 force portions of each of the webs 35 and 37 to entrap the everted neck portions of each prepared balloon. The web portions located between the recesses are then sealed together, for example by suitable heating means (not shown). The prepared balloons are now removably secured to the sealed webs.

When the prepared balloons have been secured to the webs, the mandrel head 25 moves upwards, causing the prepared balloons to become free from the mandrels. The clamping blocks are then moved apart, and the sealed webs are then advanced, thereby allowing fresh web portions to be located between the blocks.

The secured balloons are then packaged in a suitable fashion, such as, for example, in a cassette form or comb (not shown). Such a cassette or comb form allows a person or an automated ma-

chine to inflate a large number of balloons in a small amount of time.

It is of course understood that the present invention has been described purely by way of example only, and modifications of detail can be made within the scope of the invention as defined in the claims. It will also be appreciated that the invention can be adapted for use with any balloon such as, for example, bladders, footballs and cycle inner tubes.

Claims

1. A process for everting at least part of the neck of a balloon comprising the steps of inserting at least an end portion of a mandrel (1) into the neck (7) of a balloon (5); and pressing at least a portion of the neck against the mandrel (1) whilst firstly moving the mandrel (1) relative to the balloon (5) in a direction into the balloon body, and subsequently moving the mandrel (1) relative to the balloon (5) in a direction out from the balloon body.
2. A process according to claim 1 comprising the further step of applying a layer of a contact adhesive to at least an outer annular part of the everted neck (7) of the balloon.
3. A process according to claim 2 comprising the further step of applying a removable protective strip to at least the outer annular part of the everted neck (7).
4. A process according to any of the claims 1 to 3 wherein the balloon (5) has a collar (10) at the open end of the neck (7).
5. Apparatus for everting at least part of a neck of a balloon comprising an elongate mandrel (1) having an end portion insertable within the neck (7) of a balloon (5); and pressure applying means (3; 27) for pressing at least a portion of the neck (7) against the mandrel (1); and means for moving the mandrel (1) in a reciprocating fashion relative to the pressure applying means (3; 27) and in a direction at least along the axis of the mandrel (1).
6. Apparatus as claimed in claims 5 wherein the pressure applying means (3; 27) comprises one or more biased plates (11).
7. Apparatus as claimed in claim 6 wherein the pressure applying means (3; 27) comprises a pair of biased plates (11).

head 25 then swings towards the pressure applying means 27, in the fashion shown in Figure 6, until the collar 10 of each balloon is firmly located between the pair of plates 5 of each pressure applying means. Either the mandrel head 25 or the block 29 then moves in an appropriate reciprocating fashion, as described above. The reciprocating motion causes at least a part of the neck of each balloon to evert in the manner described above.

Once at least part of each neck has been everted, the mandrel head 25 swings away from the pressure applying means. This causes each mounted balloon to disengage from its respective pressure applying means. The everted part of the neck of each balloon, while supported on the mandrel, is now ready for the application of a suitable adhesive, such as, for example, untreated latex.

The adhesive is applied to the everted necks whilst each balloon is rotated, and the adhesive is then dried by suitable means (not shown). It will be appreciated that this method of applying adhesive may be used with any balloon having an everted neck, however prepared. Once the adhesive has dried, each prepared balloon can be removed from its respective mandrel either manually or by machine. However, if large quantities of balloons are required, it is preferable to have a machine which automates this removal stage.

A suitable machine for automating the removal stage is shown in Figure 7. The machine essentially comprises a pair of clamping blocks 31, each having a plurality of recesses 33, and a first web 35 and a second web 37. Webs 35 and 37 run between the clamping blocks 31 in the manner shown in Figure 7.

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When the prepared balloons have been secured to the webs, the mandrel head 25 moves upwards, causing the prepared balloons to become free from the mandrels. The clamping blocks are then moved apart, and the sealed webs are then advanced, thereby allowing fresh web portions to be located between the blocks.

The secured balloons are then packaged in a suitable fashion, such as, for example, in a cassette form or comb (not shown). Such a cassette or comb form allows a person or an automated ma-

chine to inflate a large number of balloons in a small amount of time.

It is of course understood that the present invention has been described purely by way of example only, and modifications of detail can be made within the scope of the invention as defined in the claims. It will also be appreciated that the invention can be adapted for use with any balloon such as, for example, bladders, footballs and cycle inner tubes.

Claims

1. A process for everting at least part of the neck of a balloon comprising the steps of inserting at least an end portion of a mandrel (1) into the neck (7) of a balloon (5); and pressing at least a portion of the neck against the mandrel (1) whilst firstly moving the mandrel (1) relative to the balloon (5) in a direction into the balloon body, and subsequently moving the mandrel (1) relative to the balloon (5) in a direction out from the balloon body.
2. A process according to claim 1 comprising the further step of applying a layer of a contact adhesive to at least an outer annular part of the everted neck (7) of the balloon.
3. A process according to claim 2 comprising the further step of applying a removable protective strip to at least the outer annular part of the everted neck (7).
4. A process according to any of the claims 1 to 3 wherein the balloon (5) has a collar (10) at the open end of the neck (7).
5. Apparatus for everting at least part of a neck of a balloon comprising an elongate mandrel (1) having an end portion insertable within the neck (7) of a balloon (5); and pressure applying means (3; 27) for pressing at least a portion of the neck (7) against the mandrel (1); and means for moving the mandrel (1) in a reciprocating fashion relative to the pressure applying means (3; 27) and in a direction at least along the axis of the mandrel (1).
6. Apparatus as claimed in claims 5 wherein the pressure applying means (3; 27) comprises one or more biased plates (11).
7. Apparatus as claimed in claim 6 wherein the pressure applying means (3; 27) comprises a pair of biased plates (11).



8. Apparatus as claimed in any of claims 5 to 7 wherein the or each plate (11) is curved.

9. Apparatus as claimed in any of claims 5 to 8 wherein the or each plate (11) is biased by means of a hinge (15) and spring arrangement.

10. Apparatus according to any of claims 5 to 9 comprising a plurality of said elongate mandrels (1) and corresponding pressure means (27).

11. Apparatus as claimed in claim 10 wherein each mandrel (1) is supported from a common, movable mandrel head (25), and each pressure applying mean (27) is supported on a common, movable block (29).

12. Apparatus as claimed in any of claims 5 to 11, further comprising means for applying and optionally drying an adhesive to the everted portion of the or each neck.

13. Apparatus as claimed in any of claims 5 to 12 wherein a tube (21) is located over the end of the or each mandrel (1) before the or each mandrel is inserted into the neck (7) of the or each respective balloon (5).

14. Apparatus as claimed in any of claims 5 to 13, further comprising means for applying a removable, protective strip to at least the portion of the or each everted neck (7).

15. Apparatus as claimed in any of claims 5 to 14, further comprising means for packaging the or each balloon secured to the protective strip.

16. A process according to claim 2 or claim 3 wherein the adhesive is applied by a method comprising rotating the mandrel (1) with the balloon (5) thereon, and applying said adhesive to said everted neck (7) from a stationary source adjacent to the mandrel (1).

17. A process according to any one of claims 1 to 4 or claim 16 wherein the necks (7) of a number of balloons (5) are everted and the everted balloons are attached to a web by a method comprising disposing the necks (7) of said balloons mounted on the mandrels (1) between two webs (35, 37) and sealing the two webs (35, 37) to each other in the region between adjacent balloons.

Patentansprüche

1. Verfahren zum Ausbringen bzw. Umlegen wenigstens eines Teils des Halses eines Ballons, mit den Schritten:

Einführen wenigstens eines Endabschnitts eines Dorns (1) in den Hals (7) eines Ballons (5); und

Pressen wenigstens eines Abschnitts des Halses gegen den Dorn (1) während der Dorn (1) zuerst relativ zum Ballon (5) in einer Richtung in den Ballonkörper hinein bewegt wird, und nachfolgendes Bewegen des Dorns (1) relativ zum Ballon (5) in einer Richtung aus dem Ballonkörper heraus.

2. Verfahren nach Anspruch 1, mit dem weiteren Schritt des Aufbringens einer Schicht eines Kontaktklebers auf wenigstens einen äußeren ringförmigen Teil des umgelegten Halses (7) des Ballons.

3. Verfahren nach Anspruch 2, mit dem weiteren Schritt des Aufbringens eines entfernbaren Schutzstreifens auf wenigstens den äußeren ringförmigen Teil des umgelegten Halses (7).

4. Verfahren nach einem der Ansprüche 1 bis 3, wobei der Ballon (5) einen Kragen (10) an dem offenen Ende des Halses (7) hat.

5. Vorrichtung zum Ausbringen bzw. Umlegen wenigstens eines Teils eines Halses eines Ballons, mit einem langgestreckten Dorn (1) mit einem Endabschnitt, der in den Hals (7) eines Ballons (5) einsetzbar ist; und einer Druck-Aufbringeinrichtung (3; 27) zum Pressen wenigstens eines Abschnitts des Halses (7) gegen den Dorn (1); und einer Einrichtung zum Bewegen des Dorns (1) in einer hin- und hergehenden Weise relativ zu der Druck-Aufbringeinrichtung (3; 27) und in einer Richtung wenigstens längs der Achse des Dorns (1).

6. Vorrichtung nach Anspruch 5, wobei die Druck-Aufbringeinrichtung (3; 27) eine oder mehrere vorgespannte Platten (11) aufweist.

7. Vorrichtung nach Anspruch 6, wobei die Druck-Aufbringeinrichtung (3; 27) ein paar von vorgespannten Platten (11) aufweist.

8. Vorrichtung nach einem der Ansprüche 5 bis 7, wobei jede Platte (11) gekrümmt ist.

9. Vorrichtung nach einem der Ansprüche 5 bis 8, wobei die oder jede Platte (11) vorgespannt



ist durch ein Gelenk (15) und eine Federanordnung.

10. Vorrichtung nach einem der Ansprüche 5 bis 9, mit einer Vielzahl von langgestreckten Dornen (1) und entsprechenden Druckeinrichtungen (27). 5
11. Vorrichtung nach Anspruch 10, wobei jeder Dorn (1) getragen ist von einem gemeinsamen beweglichen Dornkopf (25), und jede Druckaufbringeinrichtung (27) gehalten ist auf einem gemeinsamen beweglichen Block (29). 10
12. Vorrichtung nach einem der Ansprüche 5 bis 11, ferner mit einer Einrichtung zum Aufbringen und gewünschtenfalls Trocknen eines Klebstoffs auf dem umgelegten Abschnitt des oder jedes Halses. 15
13. Vorrichtung nach einem der Ansprüche 5 bis 12, wobei ein Rohr (21) über dem Ende des oder jedes Dorns (1) angeordnet ist, bevor der oder jeder Dorn in den Hals (7) des oder jedes jeweiligen Ballons (5) eingesetzt ist. 20
14. Vorrichtung nach einem der Ansprüche 5 bis 13, ferner mit einer Einrichtung zum Aufbringen eines entfernbaren Schutzstreifens auf wenigstens den Abschnitt des oder jedes ausgebrachten Halses (7). 25
15. Vorrichtung nach einem der Ansprüche 5 bis 14, ferner mit einer Einrichtung zum Packen des oder jedes Ballons, der an dem Schutzstreifen angebracht ist. 30
16. Verfahren nach Anspruch 2 oder Anspruch 3, wobei der Klebstoff durch ein Verfahren aufgebracht wird, das aufweist das Drehen des Dorns (1) mit dem Ballon (5) darauf, und das Aufbringen des Klebstoffs auf den ausgebrachten Hals (7) von einer stationären Quelle in der Nähe des Dorns (1). 35
17. Verfahren nach einem der Ansprüche 1 bis 4 oder Anspruch 16, wobei die Hälse (7) einer Anzahl von Ballons (5) ausgebracht werden und die ausgebrachten Ballons durch ein Verfahren an einem Gewebe bzw. einer Bahn befestigt werden, welches aufweist das Anordnen der Hälse (7) der Ballons, die an den Dornen angebracht sind, zwischen zwei Bahnen (35, 37) und Abdichten bzw. Verbinden der beiden Bahnen (35, 37) miteinander in dem Bereich zwischen benachbarten Ballons. 40

Revendications

1. Un procédé pour retourner au moins une partie du col d'un ballon comprenant les étapes consistant à insérer au moins une partie d'extrémité d'un mandrin (1) dans le col (7) d'un ballon (5); et à pousser au moins une partie du col contre le mandrin (1) tout en déplaçant tout d'abord le mandrin (1) par rapport au ballon (5) dans une direction dans le corps du ballon et à déplacer ultérieurement le mandrin (1) par rapport au ballon (5) dans une direction à l'extérieur du corps du ballon. 10
2. Un procédé selon la revendication 1 comprenant l'étape supplémentaire consistant à appliquer une couche d'un adhésif de contact à au moins une partie annulaire extérieure du col retourné (7) du ballon. 15
3. Un procédé selon la revendication 2 comprenant l'étape supplémentaire consistant à appliquer une bande protectrice amovible à au moins la partie annulaire extérieure du col retourné (7). 20
4. Un procédé selon l'une quelconque des revendications 1 à 3 dans lequel le ballon (5) comporte un collier (10) à l'extrémité ouverte du col (7). 25
5. Appareil pour retourner au moins une partie d'un col d'un ballon comprenant un mandrin allongé (1) ayant une partie d'extrémité susceptible d'être insérée dans le col (7) d'un ballon (5); et des moyens d'application de pression (3, 27) pour pousser au moins une partie du col (7) contre le mandrin (1); et des moyens pour déplacer le mandrin (1) selon un mouvement de va-et-vient par rapport aux moyens d'application de pression (3, 27) dans une direction au moins le long de l'axe du mandrin (1). 30
6. Appareil selon la revendication 5 dans lequel les moyens d'application de pression (3, 27) comprend une ou plusieurs plaques sollicitées (11). 35
7. Appareil selon la revendication 6 dans lequel le moyen d'application de pression (3, 27) comprend deux plaques sollicitées (11). 40
8. Appareil selon l'une quelconque des revendications 5 à 7 dans lequel la plaque ou chaque plaque (11) est incurvée. 45



9. Appareil selon l'une quelconque des revendications 5 à 8 dans lequel la plaque ou chaque plaque (11) est sollicitée au moyen d'une articulation (15) et d'un agencement à ressort. 5
10. Appareil selon l'une quelconque des revendications 5 à 9 comprenant une pluralité desdits mandrins allongés (1) et du moyen d'application de pression correspondant (27). 10
11. Appareil selon la revendication 10 dans lequel chaque mandrin (1) est supporté à partir d'une tête de mandrin mobile commune (25) et chaque moyen d'application de pression (27) est supporté sur un bloc mobile commun (29). 15
12. Appareil selon l'une quelconque des revendications 5 à 11 comprenant, en outre, des moyens pour appliquer et sécher facultativement un adhésif sur la partie retournée du col ou de chaque col. 20
13. Appareil selon l'une quelconque des revendications 5 à 12 dans lequel un tube (21) est disposé sur l'extrémité du mandrin ou de chaque mandrin (1) avant que le mandrin ou chaque mandrin soit inséré dans le col (7) du ballon ou de chaque ballon respectif (5). 25
14. Appareil selon l'une quelconque des revendications 5 à 13 comprenant, en outre, des moyens pour appliquer une bande protectrice amovible à au moins la partie du col retourné ou de chaque col retourné (7). 30
15. Appareil selon l'une quelconque des revendications 5 à 14 comprenant en outre, des moyens pour conditionner le ballon ou chaque ballon fixé à la bande protectrice. 35
16. Un procédé selon la revendication 2 ou la revendication 3 dans lequel l'adhésif est appliqué par un procédé consistant à faire tourner le mandrin (1) avec le ballon (5) sur celui-ci et à appliquer ledit adhésif audit col retourné (7) à partir d'une source fixe contiguë au mandrin (1). 40
17. Un procédé selon l'une quelconque des revendications 1 à 4 ou selon la revendication 16 dans lequel les cols (7) de plusieurs des ballons (5) sont retournés et les ballons retournés sont fixés à une bande par un procédé comprenant l'amenée des cols (7) desdits ballons montés sur les mandrins (1) entre deux bandes (35, 37) et le scellement des deux bandes (35, 37) l'une par rapport à l'autre dans la zone entre les ballons contigus. 45 50 55

