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(54) **Title:** METHOD OF MAKING FLEXIBLE TUBING WITH EMBEDDED WIRE CONDUCTOR

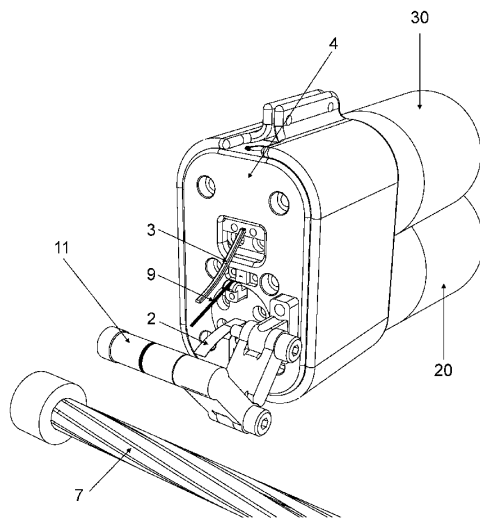


FIGURE 2

(57) **Abstract:** The present invention disclosed different possible arrangements of the tool die design for manufacturing the flexible heated tubing embedded with at least one or more electrically heated conductor or conductive wires. It employs a winding roll mechanism that facilitates an extrusion of a flat plastic ribbon and an extruded helix that is overlapping the plastic ribbon in which the helix is embedded with at least one or more electrically heated conductor or conductive wires. The plastic ribbon itself is helically wrapped such that its edges overlap and is simultaneously bonded by heat together to form the wall of the flexible tubing.

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