

ABSTRACT

The present invention relates to the field of flexible medical tubing embedded with or without at least one or more electrically heated conductor or conductive wires. It disclosed a method for creating texture on the surface of the flexible tubing during the extrusion process. More specifically, it disclosed a method that uses a roller that permits texturing on the outer surfaces of the extruded helix which overlaps on the extruded flat plastic ribbon, whereby the helix is embedded with at least one or more electrically conductive wire. The roller's surface has texture on it and is placed next to the extrusion mandrel facing opposite the tool die where the helix is being extruded out such that the roller will transfer a texture to the surface of the extruded helix by virtue of pressure applied to the extrudate (helix). Concurrently this pressure action will also enable the extrudate (helix) to have better bonding over the electrically conductive wire.

Use **Figure 2**.