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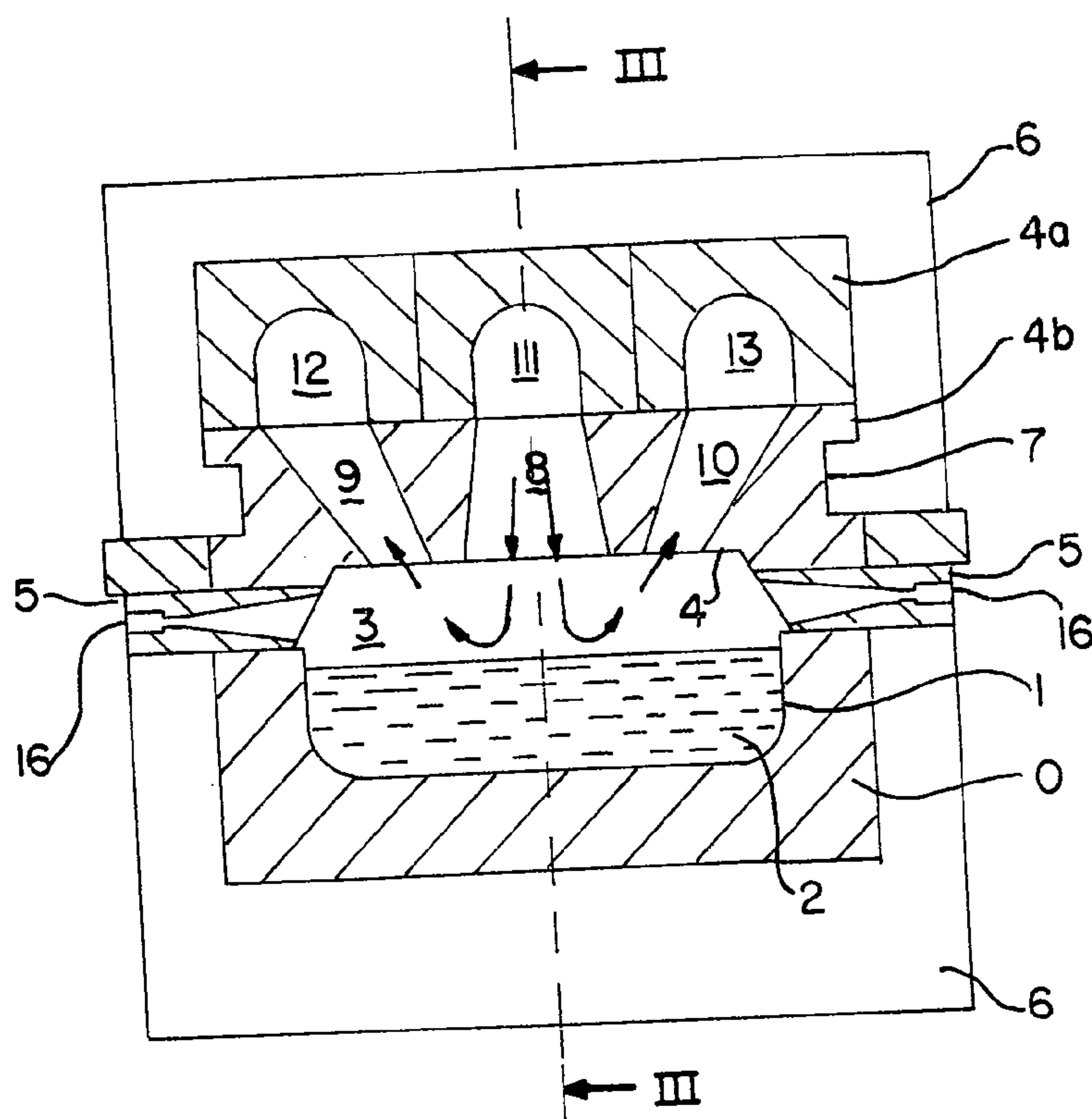
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(54) **METHODE ET DISPOSITIF D'UNIFORMISATION DE LA  
TEMPERATURE DANS L'AVANT-CREUSET POUR LA  
FABRICATION DU VERRE**

(54) **METHOD AND APPARATUS FOR EQUALIZATION OF  
TEMPERATURE IN A FOREHEARTH IN GLASS  
MANUFACTURE**



(57) The invention provides a method and apparatus for equalizing the temperature of molten glass (2) over the cross-section of a stream thereof advancing through a refractory forehearth from a glass furnace to a glass working machine. To this end, cooling air is blown downwardly to strike the mid-line of the stream, and is then evacuated upwardly from locations on either side of the mid-line, in such manner that substantial side regions of the stream surface are preserved from cooling contact with the cooling air. Apparatus for this purpose comprises refractory blocks (4a, 4b) which can be assembled to form a forehearth superstructure or roof, the blocks having hollow formations which unite on assembly thereof to form feed (11) and return (12, 13) channels for the cooling air, as well as inlet (8) and exhaust (9, 10) ducts for directing it at the molten glass and recovering it thereafter.



ABSTRACT

The invention provides a method and apparatus for equalizing the temperature of molten glass (2) over the cross-section of a stream thereof advancing through a refractory forehearth from a glass furnace to a glass working machine. To this end, cooling air is blown downwardly to strike the mid-line of the stream, and is then evacuated upwardly from locations on either side of the mid-line, in such manner that substantial side regions of the stream surface are preserved from cooling contact with the cooling air. Apparatus for this purpose comprises refractory blocks (4a, 4b) which can be assembled to form a forehearth superstructure or roof, the blocks having hollow formations which unite on assembly thereof to form feed (11) and return (12, 13) channels for the cooling air, as well as inlet (8) and exhaust (9, 10) ducts for directing it at the molten glass and recovering it thereafter.

This invention relates generally to a method and apparatus for equalizing the temperature over the cross-section of a parallel-sided stream of molten glass having a free surface and advancing along a tunnel. It relates in particular to a method and apparatus for equalizing the temperature, and hence the viscosity, of molten glass in a forehearth of the type commonly used for conveying molten glass from a melting furnace to a glass working machine, especially in the glass vessel manufacturing industry, such a forehearth being referred to hereinafter as a forehearth of the type described.

The chief purpose of a forehearth of the type described is to equalize the temperature of an advancing stream of molten glass over the cross-section thereof so that the glass on exit, where it is extruded from a feeder bowl and cut into standardised gobs (or mould charges) which are then fed to a glassware forming machine, shall be of a substantially unvarying temperature, and thus of constant viscosity,

for the duration of a moulding run; each gob of glass in consequence shall have a substantially uniform temperature in all of its parts.

05 A forehearth of the type described often comprises a plurality of zones in series, usually including at least one cooling zone, and terminates, at the entrance to the moulding machine, in an equalizing zone which has heating only. There are many known variations on this basic layout, in forehearths of the  
10 type described.

In an earlier state of the art than prevails today, foreheaths of the type described advanced the molten glass along a tunnel of refractory material in a slow-moving stream wherein the glass in the outer or  
15 edge regions, adjoining the refractory material, tended to lose heat faster and to cool more quickly than the glass in the central regions. For this reason, heating means such as gas or oil burners, or submersible electrodes, have been provided for heating  
20 the glass at the sides of the forehearth.

Modern multi-mould glass working machines, such as glass vessel moulding machines, typically consume molten glass at a much greater rate than their predecessors of the 1940's and 1950's did. Such high  
25 rates of consumption (high pulls) mean a faster flow of molten glass through the forehearth, so that, irrespective of the means adopted or the method used for equalizing temperature throughout the glass stream, any given cross-section of the stream is  
30 exposed to said means or subjected to said method for a much shorter time than used to be the case.

05 One way of compensating for these developments would be to employ a substantially longer forehearth, in which accordingly the dwell time of the glass would be greater, and the older (and, it must be said, less efficient) methods and means for equalizing temperature would have more time to operate, and thus a greater chance of being effective. The length needed would be up to twice what was common in earlier practice.

10 Unfortunately the design of furnaces and glass working machines and, in particular, the dimensions and layout of existing glass factories make it prohibitively expensive to lengthen the forehearths. The problem thus presents itself of equalizing the temperature  
15 over the cross-section of a relatively fast-flowing stream of molten glass in a forehearth of merely conventional length.

20 It is known to provide a current of cooling air, blown into the forehearth either in the direction of glass flow or transversely thereof, in an effort to cool the mid-region of the stream. Such air currents tend, however, to reduce the efficiency of the burners. They are also difficult to confine to the mid-region of the glass stream; this feature leads to cooling in  
25 undesired places, and increased costs.

30 Thus US Patent No 2 767 518 discloses a forehearth wherein a blast of cold air is supplied through refractory tubes 15 (fig 2) to the center of the glass channel above the surface of the glass. The cooling air from said tubes 15, however, passes out of the heating chamber 17 through the flues 12 together with the products of combustion from the burners, so that

the cooling effect is not confined to the midstream glass and in fact, directly opposes the heating effect of the burners.

05 It is also known, and described in US Patent 3 999  
972, to provide a forehearth having a roof with two  
longitudinal ridges extending downwardly therefrom, so  
as to define a channel over the central portion of the  
stream of molten glass, and a respective side channel,  
10 on either side of said central channel, over a  
respective side portion of the stream, and to provide  
means for feeding a cooling gas along the central  
channel in contact with the upper surface of the  
glass, between inlet and outlet apertures in the roof,  
longitudinally spaced apart, while simultaneously  
15 providing means for applying heat to the side portions  
of the glass stream. However, the cooling gas (air)  
because of its greater density tends to spread  
outwardly and cool the glass in the side portions of  
the stream, and/or interfere with the application of  
20 heat to said side portions.

It is known furthermore, and described in US Patent  
4 680 051, to provide a forehearth having at least one  
cooling zone which includes a trough and a refractory  
roof over the trough, from which roof a pair of spaced  
25 projections extend downwardly to define a central  
channel over the molten glass and side channels over  
respective side portions of the molten glass. The  
roof has an area of reduced thickness in the portion  
over the central channel. An enclosed upper cooling  
30 channel extends longitudinally over the area of  
reduced thickness and has an inlet, and an outlet  
spaced from the inlet. Heating means are provided for  
each side portion of the forehearth. This known  
system removes the cooling air from direct contact

with the glass, so that cooling takes place mainly by radiation from the molten glass to the refractory roof, followed by conduction away through the refractory material. Refractories are often poor  
05 conductors, however, and so the apparatus is subject to only coarse control and responds very slowly to adjustments.

It is an object of the invention to remove or alleviate at least some of the aforesaid  
10 disadvantages. Another object is to provide a forehearth of the type described with more efficient gas or air cooling than known forehearths. A third object is to reduce or even eliminate the need for heat input to a forehearth by reason of the attainment  
15 of temperature homogeneity through cooling alone. A further object is to provide a forehearth the operation of which returns substantial savings as compared with current practice and conventional forehearths. A particular object is to equalize the  
20 temperature over the cross-section of a relatively fast-flowing stream of molten glass in a forehearth of merely conventional length.

In the development of the present invention it was recognized that centre cooling and side heating was a  
25 more efficient method to achieve efficiency and good temperature homogeneity at the forming machine. It was also recognised that cooling air contact with the glass surface in the centre of the channel with the minimum opportunity for the cooling air and combustion  
30 products to mix, or for cooling to occur at the sides, might be a more efficient system and might give the required temperature homogeneity at the glass forming stage.

The first step undertaken was to introduce a side firing system which had a large turndown ratio. A proprietary high pressure gas system was selected; this incorporates a fluegas air damper which can be adjusted to keep the forehearth combustion/cooling zone under slightly positive pressure. The cooling air is introduced at the rear of the zone and fed by way of a channel in the centre, the length of the zone, above the roof blocks. As the cooling air passes along this centre channel, it escapes through openings provided in the roof so that the cooling air blows directly onto the centre of the molten glass surface in the chamber below. These openings in the roof structure are slightly wider at the bottom than at the top. On either side of each of these openings, there is a respective other opening to allow the cooling air and combustion products to exit from the chamber. This reduces to a minimum the time available for mixing of the cooling air and combustion products and so prevents the cooling air from cooling the glass near the side wall. Likewise, since the combustion products can exit along the side of the chamber, minimum heating of the centreglass occurs. These side exits communicate with two channels running the length of the zone, above the roof structure, which meet at the front of the zone in a common, air-damped, flue. This allows a controlled equal back pressure to be applied to both channels. The heating and cooling are controlled automatically, with a minimum of applied heating and cooling at all times. When the zone is at well below the set temperature, high firing is employed, with a minimum of applied cooling, or none. As the set temperature is approached, the firing automatically decreases until at the set temperature the cooling and firing are both at a minimum. If the temperature continues to rise, the controls

automatically increase the applied cooling, while the firing remains at a minimum. The minimum firing and cooling is set by monitoring a new feeder for a short period of time, at different minimum settings. In  
05 fact for high pulls (high rates of glass production) it is often found with this invention that no firing is required.

The difference between the invented method and apparatus and others in use, is the introduction of  
10 air directly to the centre of the glass and its removal as quickly as possible, which allows rapid cooling at the centre, while a high temperature is maintained at the sides.

The invention accordingly provides, in a parallel-sided stream of molten glass having a free surface and advancing along and in a tunnel, a method of equalizing the temperature of the glass over the  
15 cross-section of the stream by local cooling, which method comprises directing at least one current of cooling air downwardly to strike the mid-line of the stream, and at the same time evacuating air upwardly  
20 from two locations one on either side of the current of cooling air, the airflow conditions being adapted to preserve substantial lateral regions of the stream  
25 from cooling contact with the current of cooling air.

The invention likewise provides apparatus for performing the above method, which apparatus comprises a forehearth roofed with refractory blocks having cavities which, in the assembled state of the roof,  
30 unite to constitute one enclosed central longitudinal feed channel for incoming cooling air, and at least two enclosed lateral longitudinal exhaust channels for spent cooling air, the channels communicating with the

airspace or chamber over the molten glass by means of air ducts. Preferably, a refractory block is elongate and parallelepipedal having, in use, an upper face, a lower face and two sides, as well as two ends, and  
05 defines three air channel sections extending in parallel from one side to the other. Preferably the refractory blocks if laid side to side produce a layer of blocks with three air channels extending the length of the layer; these channels are preferably terminated  
10 by refractory blocks of special design. Another special block connects the central channel to a cooling air input location, and at least one further special block interconnects the two exhaust channels and connects them to an exhaust flue location.

15 The air ducts are preferably defined by the approximation of matched surface recesses provided in the sides of adjacent refractory blocks. Preferably the recessed blocks in question form a discrete layer underlying those blocks which form the three air  
20 channels, the recesses being dimensioned and disposed so as to provide ducts which communicate with the respective channels, to constitute air feed ducts when they communicate with the central channel, and air exhaust ducts when they communicate with either of the  
25 two other channels (the exhaust channels). Preferably the matched surface recesses are of tapered configuration, each feed duct expanding from the feed channel towards the molten glass in use, while each exhaust duct expands from the molten glass towards the  
30 respective exhaust channel.

Preferably the disposition of the feed ducts is such that in use the cooling air is fed perpendicularly to the free surface of the molten glass in a current which splits "right and left" on striking said

surface. Preferably the main axes of the exhaust ducts are inclined so as to facilitate the uptake of air from said split air current.

05 The invention will be understood in greater detail from the following description of a particular and preferred embodiment thereof, given by way of example only, with reference to the accompanying drawings, in which

10 Fig 1 is a schematic plan view of a forehearth superstructure with an upper layer of refractory blocks stripped away;

15 Fig 2 is a schematic cross-section of a forehearth incorporating the superstructure of Fig 1, taken along the line II-II in that figure and viewed in the direction of the associated arrows, but with said upper layer of refractory blocks back in place;

20 Fig 3 is a schematic part section, in side elevation, of the forehearth of Fig 2, taken along the line III-III in that figure and viewed in the direction of the associated arrows; and

25 Fig 4 is a perspective view of three refractory blocks, one (4a) taken from the upper layer and two (4b) from the lower layer of the forehearth of Figs 2 and 3; one of the latter is only partly represented.

30 Referring now to the drawings, a forehearth comprises refractory materials 0 (figs 2 & 3) defining a trough 1 for molten glass 2, and an airspace or chamber 3 thereover, limited by a ceiling 4. The ceiling 4 is formed by a file of refractory blocks 4b laid side by side in mutual contact, each bridging the trough 1, supported on side blocks 5 and keyed into an outer

envelope 6 of refractory material by means of an end  
formation 7 on each end of each block 4b, and a  
complementary formation on the inside of the outer  
envelope 6, which formations interengage. The  
05 formations 7, however, primarily serve to facilitate  
handling of the blocks 4b during construction of the  
forehearth superstructure.

Each of the ceiling blocks 4b is provided on its side  
faces with respective complementary recesses 8a, 9a  
10 10a which, when the blocks 4b are laid side by side,  
combine to form, between each pair of blocks 4b, an  
air feed duct 8 and two air exhaust ducts 9, 10. Thus  
in use the ceiling presents repeated transversely  
oriented groups of three air ducts 9, 8, 10, the  
15 groups being spaced apart at 20 cm centres longitud-  
inally of the trough 1, where 20 cm is the standard  
width of the block 4b.

Above the ceiling blocks 4b rests a layer of  
refractory channel blocks 4a, each presenting three  
20 parallel round-topped, downwardly open channels 12a,  
11a, 13a, and all enclosed in the outer envelope 6.  
In use, the blocks 4a lie side to side so as to create  
three parallel elongate air channels 12, 11, 13, and  
lie upon the upper faces of the ceiling blocks 4b so  
25 as to enclose said channels except at their ends.  
Special refractory blocks 4c are provided to close the  
ends of the channel 11 and another refractory block 4d  
having a top perforation 14 is provided for connecting  
the channel 11 to a source of cooling air under  
30 positive pressure. Special refractory blocks 4e are  
provided to close one end of each of channels 12 and  
13 and a further refractory block aggregate 4f to  
unite their respective other ends and for connecting  
said channels 12 and 13 to an exhaust flue 15. The

layout of channels 11, 12, 13, blocks 4c, 4d, 4e and 4f, top perforation 14 and flue 15 are indicated in Fig 1 by means of broken outlines to assist comprehension.

05 The side blocks 5 house spaced-apart lateral gas burners 16 for heating the glass at the sides of the forehearth.

In use, an air pressure difference is created as  
10 between air in the feed channel 11 on the one hand,  
and the exhaust channels 12, 13 on the other,  
sufficient to produce a cooling current which proceeds  
downwardly from the feed ducts 8, strikes the surface  
of the stream of glass in the middle, fans out and  
15 circulates back to be substantially removed through  
the exhaust ducts 9, 10 as spent or heated air. This  
circulation is depicted by the six arrows in the  
central region of Fig 2. It is substantially confined  
to the central region of the surface of the stream of  
molten glass 2 by reason of the geometry of the feed  
20 and exhaust ducts 8 and 9, 10 respectively. As a  
result, the air over the lateral regions of the molten  
glass stream remains substantially undisturbed,  
leading in turn to a reduced heat requirement in those  
regions and, in favourable cases, to the elimination  
25 of the need for the use of the gas burners 16.  
Favourable cases include production runs with high  
pulls (ie high rates of glass production).

Claims

1. In a parallel-sided stream of molten glass (2) having a free surface and advancing along and in a tunnel (1), an improved method of equalizing the temperature of the glass over the cross-section of the stream by local cooling, wherein the improvement comprises directing at least one current of cooling air downwardly to strike the mid-line of the stream, and at the same time evacuating air upwardly from two locations one on either side of the current of cooling air, the airflow conditions being adapted to preserve substantial side regions of the stream surface from cooling contact with the current of cooling air.

2. A method according to claim 1, wherein several currents of cooling air, each disposed in a plane transverse to the direction of flow of the stream of glass, are arranged spaced apart along the midline of said stream.

3. A method according to claim 1, wherein the cooling air is fed perpendicularly to the free surface of the molten glass in a current which splits "right and left" on striking said surface.

4. A method according to claim 3, wherein the air from the locations on either side of the current of cooling air is evacuated in a direction inclined to that of the cooling air incident current, so as to facilitate the uptake of air from said split air current.

5. Apparatus for use in performing the method according to claim 1, which apparatus comprises a forehearth roofed with refractory blocks (4a, 4b) containing cavities (8a - 13a) which, in the assembled state of the roof, unite to define one enclosed central longitudinal feed channel (11) for incoming cooling air, and at least two enclosed lateral longitudinal exhaust channels (12, 13) for spent cooling air, the channels communicating with the airspace or chamber (3) over the molten glass (2) by means of air ducts (8 - 10).

6. Apparatus according to claim 5, wherein each refractory block (4a) is elongate and parallelepipedal having, in use, an upper face, a lower face and two sides, as well as two ends, and defines three air channel sections extending in parallel from one side to the other.

7. Apparatus according to claim 5 wherein the refractory blocks (4a) are laid side to side so as to produce a layer of blocks with three air channels (11 - 13) extending the length of the layer, and

adapted for connection of a cooling air input (14) to the central channel and for connection of an exhaust flue (15) to the other two channels.

8. Apparatus according to claim 5 wherein the air ducts (8 - 10) are defined by surface recesses (8a - 10a) in the sides of refractory blocks (4b) in a discrete layer underlying those refractory blocks (4a) which define the channels (8 - 10) for incoming and spent cooling air.

9. Apparatus according to claim 8, wherein the air ducts (8 - 10) are defined by the approximation of matched surface recesses (8a - 10a) provided in the sides of adjacent blocks (4b).

10. Apparatus according to claim 9, wherein the matched surface recesses (8a - 10a) are of tapered configuration, so that each feed duct (8) expands from the feed channel (11) towards the molten glass (2) in use, while each exhaust duct (9, 10) expands from the molten glass (2) towards the respective exhaust channel (12, 13).

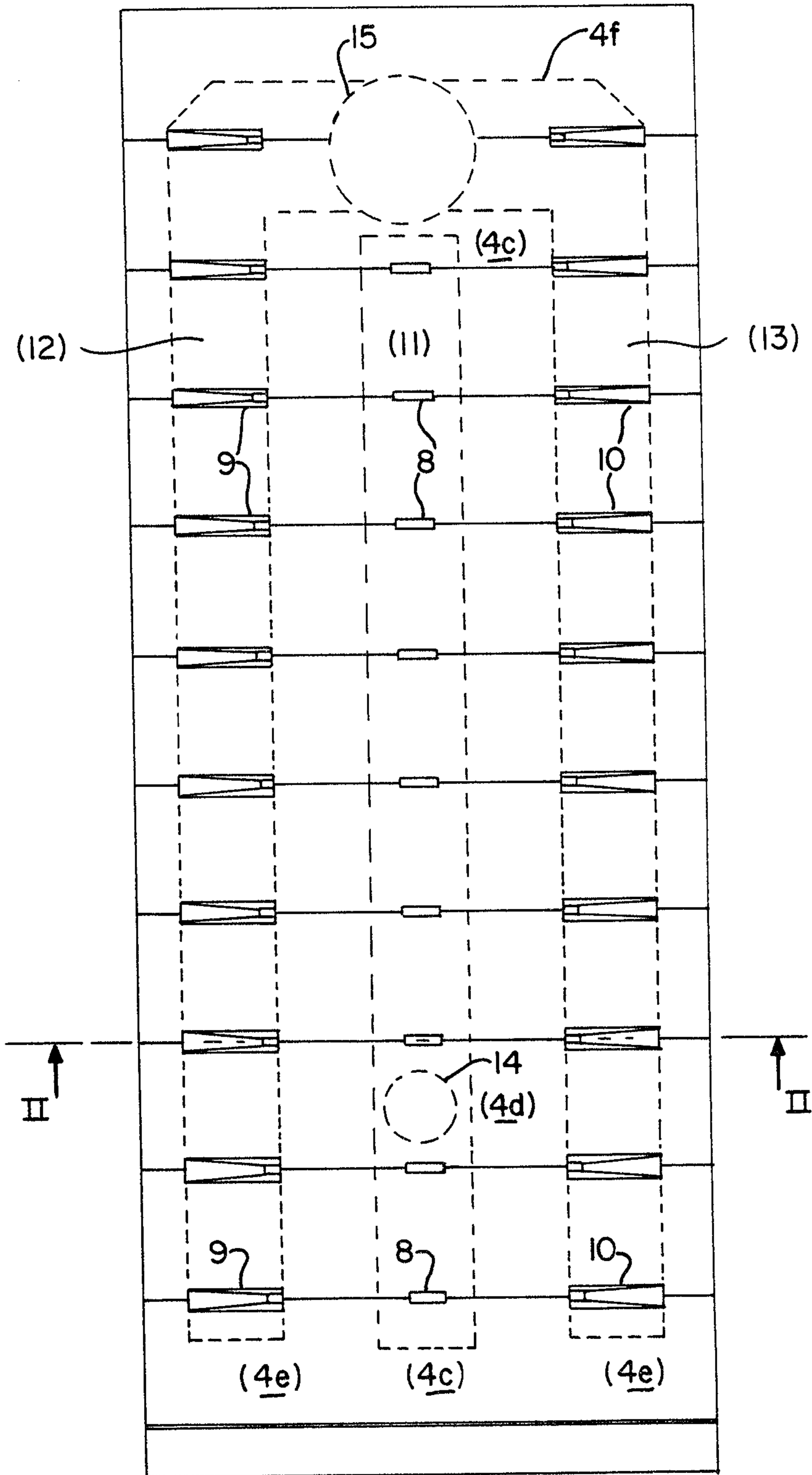


FIG. 1

*[Handwritten Signature]*  
Agents for the Applicant/s

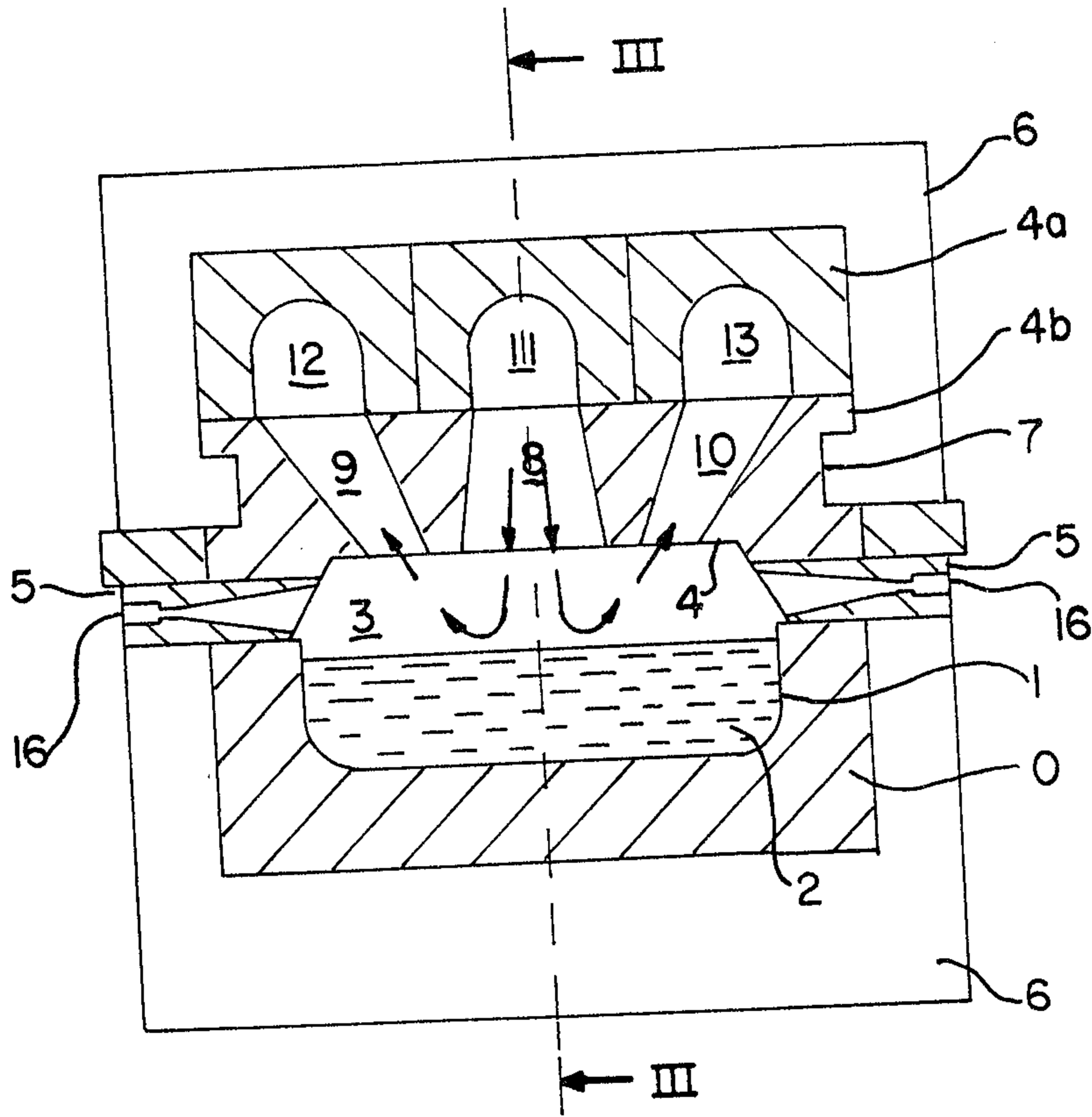


FIG. 2

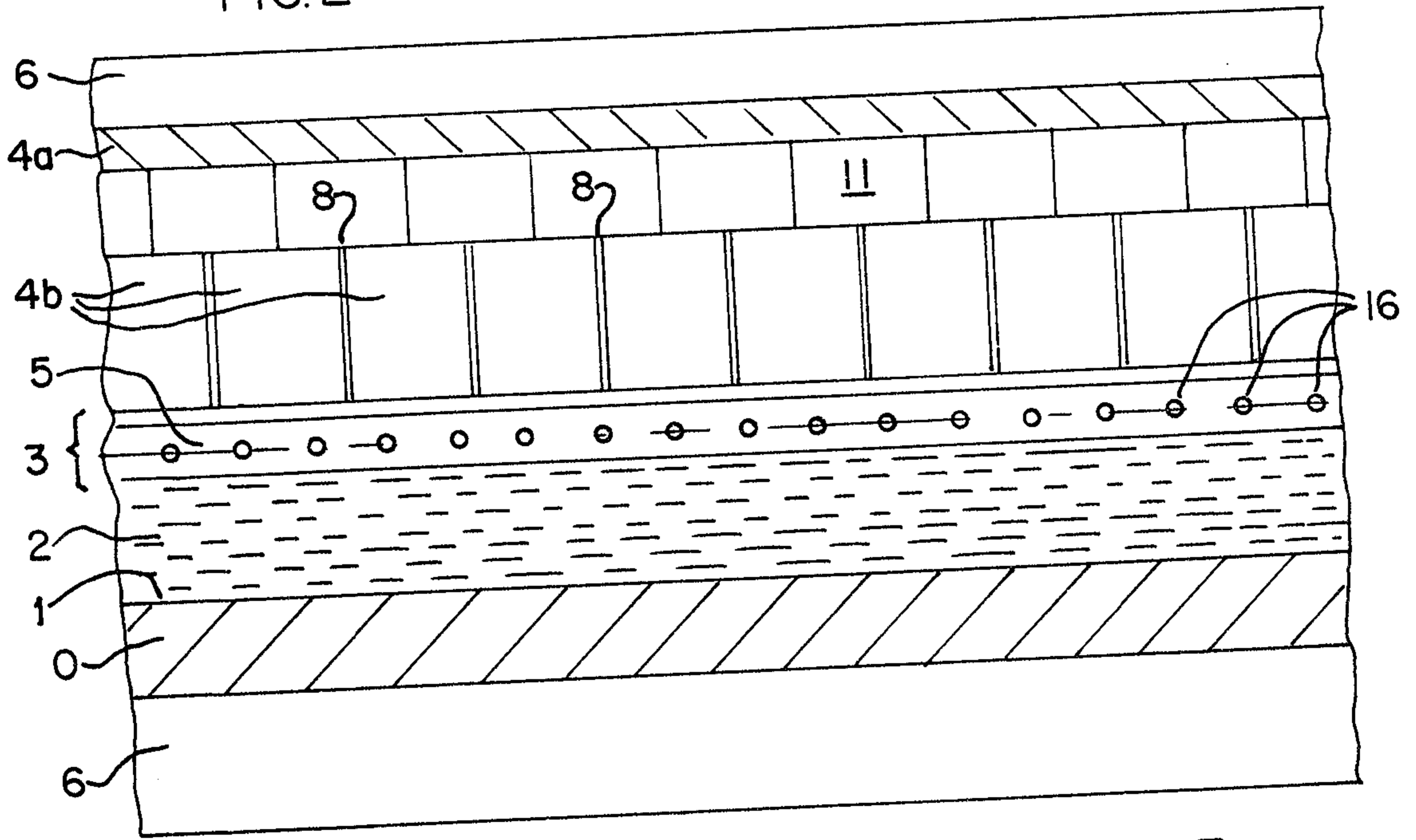


FIG. 3

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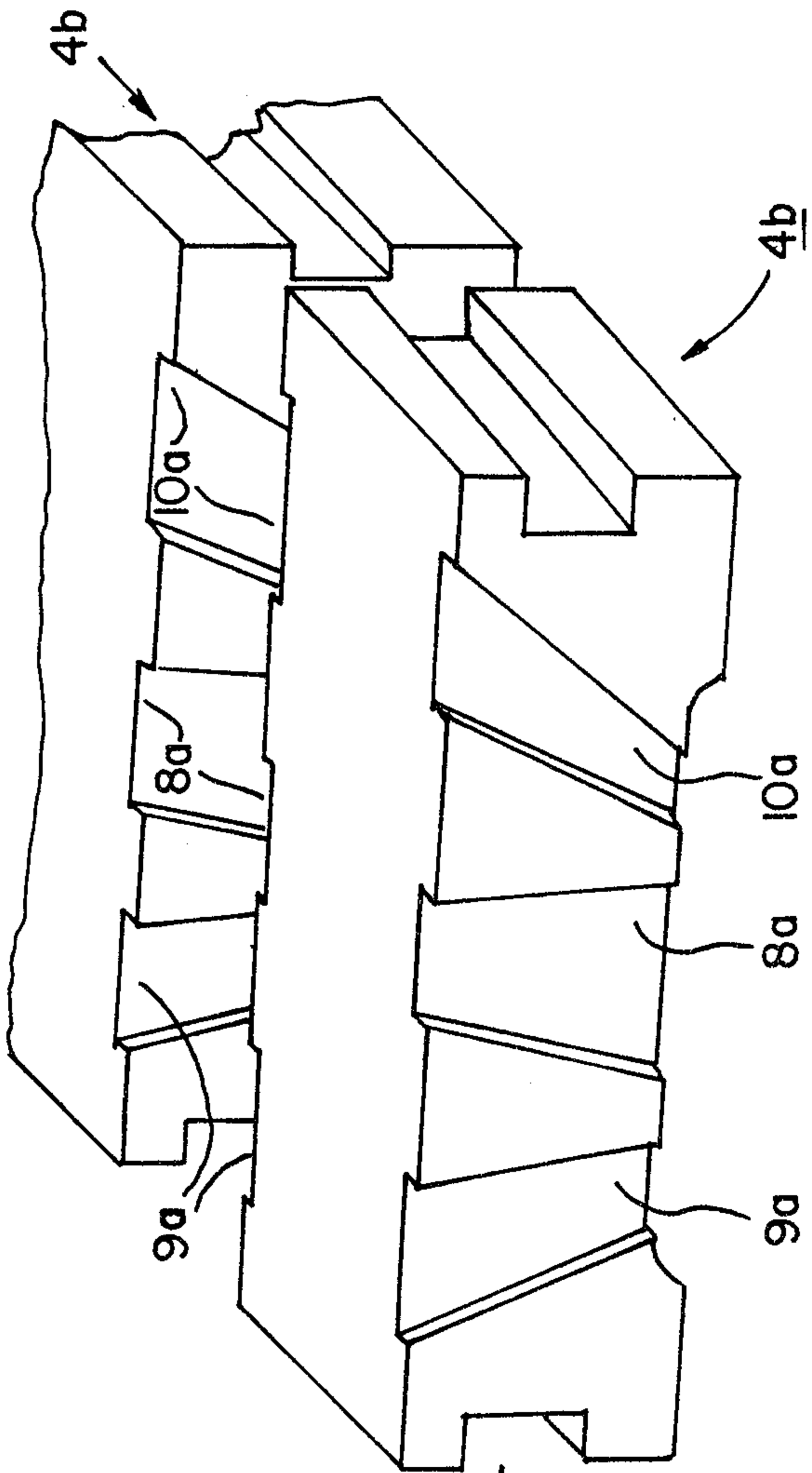
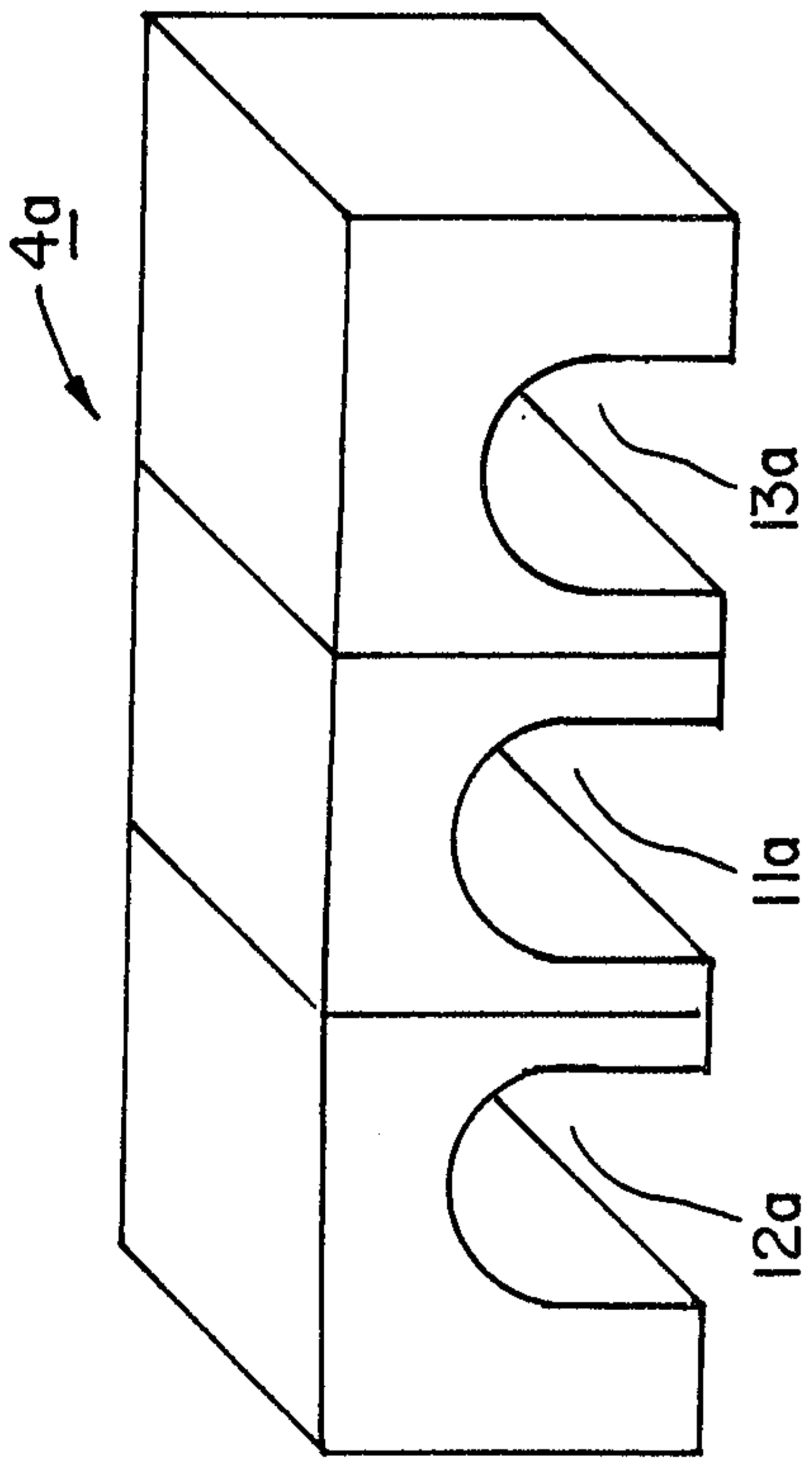


FIG. 4

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