



INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

<p>(51) International Patent Classification⁶ : C09J 5/06, B29C 65/36 // B29K 21:00</p>	<p>A1</p>	<p>(11) International Publication Number: WO 98/05726 (43) International Publication Date: 12 February 1998 (12.02.98)</p>
<p>(21) International Application Number: PCT/US97/13732 (22) International Filing Date: 5 August 1997 (05.08.97) (30) Priority Data: 08/692,390 5 August 1996 (05.08.96) US (71) Applicant: SENCO PRODUCTS, INC. [US/US]; 8485 Broadwell Road, Cincinnati, OH 45244 (US). (72) Inventors: REMEROWSKI, David, L.; 8173 Fontaine Court, Cincinnati, OH 45236 (US). SHOMLER, Duane, C.; 10094 Bolingbroke Drive, Cincinnati, OH 45241 (US). RACCA, Anthony, T.; 1045 Wittshire Circle, Cincinnati, OH 45255 (US). LOCOCO, David, J.; 3207 Ashwood Drive, Cincinnati, OH 45213 (US). (74) Agent: LITZINGER, Jerrold, J.; 8485 Broadwell Road, Cincinnati, OH 45244 (US).</p>	<p>(81) Designated States: AU, BR, CA, JP, MX, European patent (AT, BE, CH, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE). Published <i>With international search report.</i></p>	
<p>(54) Title: METHOD OF ADHESIVELY ADHERING RUBBER COMPONENTS</p>		
<p>(57) Abstract</p> <p>A clean, neat and effective method for adhesively adhering a rubber component to a work surface entails placing adjacent to the surfaces to be joined a device which comprises: a target element contiguous with a heat activatable adhesive material, said target element being absorbent of electromagnetic waves which are convertible to heat energy to activate said adhesive material, holding said surfaces together, and exposing said device to electromagnetic waves to produce heat sufficient to activate the adhesive material and effect a bonded relationship between the rubber component and the work surface.</p>		

FOR THE PURPOSES OF INFORMATION ONLY

Codes used to identify States party to the PCT on the front pages of pamphlets publishing international applications under the PCT.

AL	Albania	ES	Spain	LS	Lesotho	SI	Slovenia
AM	Armenia	FI	Finland	LT	Lithuania	SK	Slovakia
AT	Austria	FR	France	LU	Luxembourg	SN	Senegal
AU	Australia	GA	Gabon	LV	Latvia	SZ	Swaziland
AZ	Azerbaijan	GB	United Kingdom	MC	Monaco	TD	Chad
BA	Bosnia and Herzegovina	GE	Georgia	MD	Republic of Moldova	TG	Togo
BB	Barbados	GH	Ghana	MG	Madagascar	TJ	Tajikistan
BE	Belgium	GN	Guinea	MK	The former Yugoslav Republic of Macedonia	TM	Turkmenistan
BF	Burkina Faso	GR	Greece			TR	Turkey
BG	Bulgaria	HU	Hungary	ML	Mali	TT	Trinidad and Tobago
BJ	Benin	IE	Ireland	MN	Mongolia	UA	Ukraine
BR	Brazil	IL	Israel	MR	Mauritania	UG	Uganda
BY	Belarus	IS	Iceland	MW	Malawi	US	United States of America
CA	Canada	IT	Italy	MX	Mexico	UZ	Uzbekistan
CF	Central African Republic	JP	Japan	NE	Niger	VN	Viet Nam
CG	Congo	KE	Kenya	NL	Netherlands	YU	Yugoslavia
CH	Switzerland	KG	Kyrgyzstan	NO	Norway	ZW	Zimbabwe
CI	Côte d'Ivoire	KP	Democratic People's Republic of Korea	NZ	New Zealand		
CM	Cameroon		Republic of Korea	PL	Poland		
CN	China	KR	Republic of Korea	PT	Portugal		
CU	Cuba	KZ	Kazakstan	RO	Romania		
CZ	Czech Republic	LC	Saint Lucia	RU	Russian Federation		
DE	Germany	LI	Liechtenstein	SD	Sudan		
DK	Denmark	LK	Sri Lanka	SE	Sweden		
EE	Estonia	LR	Liberia	SG	Singapore		

**METHOD OF ADHESIVELY ADHERING
RUBBER COMPONENTS**

CROSS REFERENCE TO A RELATED APPLICATION

This application relates to U.S. Patent Application Serial No. filed on even date
5 herewith and entitled "Adhesive Device" by Shomler et al. Said application and its
disclosure are hereby incorporated by reference.

BACKGROUND OF THE INVENTION

This disclosure relates to a method for adhering rubber components to a work
surface using an adhesive device that is activated by electromagnetic waves. The
10 assembled rubber components include assemblies employed in the manufacture of toys,
tools, machines, automobiles, boats, airplanes, furniture and all manner of residential and
commercial constructions.

The adhesive assembly of rubber products is typically effected by employing a
variety of adhesives. However, this traditional fastening means is rapidly falling into
15 disfavor as it becomes desirable and even necessary to work quicker and neater and form
even more secure adhesive bonds. It is apparent, then, that inventions are waiting to be
made which address the placement of adhesive material in a neat, clean, safe and
effective manner especially with regard to the adhesive assembly of rubber components
to a work surface.

20 Not surprisingly then, others have experimented with alternatives to traditional
fastening devices for adhesively joining the components of an assembled product.

DESCRIPTION OF THE PRIOR ART

United States Patent 4,038,120 to Russell describes the use of an energized heating element or wire to heat a hot melt glue resulting in adhesion between contiguously assembled panels. The reference method involves heating a glue-coated wire to liquefy the glue producing a cohesive state and facilitating the assembly of panels. This method is particularly useful for introducing a cohesive material (glue) to an area of limited accessibility (groove), but the heating element (wire) requires the direct application of energy (electricity) to provide the heat to melt glue.

United States Patent 3,574,031 to Heller et al. describes a method and material for welding thermoplastic bodies by using a susceptor between the bodies to be joined. The susceptor sealant is characterized by having particles, heatable by induction, dielectric or radiant energy, dispersed in a thermoplastic carrier compatible with the thermoplastic sheets to be welded. The welding of the thermoplastic sheets is effected by exposing the susceptor sealant to heat energy, softening the carrier material and joining all thermoplastic materials.

United States Patent 3,996,402 to Sindt relates to the assembly of sheet materials by the use of a fastening device utilizing an apertured sheet of eddy current-conducting material sandwiched between coatings of hot-melt glue. An induction heating system is activated causing eddy current heating in the EC-conducting material with consequent melting of the hot-melt glue thus resulting in fusion and, ultimately, bonding of the sheet materials in accordance with the desired construction.

SUMMARY OF THE INVENTION

The presently disclosed method of adhesively adhering rubber components to a work surface is distinguished from, and improves upon, the prior art by utilizing a device to be placed adjacent to the surfaces to be joined which comprises a target element
5 contiguous with a heat activatable adhesive material said target element being absorbent of electromagnetic waves which are convertible to heat energy for activating the adhesive material, holding said surfaces together, and exposing said device to electromagnetic waves to produce heat sufficient to activate the adhesive material to effect an adhesive bond between the rubber components and the work surface.

DESCRIPTION OF THE PREFERRED EMBODIMENT

10 It is desirable that the adhesive assembly of articles having a rubber component be constructed as efficiently as possible. There is not a lot of technology or know-how in the fabrication of these items. Typically, they're made of one or two rubber components and a non-rubber work surface. The rubber component is typically attached to the work
15 surface by using traditional glues, adhesives and hot melts. The disclosed method will allow the rubber components to arrive at the assembly point with the adhesive device already in place. It is believed that the disclosed method of assembling rubber products will provide definite advantages of cost, safety and appearance over traditionally fastened rubber products.

20 By the term "rubber products" is meant all natural and synthetic materials having elastomeric properties and consisting of organic, semi-organic and siloxane polymers as a fundamental structural unit and capable of being fabricated into a variety

of forms and shapes so as to perform the innumerable functions envisioned for these versatile materials. While natural rubber components and products continue to be used where cost effectiveness is unchallenged, its use has been largely replaced by synthetic materials also having elastomeric properties. These synthetic elastomeric materials are typically comprised of polymers consisting of monomers such as butadiene, styrene, ethylene, propylene, isoprene and the like.

Also, bear in mind that these assembled rubber components are characteristically made in assembly line operations. They're made with standard pieces according to standard specifications. This uniformity of composition and process is well suited for the employment of an adhesive device that can be desirably situated between or adjacent to pieces to be joined in the assembly of a product and activated to adhesively join the components into a sturdy, well-constructed product.

Looking at the adhesive device employed in the disclosed method in greater detail, we see that the target element must, for the most part, be fashioned from materials or substances that are not transparent to electromagnetic waves. Indeed, the target element will necessarily be constructed of a composition that will absorb electromagnetic waves. Once absorbed by the target element, these waves will produce magnetic hysteresis and eddy currents resulting in heat energy which will melt or activate the contiguous adhesive material.

Typically, the target element will be fashioned from metallic materials such as steel, aluminum, copper, nickel or amalgams thereof which have proven utility and are readily available; although, some semi-metallic materials such as carbon and silicon are

also known to be suitable for the absorption of electromagnetic waves.

The target element can assume any form or shape consistent with the overall configuration of the adhesive device. Frequently, the target element will be presented as a metallic foil, mesh or strip, and, in some instances, it will be more effective to present
5 the target element in the form of a fiber, chip or flake of an electromagnetic absorbable material. The point to be made is that the target element need only be fashioned from a material reasonably impervious to, and absorptive of, electromagnetic waves.

In use, the adhesive device needs to be situated adjacent to the pieces or components of the rubber product to be assembled. As a practical matter, of course, all
10 rubber products are transparent to electromagnetic waves. Some rubber materials will be more transparent than others, and empirical adjustments can and will be made to modulate the quantity and intensity of electromagnetic wave energy needed to optimally activate the adhesive material.

In many instances, it will be sufficient for the adhesive device simply to be
15 placed adjacent to or between the rubber component and the work surface. In other construction or assembly situations, it will be necessary to make some arrangements or take additional steps to make sure the adhesive device remains in place prior to activation. Such an additional step need be little more than introducing an attachment element such as a small pressure sensitive adhesive area on the surface of the device .
20 Simpler means for positioning the device prior to activation might include clamping, tacking, stapling or spiking to make sure the adhesive device is situated and activated in the most effective and, therefore, most desirable location. But these measures, of course,

would be optional procedures and in no way essential to the performance of the device in its broadest typical and routine applications.

When desirably situated adjacent to the rubber component of the product to be assembled, the adhesive device is ready to be exposed to electromagnetic waves produced by and emanating from a generator powered by a source of alternating electric current. The generator can be held in a fixed position for assembly-line production or designed to be manipulated so as to quickly and easily pass over, around or near the strategically "hidden" device while emitting electromagnetic waves which will penetrate the "transparent" rubber component, be absorbed by the target element, be converted to heat energy and activate the adhesive material resulting in a bonded relationship between the pieces of the rubber product being assembled.

To elaborate, somewhat, heat is produced in the conductive target element by two mechanisms: eddy current resistive heating and magnetic hysteresis. Eddy current resistive heating applies to all conductive materials and is produced in the target element by the electromagnetic waves emanating from the generator. The heat resulting from magnetic hysteresis is observed only in magnetic materials. As the electromagnetic field produced by the generator reverses polarity, the magnetized atoms or molecules in the target element also reverse. There is an energy loss in this reversal which is analogous to friction: This energy loss is magnetic hysteresis. The "lost" energy is quickly converted to heat and conducted by the target material to the contiguous, and frequently enveloping, heat-activatable adhesive material to initiate adhesion.

When heated to the necessary temperature, the adhesive material will liquefy or

become heat-activated, attach itself to the surfaces to be joined and, on cooling, create an adhesive relationship joining the rubber component to the work surface. Two adhesion mechanisms, hot-melt and heat-activated cure, are proposed for use with the disclosed device. Both mechanisms are initiated by heat emanating from the target element.

5 Hot-melt adhesives are solid at ambient temperatures, but melt or liquefy when the temperature is elevated by, for instance, heat accumulating in the target element. The melted adhesive “wets” the adherends and attaches to the surface of the pieces to be bonded. As the adhesive cools, the adherends and adhesive are bonded by the electrostatic attraction of polar molecular groups. Note that for the hot-melt mechanism,
10 the bonding is reversible. Thus by repeating the induction heating procedure, the bond can be undone and the adherends separated. The ability to reverse the adhesion and separate adhesively assembled pieces is not a trivial attribute. In addition to the obvious advantage of being able to reassemble or repair misaligned pieces in assembled products, it may also be desirable to be able to disassemble adhesively assembled products to
15 facilitate serviceability and repair.

Heat-activated curing adhesives are also solid and easy to manipulate at ambient temperatures, but when the adhesive temperature is elevated by, for example, the heat emanating from the target element, a chemical reaction is initiated. This reaction involves a cure or crosslinked bonding either within the adhesive or between the
20 adherends. Such bonds are typically irreversible. Frequently, a heat-activated curing adhesive bond will demonstrate an electrostatic attraction between the adhesive and the adherends and a crosslinked bond within itself.

While the foregoing is a complete description of the disclosed method, numerous variations and modifications may also be employed to implement the purpose of the invention. And, therefore, the elaboration provided should not be assumed to limit the scope of the invention which is intended to be defined by the appended claims.

What is claimed is:

1. A method of adhesively adhering rubber components to a work surface which comprises placing adjacent to the surfaces to be joined a device which comprises: a target element contiguous with a heat activatable adhesive material, said target material
5 being absorbent of electromagnetic waves which are convertible to heat energy to activate said adhesive material, holding said surfaces together, and exposing said device to electromagnetic waves to produce heat sufficient to activate the adhesive material to effect a bonded relationship between the rubber component and the work surface.
2. An assembled product comprising rubber components assembled according to
10 the method of claim 1.

INTERNATIONAL SEARCH REPORT

International Application No
PCT/US 97/13732

A. CLASSIFICATION OF SUBJECT MATTER
IPC 6 C09J5/06 B29C65/36 //B29K21:00

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)
IPC 6 B29C C09J

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	DE 38 05 421 A (SCHWAEBISCHE HUETTENWERKE GMBH) 21 September 1989 see claims 1,2,5-7; figures 10,11 ---	1,2
X	DATABASE WPI Section Ch, Week 9305 Derwent Publications Ltd., London, GB; Class A35, AN 93-040198 XP002045787 & JP 04 364 926 A (ADOHEYA SANSHO KK) , 17 December 1992 see abstract; figures ---	1,2
X	GB 2 240 980 A (UNIV VIRGINIA ALUMNI PATENTS FO ;MALAYSIAN RUBBER PRODUCERS (GB)) 21 August 1991 see claims --- -/--	1,2

Further documents are listed in the continuation of box C.

Patent family members are listed in annex.

* Special categories of cited documents :

- "A" document defining the general state of the art which is not considered to be of particular relevance
- "E" earlier document but published on or after the international filing date
- "L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)
- "O" document referring to an oral disclosure, use, exhibition or other means
- "P" document published prior to the international filing date but later than the priority date claimed

- "T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention
- "X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone
- "Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art.
- "&" document member of the same patent family

Date of the actual completion of the international search

21 November 1997

Date of mailing of the international search report

28/11/1997

Name and mailing address of the ISA
European Patent Office, P.B. 5818 Patentlaan 2
NL - 2280 HV Rijswijk
Tel. (+31-70) 340-2040, Tx. 31 651 epo nl,
Fax: (+31-70) 340-3016

Authorized officer

Cordenier, J

INTERNATIONAL SEARCH REPORT

International Application No
PCT/US 97/13732

C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT		
Category	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	EP 0 440 410 A (KINUGAWA RUBBER IND) 7 August 1991 see the whole document ----	1,2
X	GB 2 065 027 A (POLYMER LAB LTD) 24 June 1981 see page 2, line 117 - line 125; claims ----	1,2
X	WO 87 00074 A (HEATH CLIVE ANTHONY;HIBBLE BARRY FRANCIS) 15 January 1987 see page 3, line 8 - line 13; claims 1,4 ----	1,2
X	DE 39 40 461 A (PFEFFERKORN & CO) 13 June 1991 see column 2, line 47 - line 53; claim 12 ----	1,2
X	US 5 340 649 A (ROEKER DAVID C ET AL) 23 August 1994 see the whole document ----	1,2
X	US 3 996 402 A (SINDT MELVIN R) 7 December 1976 cited in the application see abstract; figures 4,5 ----	1,2
X	US 3 574 031 A (HELLER WILLIAM C JR ET AL) 6 April 1971 cited in the application see claims 1-4 ----	1,2
A	PATENT ABSTRACTS OF JAPAN vol. 010, no. 365 (M-542), 6 December 1986 & JP 61 160229 A (DAINICHI NIPPON CABLES LTD), 19 July 1986, see abstract ----	1
A	PATENT ABSTRACTS OF JAPAN vol. 017, no. 524 (M-1483), 21 September 1993 & JP 05 138742 A (SHIN ETSU POLYMER CO LTD), 8 June 1993, see abstract; figures -----	1

INTERNATIONAL SEARCH REPORT

Information on patent family members

Int. Patent Application No

PCT/US 97/13732

Patent document cited in search report	Publication date	Patent family member(s)	Publication date
DE 3805421 A	21-09-89	NONE	
GB 2240980 A	21-08-91	NONE	
EP 0440410 A	07-08-91	JP 3221434 A DE 69127216 D	30-09-91 18-09-97
GB 2065027 A	24-06-81	NONE	
WO 8700074 A	15-01-87	CA 1267515 A EP 0229096 A JP 63500082 T US 4765859 A	10-04-90 22-07-87 14-01-88 23-08-88
DE 3940461 A	13-06-91	NONE	
US 5340649 A	23-08-94	US 5400460 A AU 656016 B AU 2308792 A CA 2112243 A EP 0592588 A JP 6508878 T WO 9301247 A	28-03-95 19-01-95 11-02-93 21-01-93 20-04-94 06-10-94 21-01-93
US 3996402 A	07-12-76	US 4120712 A	17-10-78
US 3574031 A	06-04-71	DE 1704116 A FR 1577304 A GB 1216516 A	22-04-71 08-08-69 23-12-70