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CA 2145292 C 2002/11/19

(11)(21) 2 145 292

(12) BREVET CANADIEN
CANADIAN PATENT

(13) C

(86) Date de dépôt PCT/PCT Filing Date: 1993/09/22
(87) Date publication PCT/PCT Publication Date: 1994/03/31
(45) Date de délivrance/Issue Date: 2002/11/19
(85) Entrée phase nationale/National Entry: 1995/03/22
(86) N° demande PCT/PCT Application No.: NZ 1993/000087
(87) N° publication PCT/PCT Publication No.: 1994/007071
(30) Priorité/Priority: 1992/09/22 (244431) NZ

(51) Cl.Int.⁶/Int.Cl.⁶ B21D 15/04, F16L 9/06, F28D 7/02

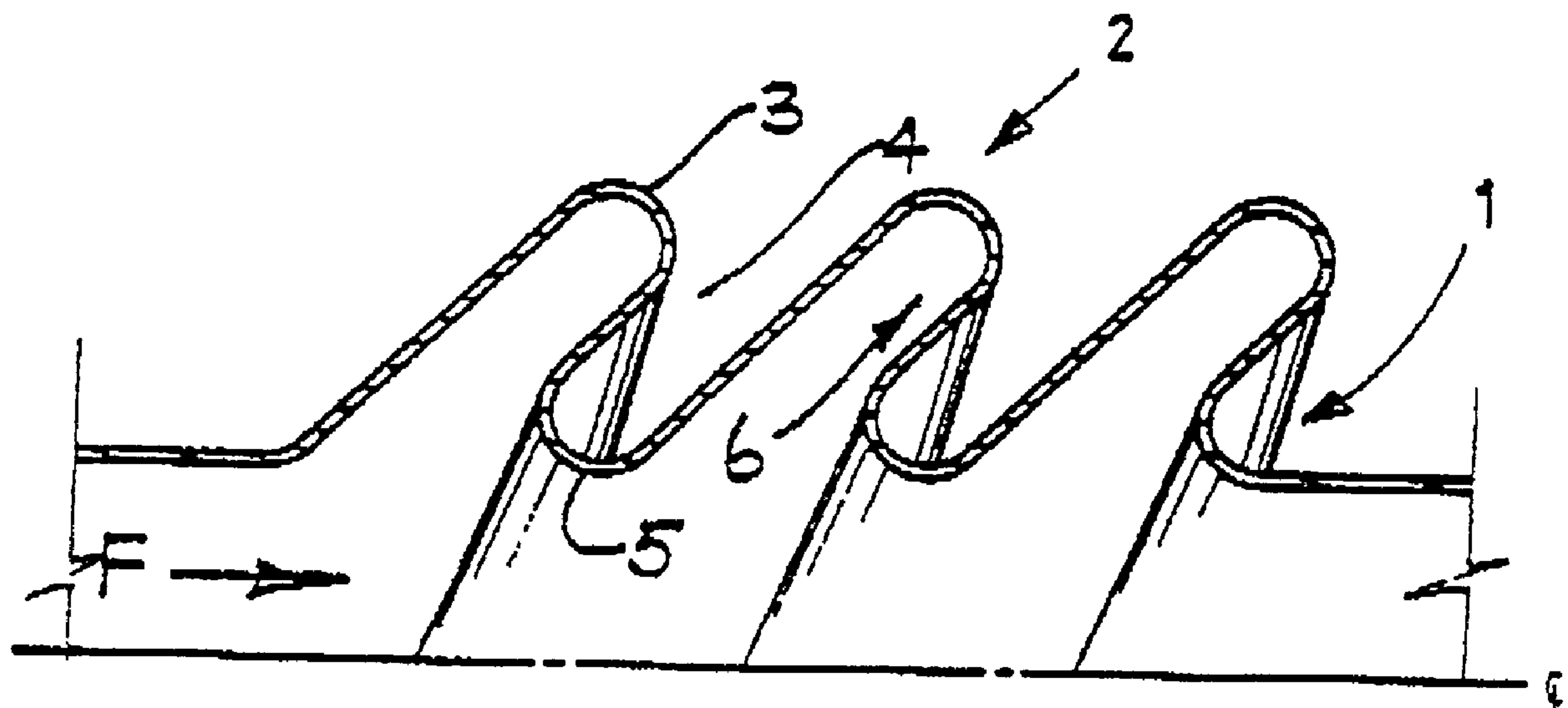
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(54) Titre : FABRICATION DE CONDUIT A ONDULATIONS HELICOÏDALES

(54) Title: MANUFACTURE OF HELICALLY CORRUGATED CONDUIT



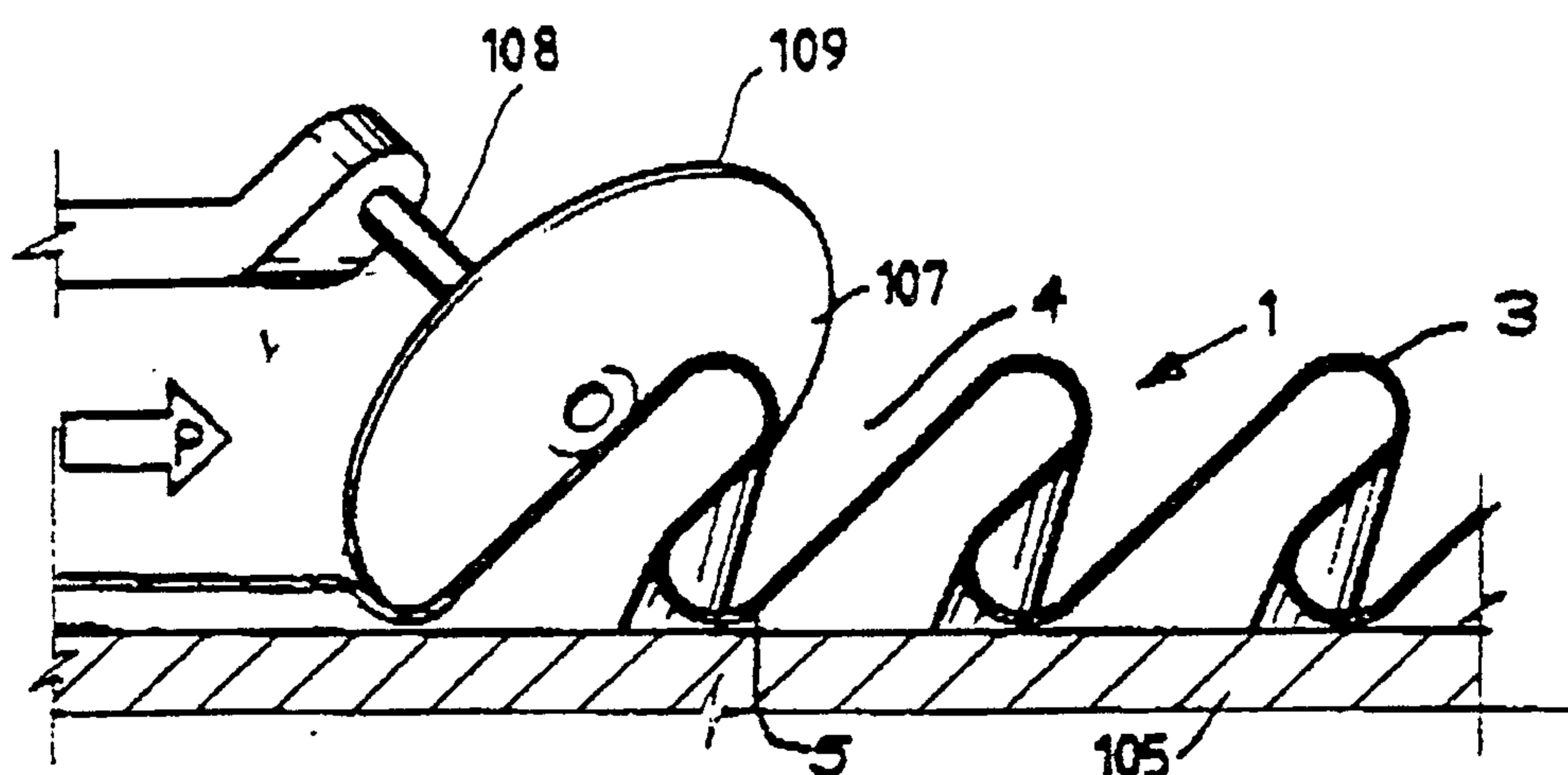
(57) Abrégé/Abstract:

This invention concerns the manufacture of helically corrugated conduit having at least a portion of its length corrugated in the form of at least one helix. The method includes the driving of a smooth walled tube into a forming head having forming wheels which engage the outside of the tube and the wheels are at an angle relative to the longitudinal axis of the tube. The forming wheels form the helical spiral as part of a cold rolled forming process. More than one helical spiral can be formed simultaneously using a multiplicity of forming wheels.

INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(51) International Patent Classification 5 : F16L 9/06, B21D 15/04 F28D 7/02		A1	(11) International Publication Number: WO 94/07071 (43) International Publication Date: 31 March 1994 (31.03.94)
(21) International Application Number: PCT/NZ93/00087 (22) International Filing Date: 22 September 1993 (22.09.93)		Published <i>With international search report.</i>	2145292
(30) Priority data: 244431 22 September 1992 (22.09.92) NZ			
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(81) Designated States: AT, AU, BB, BG, BR, BY, CA, CH, CZ, CZ (Utility model), DE, DE (Utility model), DK, DK (Utility model), ES, FI, GB, HU, JP, KP, KR, KZ, LK, LU, LV, MG, MN, MW, NL, NO, NZ, PL, PT, RO, RU, SD, SE, SK, SK (Utility model), UA, US, UZ, VN, European patent (AT, BE, CH, DE, DK, ES, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, ML, MR, NE, SN, TD, TG).			

(54) Title: MANUFACTURE OF HELICALLY CORRUGATED CONDUIT



(57) Abstract

This invention concerns the manufacture of helically corrugated conduit having at least a portion of its length corrugated in the form of at least one helix. The method includes the driving of a smooth walled tube into a forming head having forming wheels which engage the outside of the tube and the wheels are at an angle relative to the longitudinal axis of the tube. The forming wheels form the helical spiral as part of a cold rolled forming process. More than one helical spiral can be formed simultaneously using a multiplicity of forming wheels.

MANUFACTURE OF HELICALLY CORRUGATED CONDUITBACKGROUND OF THE INVENTION

This invention relates to the manufacture of helically corrugated conduits and conduits made by that method such as heat exchange conduits used to exchange heat from one fluid to another, in liquid to gas, gas to gas or liquid to liquid heat exchange and also the drying of powders or any other uses where a helical spiralled tube is of assistance such as electrical element housing tube.

A number of conduits incorporating a helical spiral or even a multi-start helix in the wall of the conduit are known. Such tubes or conduits are variously described in apparatus in specification numbers GB1511718, GB2374609, US3730229 and US4559999.

Of these specifications, only US3730229 goes into some detail on the method of manufacture of such a conduit. The method disclosed in that specification involves creating indentations in the tube to act as starting points for the helical spiral and then the simultaneous twisting and longitudinal compression of the tube over an internal mandrel and within an exterior tube. Such a method is both complex, time consuming and can lead to the twisted helical conduit being jammed within the outer tube.

Both this prior art method of manufacture and others suggested by twisting the conduit can lead to conduits of uneven wall thickness and uneven stresses within the finished conduit. This can lead to breakage during manufacture and failure of the conduit in use.

In United States Patent 3,606,780, three forming rollers have an outer periphery with arced grooves and ridges which are pressed into the pipe as it passes between the rollers to form the helical grooves and ridges in the pipe.

OBJECTS OF THE INVENTION

It is thus an object of the present invention to provide a method of manufacture of a helically corrugated conduit with a relatively constant wall thickness and/or which is more economic than the prior art methods.

SUMMARY OF THE INVENTION

According to a first aspect of this invention, there is provided a method of manufacturing a helically corrugated conduit incorporating at least one helical undulation thereon and including the steps of:

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- i) positioning a portion of substantially smooth walled tube formed in a malleable material on a support means;
- ii) positioning at least one forming wheel with at least its outer periphery in contact with the surface of said tube with the axis of said wheel mounted at an angle relative to a longitudinal axis of said tube;
- iii) rotating said tube and the at least one forming wheel relative to the other to form a wave of material from a wall portion of said tube adjacent said forming wheel to longitudinally undulate a portion of said tube wall substantially helically; characterised in that the outer periphery of the wheel forms the wave of material substantially without diminishing the wall thickness so that the finished conduit is shorter than the initial tube.

According to a second aspect of this invention, a helically corrugated conduit is manufactured by the above defined method and has a substantially uniform wall thickness.

BRIEF DESCRIPTION OF THE DRAWINGS

One form of the invention will now be described in relation to the accompanying drawings in which:

Figure 1 is a partial cutaway substantially diagrammatic side view of one embodiment of the conduit of this invention.

Figure 2 is a diagrammatic end view of the conduit of Figure 1.

Figure 3 is a substantially diagrammatic cross-sectional side view of a further embodiment of a portion of conduit.

Figure 4 is a similar view to that of Figure 3 showing a still further embodiment of conduit.

Figure 5 is a similar view to that of Figures 3 and 4 showing a still further embodiment of conduit.

Figure 6 is a substantially diagrammatic side view of an apparatus for manufacturing the conduit in one embodiment.

Figure 7 is a substantially diagrammatic cross-sectional side view of a portion of the forming head of the apparatus of Figure 6.

Figure 8 is a substantially diagrammatic end view of the forming head of Figure 7 viewed substantially longitudinally of the apparatus of Figure 5.

DESCRIPTION OF PREFERRED EMBODIMENTS

With reference to the drawings, in the preferred form of the invention, the conduit as generally indicated by arrow 1 is preferably formed in a thermally conductive material such as metal; for example copper, stainless steel, aluminium and the like, being

preferably a substantially malleable or formable material if it is to be used as a heat exchange conduit. Other materials for heat exchange or other uses may be substituted. It is possible to use the method on plastic tubing and also plastic lined tubing. The forming method can form the plastic lining with the tubing in one operation.

With particular reference to Figures 1 to 5, a heat exchange conduit 1 produced by the method of manufacture is in the preferred formed from substantially smooth walled copper tube and is arranged along at least a portion of the length of the tube to have a substantially helically ribbed portion as generally indicated by arrow 2.

It will be appreciated that the undulations substantially increase the surface area to length ratio of the tube over the substantially smooth walled tube and enhance the thermal-conductivity of the tube relative to its length in view of the increase in surface area.

The heat exchange conduit 1 is preferably provided with undulations which have outer ribs 3 thereof which project outwardly of a general peripheral line of the tube from which the heat exchange conduit 1 is made. The undulations are each preferably defined as a plurality of helical ribs 3 extending about and

longitudinally of the conduit 1 coupled with an associated groove 4 which, in this preferred form extends inwardly into the interior of the tube to define a plurality of internal ribs 5 therein.

In the preferred form of the invention, the extent of outward projection of the ribs 3 is substantially commensurate with an outer preferred diameter of the finished heat exchange conduit 1.

Preferably the inner ribs 5 are such that they are substantially commensurate with a normal inner diameter of the tube from which the heat exchange conduit 1 is formed. In this way, it will be appreciated that the formation of the conduit 1 does not reduce its cross-sectional area and perhaps create an undue restriction therein. Internal grooves 6 defined between the internal ribs 5 enable a flow of fluid through the interior of the conduit passageway to extend into the ribs 3, to provide a high ratio of surface area to length of the tube conduit 1 and good heat transfer properties therein, as fluid flows through the passageway of the conduit.

In the preferred form of the invention, preferably the helical ribbing 3 of the tube to provide the conduit 1 is provided as a plurality (preferably four) of

helical ribs 3 each commencing in a similar longitudinal position relative to said tube, substantially diametrically opposed one relative to the other so as to provide a form substantially known in the trade as "multistart" helixes.

Referring now to Figures 3, 4 and 5, it is envisaged that the conduit 1 and its undulations can be alternatively formed. By way of example only, Figure 3 shows substantially cross-sectionally a portion of a wall of a conduit 1 which is particularly suited to gas-to-fluid heat exchange. The gas is positioned externally of the conduit 1, and with the undulations, being closely defined leaving only a small groove for liquid with an enhanced surface area to length ratio over the form of Figure 1. Such an arrangement would be particularly suited to motor vehicles radiators, space heating apparatus and refrigerator condenser cores.

With reference to Figure 4, it is envisaged that in certain instances, such as where greater need for prevention of "streaming" is required, that the undulating portions of the conduit 1 can be provided and positioned so that internal ribs 5 thereof are mounted substantially inwardly, out of register with remaining portions of the tube, from which the conduit 1 is formed. It will be appreciated that this causes an

increased interference to the flow of the fluid through the conduit 1, and a greater turbulating action to the fluid passing therethrough as a result.

In the preferred form of the invention, a flow of fluid through the passageway of the conduit is preferably in the direction of arrow F as is shown by Figures 1 to 5. It will be appreciated that with a flow in this direction, and with the particular shape of the associated ribs 5 and recesses 6 internally thereof, there is an enhanced tendency for fluid to flow into the recesses 6 and turbulate, scroll or rotate therein as it flows through the passageway.

It is to be appreciated that a varying of the shape of the undulations may enable more efficient flow from a substantially opposite direction from that described and therefore the invention is not limited to the flow direction as shown and described with reference to Figures 1 to 5.

It is envisaged that each piece of conduit will be provided with a short spigot portion preferably adjacent each end thereof formed in substantially smooth walled tube, to thus facilitate the convenient connection of such conduits with other portions of apparatus utilising substantially known fittings and techniques.

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The conduit 1 may be used as an electrical element housing tube within water heaters such as kettles or cylinders.

Now turning to Figures 6, 7 and 8, a method of forming the conduit 1 will be described.

With reference to Figures 6, 7 and 8, and in particular Figure 6, it is to be appreciated that the conduit 1 is preferably formed from tubular metal material, such as copper, which is provided in substantially selected lengths and is positioned in a magazine 100. The magazine 100 is arranged by rollers 101 and associated selection means (not shown) to progressively feed a single length of smooth walled tubular material into drive rollers 102 mounted between the magazine 100 and a cutoff means 103 adjacent a forming head 104. The drive rollers 102 in the preferred form of the invention preferably drive the selected length of tubular material through the forming head 104 whereupon the undulating form of the conduit 1 is cold roll-formed thereon as said tube positions and is pushed over an elongate mandrel means 105 which extends from a remote stop portion 106.

If only a shallow corrugation is required, it is possible to dispense with the mandrel and support the tubing on other support means such as rollers.

Preferably suitable actuating means and stop means are provided adjacent the mandrel stop, drive rollers, cut off means and the like so as to enable a sequence operation to occur and enable substantially automated production of the conduit 1 according to a predetermined design.

Turning now particularly to Figures 7 and 8, the forming head 104 of Figure 6 in the preferred form of the invention preferably includes a plurality of diametrically arranged forming wheels 107 each radially arranged relative to the mandrel 105 of the forming head 104.

Preferably, each forming wheel is mounted substantially as is shown by Figure 7, at an angle and with its rotational axis inclined relative to the longitudinal axis of the mandrel and therefore the conduit 1 positioned thereon.

Adjustment of the angle of the forming wheel 107 can change the pitch and depth of the corrugations in the finished conduit.

Preferably peripheral portions 109 of the each wheel 107 are each so shaped to engage with outer surfaces of the tube from which the conduit 1 is formed and to run thereon said wheels 107 are each mounted substantially out of line with a normal rolling run of said periphery 109 so that when the tube is positioned over said mandrel 105 and said roller 107 periphery 109 is brought into contact with exterior surface of the tube, a "wave" of material is developed downstream of said roller 107 and a surface of the tube is formed into the undulations described hereinbefore in relation to Figures 1 to 5 upon the relative rotation of said tube and said wheels 107.

It will be appreciated that the rollers 107 are each mounted to move to and from the operative position to enable feeding of the tube onto the mandrel 105 end prior to formation. It is also to be appreciated that the drive rollers 102 in the preferred form of the invention provide a sufficient degree of pressure P in the direction of arrow P of Figures 6 and 7 so that the "wave" of tube material is formed by each of the rollers or wheels 107 as the drive rollers 102 force the tubular material over the mandrel 105 and maintain pressure against the rollers 107. The pressure required will vary according to the type of material used, the thickness of the wall of the tubing and the corrugation desired.

It will be appreciated that by this method a substantially quadruple start helix is provided on the conduit. It should be appreciated that as many "starts" as may be required may be provided, subject to sufficient rollers 107 being able to be arranged substantially radially of the mandrel 105 and in the forming head 104. In some instances, particularly with larger tubing, it may be desirable to use more than one forming wheel to form each helical spiral. For example, eight forming wheels for a four start helix.

The conduit resulting from this method of manufacture comprises a conduit of relatively uniform wall thickness through the cold rolled forming of the helical spirals. The spirals are created to form a finished conduit of shorter length than the length of initial smooth walled tube used in its creation. Other methods of manufacture may create uneven wall thicknesses and perhaps an uneven distribution of stresses throughout the finished conduit.

Thus, by this invention, there is provided an improved method of manufacture of a helically corrugated conduit providing for economic manufacture of a conduit incorporating a relatively simple design and a high ratio of surface area to length.

CLAIMS:

1. A method of manufacturing a helically corrugated conduit incorporating at least one helical undulation thereon, including the steps of:
 - i) positioning a portion of substantially smooth-walled tube formed in a malleable material on a support means;
 - ii) positioning at least one forming wheel with at least its outer periphery in contact with the surface of said tube with the axis of said wheel mounted at an angle relative to the longitudinal axis of said tube;
 - iii) rotating said tube and the at least one forming wheel relative to the other to form a wave of material from a wall portion of said tube adjacent said forming wheel to longitudinally undulate a portion of said tube wall substantially helically; characterised in that the outer periphery of the wheel forms the wave of material substantially without diminishing the wall thickness, so that the finished conduit is shorter than the initial tube.

2. A method of manufacturing a helically corrugated conduit as claimed in Claim 1 characterised in that said tube or forming wheel is moved to traverse a substantial portion of the length of said tube.

3. A method of manufacturing a helically corrugated conduit as claimed in Claim 1 or Claim 2 characterised in that a multiplicity of forming wheels are positioned about the circumference of said tube to form a multiplicity of helical spirals.

4. A method of manufacturing a helically corrugated conduit as claimed in Claim 3 characterised in that said multiplicity of forming wheels comprises four forming wheels.

5. A method of manufacturing a helically corrugated conduit as claimed in any preceding claim, characterised in that a portion of said smooth walled tube is unformed adjacent an end of said tube.

6. A method of manufacturing a helically corrugated conduit as claimed in any preceding claim, wherein said tube is progressed against said at least one forming wheel under a pressure so as to form the said helical spiral in the wall of said tube conduit.

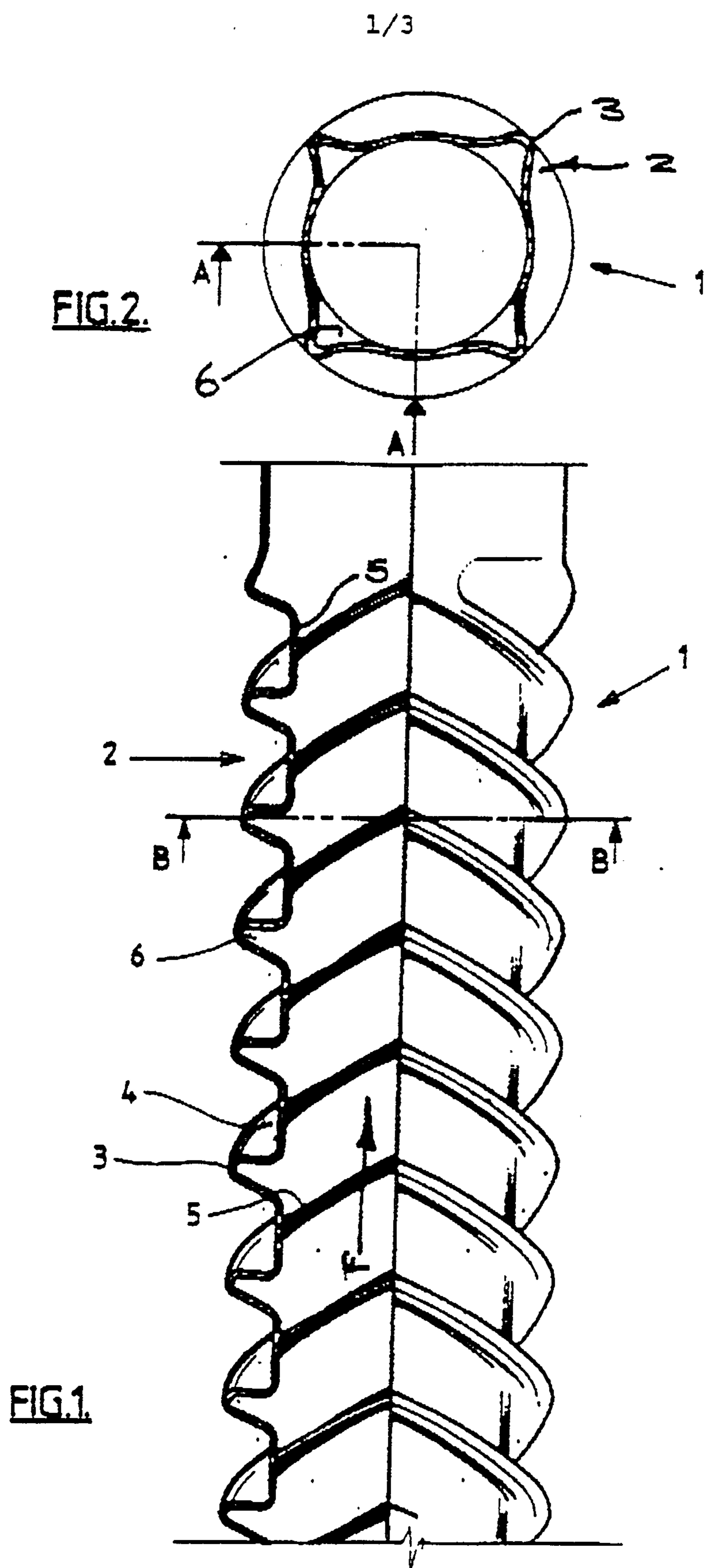
7. A method of manufacturing a helically corrugated conduit as claimed in claim 6 characterised in that said tube is progressed towards said at least one forming wheel by driving means.

8. A method of manufacturing a helically corrugated conduit as claimed in claim 7 characterised in that said driving means comprise drive rollers.

9. A method of manufacturing a helically corrugated conduit as claimed in any preceding claim, characterised in that said support means comprise a cylindrical mandrel positioned within said tube.

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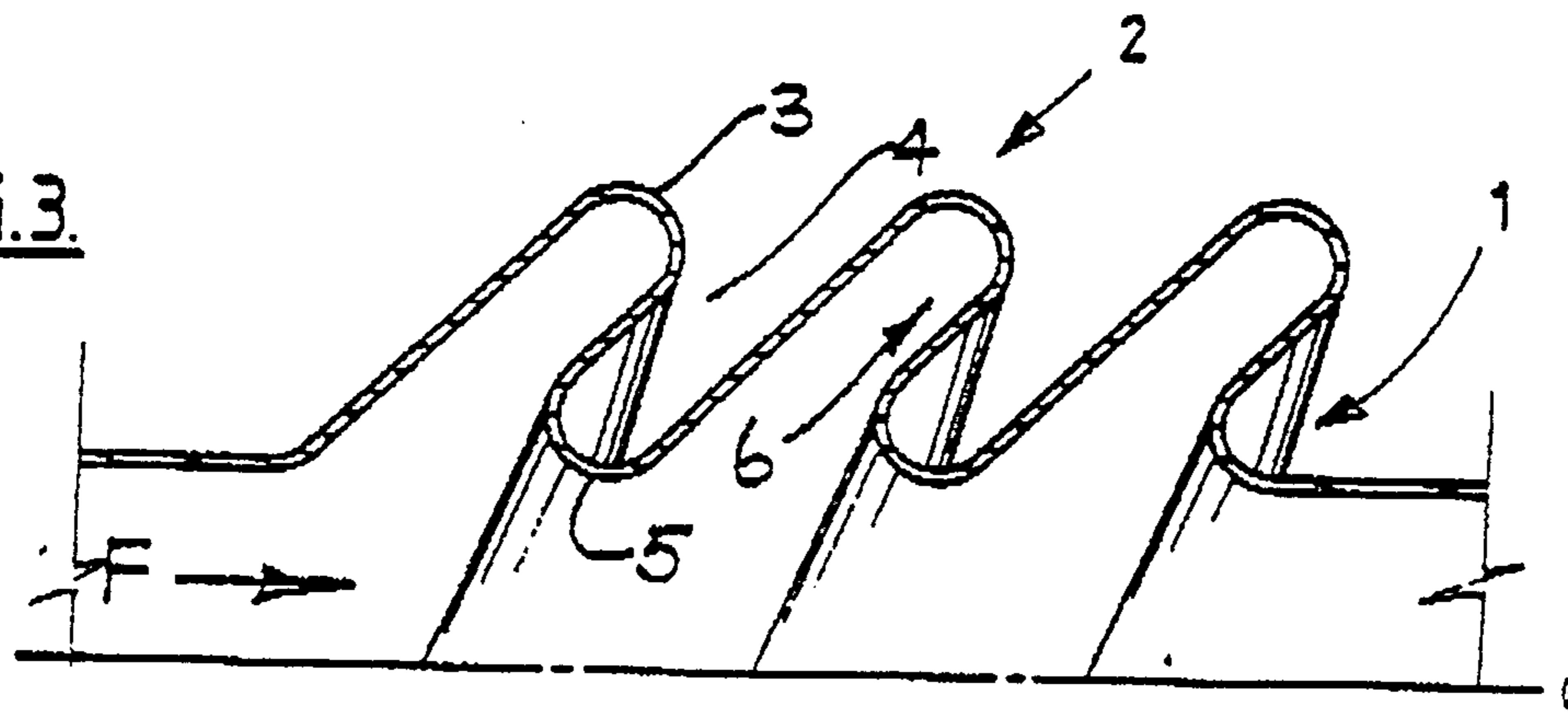
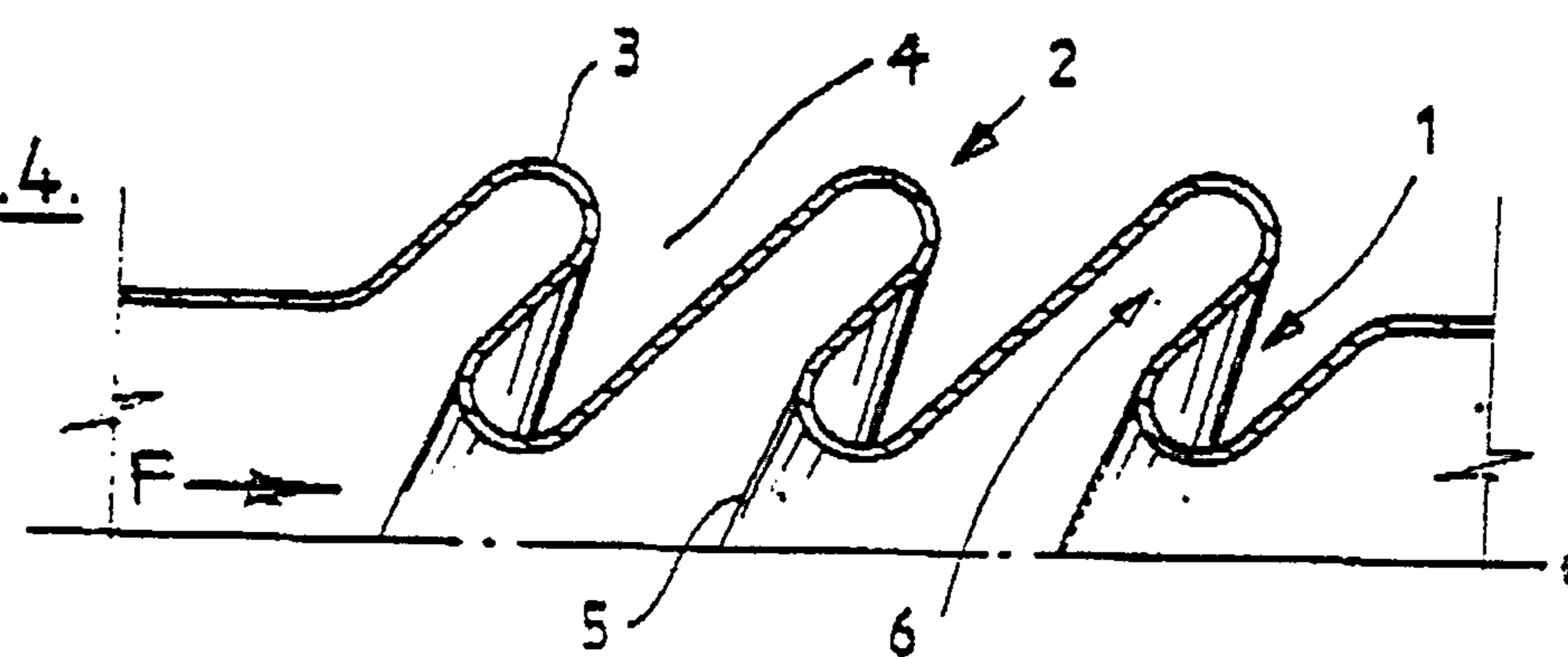
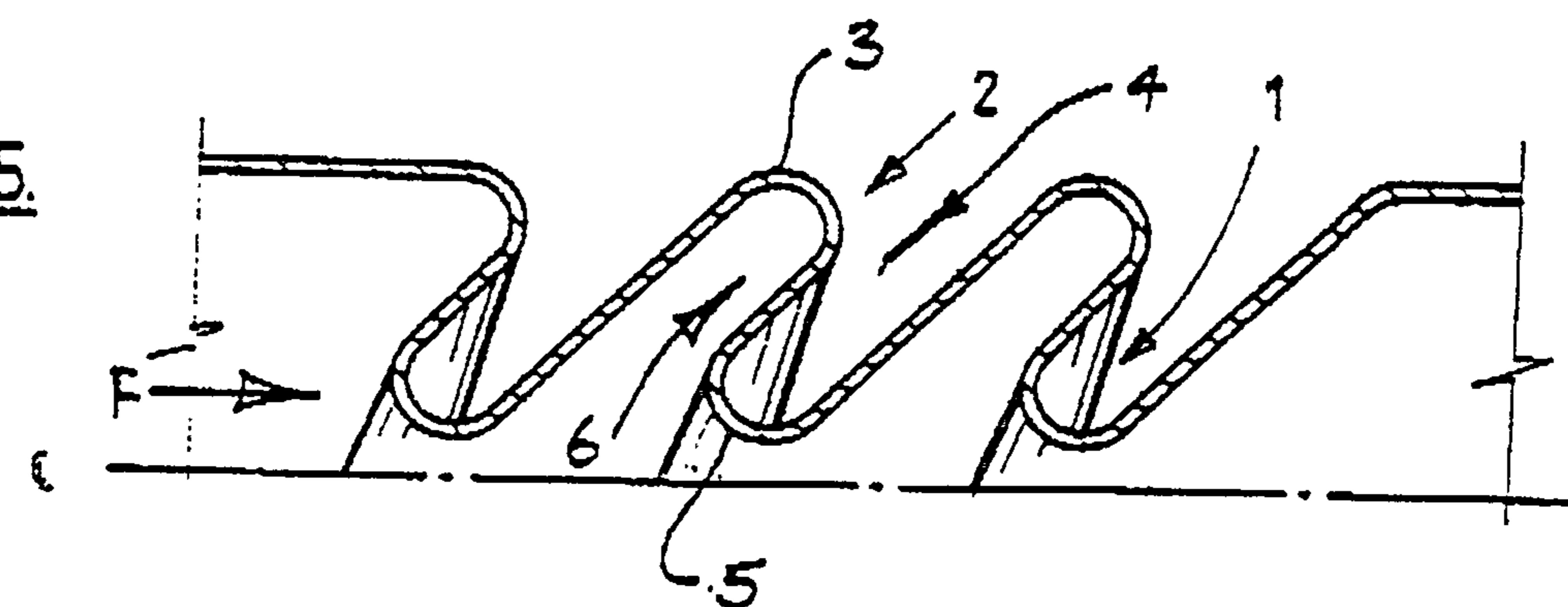
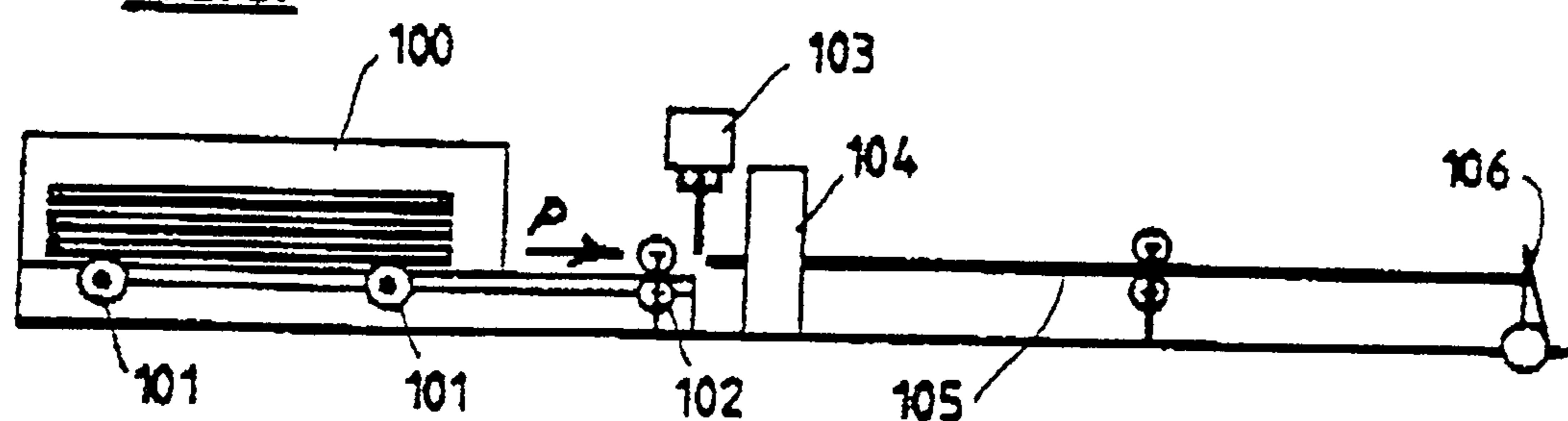
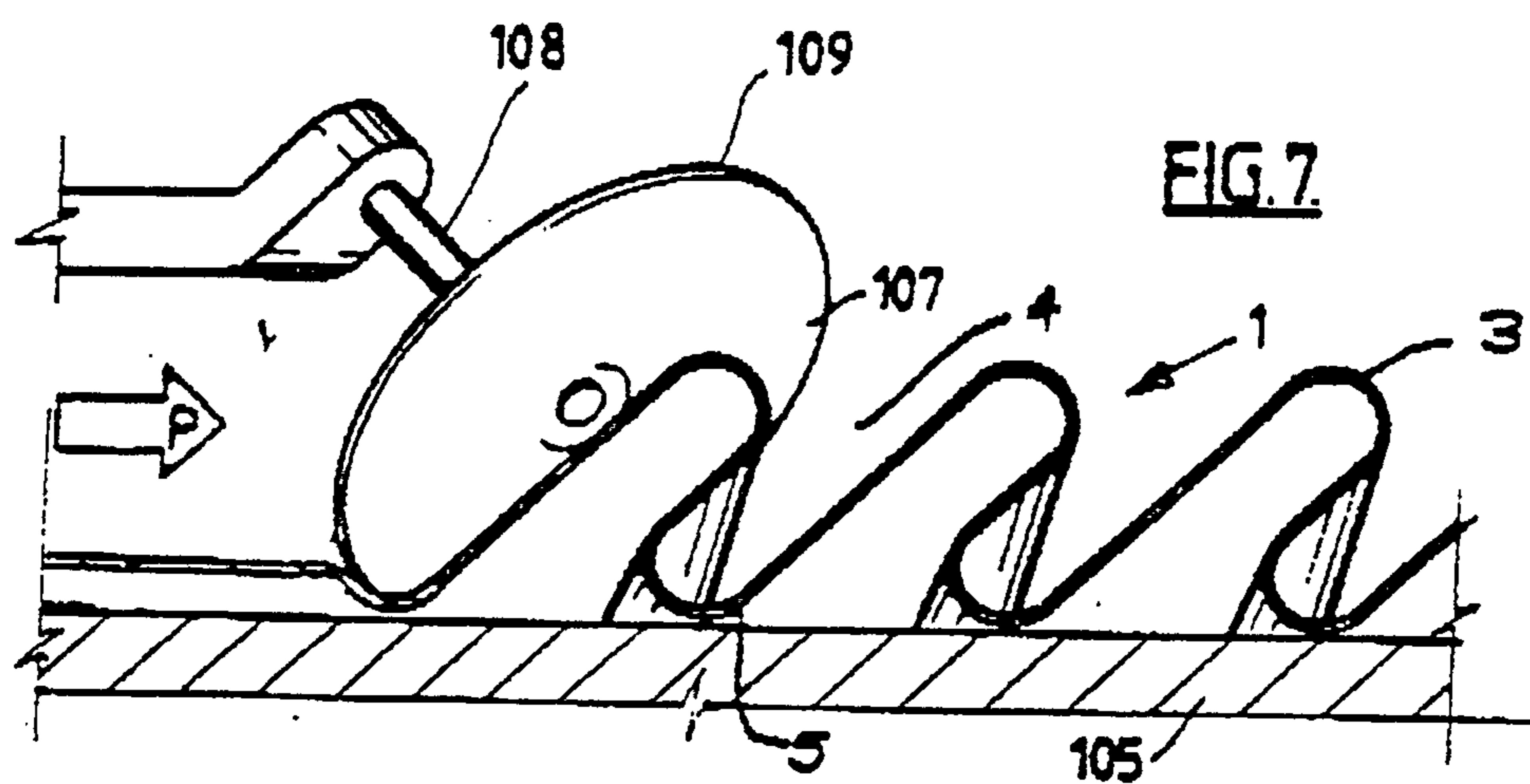
FIG.3.FIG.4.FIG.5.

FIG.6.FIG.7.FIG.8.