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13/836,299 15 March 2013 (15.03.2013) US(71) Applicant: FEDERAL-MOGUL POWERTRAIN, INC.
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(54) Title: CORRUGATED KNIT SLEEVE AND METHOD OF CONSTRUCTION THEREOF

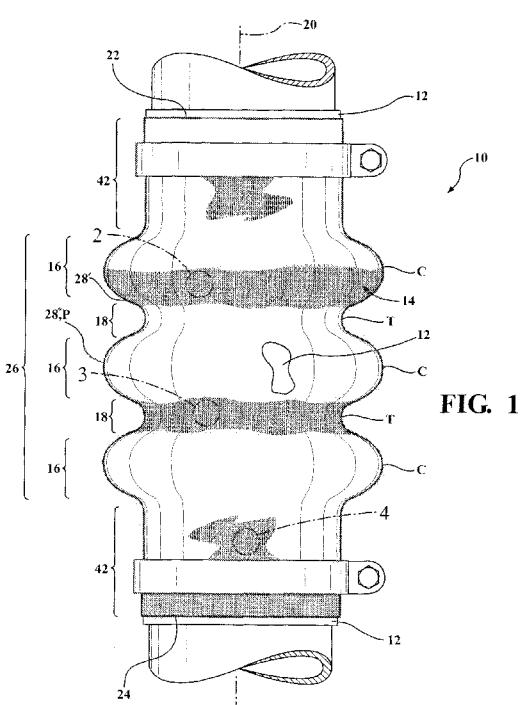


FIG. 1

(57) Abstract: A knit tubular sleeve for providing abrasion resistance and expansion restriction to an elastic elongate member extending therethrough and method of construction thereof is provided. The knit tubular sleeve includes a knit tubular wall extending along a longitudinal axis between opposite ends. The knit wall has a plurality of coaxially aligned first regions forming crests spaced axially from one another by intermediate second regions forming troughs between the crests. The first and second regions are knitted over a plurality of courses, with each of the courses comprising a plurality of knit stitches extending circumferentially around the longitudinal axis. The courses of the first regions are formed with a different pattern of knit stitches from the courses of the second regions, wherein the second regions provide the wall with a decreased capacity to expand radially relative to the first regions, thereby inhibiting the elongate member against radial expansion.



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KM, ML, MR, NE, SN, TD, TG).

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CORRUGATED KNIT SLEEVE AND METHOD OF CONSTRUCTION THEREOF

BACKGROUND OF THE INVENTION

1. Technical Field

[0001] This invention relates generally to protective tubular sleeves for providing protection to elongate members contained therein, and more particularly to corrugated knit tubular sleeves and to their method of construction.

2. Related Art

[0002] Corrugated rubber hoses are commonly used in various industries to provide a tubular member through which media can be routed, such as elongate members, fluid and gas. The corrugations of the hose provide enhanced radial crush strength, while at the same time providing enhanced flexibility to enable the hose to be routed over meandering paths without kinking. Although corrugated rubber hoses provide certain benefits, they also require being protected against abrasion and from radial expansion, particularly when used to route high pressure fluid or gas. Accordingly, a supplemental sleeve constructed to provide protection against abrasion coupled with a plurality of rigid annular anti-expansion rings to prevent radial expansion, such as, in addition to clamp rings, plastic or metal rings disposed along the length of the sleeve, are commonly used in combination with corrugated rubber hoses. Although the supplemental sleeve and anti-expansion rings provide abrasion and anti-expansion protection to the underlying rubber hose, they come at an added cost, both in manufacture and assembly.

SUMMARY OF THE INVENTION

[0003] In accordance with one aspect of the invention, a knit tubular sleeve for providing abrasion resistance and expansion restriction to an elongate member extending therethrough is provided. The knit tubular sleeve includes a knit tubular wall extending along a

longitudinal axis between opposite ends. The wall has a plurality of coaxially aligned first regions forming crests spaced axially from one another by intermediate second regions forming troughs between the crests. The first and second regions are knitted over a plurality of courses, with each of the courses comprising a plurality of knit stitches extending circumferentially around the longitudinal axis. The courses of the first regions are formed with a different pattern of knit stitches from the courses of the second regions and thereby provide the second regions with a decreased or restricted capacity to expand radially relative to the first regions, thereby inhibiting the elongate member from expanding radially and protecting the elongate member against rupture due to overexpansion.

[0004] In accordance with another aspect of the invention, the tubular wall further includes cylindrical regions knitted over a plurality of courses. Each of the cylindrical regions extends from one of the opposite ends toward an adjacent crest. The courses of the cylindrical regions are formed with a different pattern of knit stitches from the courses of the first and second regions.

[0005] In accordance with another aspect of the invention, the first regions are formed by one of 1 X 1 jersey knit stitches or interlocking knit stitches.

[0006] In accordance with another aspect of the invention, the second regions include missed-stitches.

[0007] In accordance with another aspect of the invention, the cylindrical regions include missed-stitches.

[0008] In accordance with another aspect of the invention, the crests formed by the first regions extend from radially innermost courses adjacent the troughs to radially outermost courses forming peaks, wherein the knit stitches of the peaks have stitch lengths greater than the knit stitches of the radially innermost courses.

[0009] In accordance with another aspect of the invention, the knit stitches in alternating courses of each of the first regions increase in length from the radially innermost course to the course forming the peak.

[0010] In accordance with another aspect of the invention, a method of constructing a tubular sleeve for preventing over expansion of an elongate corrugated member contained therein is provided. The method includes knitting a tubular wall from a plurality courses extending circumferentially about a longitudinal axis of the wall with the courses forming coaxially aligned first regions having crests and intermediate second regions forming troughs between adjacent crests. Further, knitting the courses of the first regions having a different pattern of knit stitches from the courses of the second regions to provide the second regions with a decreased capacity to expand radially relative to the first regions.

[0011] In accordance with another aspect of the invention, the method can further include knitting cylindrical regions from a plurality of courses extending from opposite ends of the tubular wall toward an adjacent crest and knitting the courses of the cylindrical regions with knit stitches having a different pattern from the knit stitches in the courses forming the first and second regions.

[0012] In accordance with another aspect of the invention, the method further includes knitting the first regions with one of 1 X 1 jersey knit stitches or interlocking knit stitches.

[0013] In accordance with another aspect of the invention, the method further includes knitting the second regions with missed-stitches.

[0014] In accordance with another aspect of the invention, the method further includes knitting the cylindrical regions with missed-stitches.

[0015] In accordance with another aspect of the invention, the method can further include forming the crests to extend from radially innermost courses adjacent the troughs to radially

outermost courses forming peaks and knitting the stitches forming the peaks with stitch lengths greater than stitch lengths of the knit stitches forming the radially innermost courses.

[0016] In accordance with another aspect of the invention, the method can further include knitting alternating courses of each of the first regions having knit stitches increasing in length moving from the radially innermost course to the course forming the peak.

BRIEF DESCRIPTION OF THE DRAWINGS

[0017] These and other aspects, features and advantages of the present invention will become more readily appreciated when considered in connection with the following detailed description of presently preferred embodiments and best mode, appended claims and accompanying drawings, in which:

[0018] Figure 1 is side view of a knit tubular sleeve constructed in accordance with one aspect of the invention shown having tubular member extending therethrough;

[0019] Figure 2A is an enlarged view of one embodiment of the encircled area 2 of Figure 1;

[0020] Figure 2B is an enlarged view of another embodiment of the encircled area 2 of Figure 1;

[0021] Figure 3A is an enlarged view of one embodiment of the encircled area 3 of Figure 1;

[0022] Figure 3B is an enlarged view of another embodiment of the encircled area 3 of Figure 1; and

[0023] Figure 4 is an enlarged view of the encircled area 4 of Figure 1.

DETAILED DESCRIPTION OF PRESENTLY PREFERRED EMBODIMENTS

[0024] Referring in more detail to the drawings, Figure 1 illustrates a knit tubular sleeve 10 for providing abrasion resistance and expansion restriction to an elongate member 12 extending therethrough, shown as a corrugated rubber hose. The inventive construction of a

knit tubular wall 14 of the sleeve 10 provides radially expandable first regions 16 that allows the wall 14 to readily conform to the corrugations of the rubber hose 12 while also having radially inflexible second regions 18 that restrict the radial expansion of the rubber hose 12 while high pressure fluid or gas flows therethrough, thereby preventing the hose 12 from rupturing. Further, the sleeve 10 is lightweight, flexible, economical in construction and in assembly, and has a high level of resistance to abrasion.

[0025] The wall 14 of the sleeve 12 extends along a longitudinal axis 20 between opposite ends 22, 24. The wall 14 includes a plurality of the first regions 16, which are coaxially aligned with one another and form crests (C) spaced axially from one another by the intermediate second regions 18, which form troughs (T) between the crests. Accordingly, the first and second regions 16, 18 provide the sleeve 12 with a corrugated region 26 configured to conform to the corrugations of the hose 12. The first and second regions 16, 18 are knitted over a plurality of respective circumferentially extending courses 28, 30, wherein each of the courses 28, 30 comprising a plurality of respective knit stitches 32, 33 extending circumferentially around the longitudinal axis 20. The courses 28 of the first regions 16 are formed with knit stitches 32 of a different stitch pattern from the courses 30 of the second regions 18, wherein the stitch pattern of the first regions 16 allow for at least some radial expansion and the stitch pattern of the second regions 18 inhibit radial expansion. Accordingly, the second regions 18 provide a decreased capacity to expand radially relative to the first regions 16.

[0026] The first regions 16 are formed by one of jersey knit stitches in a 1X1 stitch pattern 34 (Figure 2A) or an interlocking knit stitch pattern 35 (Figure 2B). These types of patterns have a continuous string of knit loops of yarns interlinked with one another, wherein the interlinked knit loops allow for radial expansion. By allowing radial expansion, the first regions 16 are able to readily conform to the corrugated shape of the hose 12 passing through

the sleeve 10. The crests C of the first regions 16 extend from radially innermost courses 28' adjacent the troughs T to radially outermost courses 28" forming peaks P. The knit stitches forming the radially outermost courses 28" of the peaks P have stitch lengths greater than the knit stitches forming the radially innermost courses 28' of the crests C. The knit stitches in alternating courses 28 of each of the first regions 16 increase in length from the radially innermost course 28' to the radially outermost course 28" forming the peak P. Accordingly, reduced length knit stitches are adjacent the troughs T, while increased length knit stitches are adjacent the peaks P, with intermediate length knit stitches being between the troughs T and the peaks P. The reduced length knit stitches provide enhanced radial expansion, while the increased length knit stitches have less capacity for radial expansion, thereby providing the desired balance of radial expansion and restriction within the crests C. The axial length of the first regions 16 can be formed as desired to ensure conformity with the crests of the underlying hose, and in one example, the first regions 16 are constructed having 24 courses, which, as discussed above, include knit stitches that increase in length every 2 courses moving radially outwardly from the trough T to the peak P.

[0027] In contrast, the second regions 18 are formed by missed-stitches, wherein the missed-stitches are formed by skipping at least 3 needles, also referred to as a 3 needle skip twill pattern 36 (Figure 3A), or by skipping more needles, such as 4 needles, also referred to as a 4 needle skip twill pattern 38 (Figure 3B). By skipping needles, straight float portions FP of the yarns are formed. The straight float portions FP inherently have minimal capacity to stretch, given they are already straight or substantially straight, in contrast to the continuous string of loops forming the first regions 16. The axial length of the second regions 18 can be formed as desired to ensure conformity with the troughs of the underlying hose, and in one example, the second regions 18 are constructed having 24 courses, with 20 intermediate courses being knit with a 3 or 4 needle skip twill pattern, as discussed above,

and 2 outermost courses on each side of the intermediate courses being knit include knit with interlock stitches.

[0028] In addition to the first and second regions 16, 18, the tubular wall 14 further includes cylindrical regions 42 knitted via knit stitches 43 over a plurality of courses 44. Each of the cylindrical regions 42 extends from one of the opposite ends 22, 24 toward an adjacent crest C of the nearest or adjacent first region 16. The courses 44 of the cylindrical regions 42 are formed with a different pattern of knit stitches 43 from the knit stitches 32, 33 forming the courses 28, 30 of the respective first and second regions 16, 18. Like the second regions 18, the cylindrical regions 42 are formed with missed-stitches, however, the missed-stitches of the cylindrical regions 42 are formed by skipping 2 needles, also referred to as a 2 needle skip twill pattern 46 (Figure 4). As such, the cylindrical regions 42 have a decreased ability to expand radially relative to the first regions 16, but have an increased ability to expand radially relative to the second regions 18. Although having a decreased ability to expand radially relative to the first regions 16, the abrasion resistance of the cylindrical regions 42 is increased relative to the first regions 16, thereby providing the cylindrical regions 42 with a knit pattern capable of meeting the requirements for clamps to be installed thereon. The axial length of the cylindrical regions 42 can be formed as desired to ensure substantial conformity in length with the cylindrical ends of the underlying hose, and in one example, the cylindrical regions 42 are constructed having 30 courses.

[0029] Many modifications and variations of the present invention are possible in light of the above teachings. It is, therefore, to be understood that the invention may be practiced otherwise than as specifically described, and that the scope of the invention is defined by any ultimately allowed claims.

What is claimed is:

1. A knit tubular sleeve for providing abrasion resistance and expansion restriction to an elongate member extending therethrough, comprising:
a knit tubular wall extending along a longitudinal axis between opposite ends, said wall having a plurality of coaxially aligned first regions forming crests spaced axially from one another by intermediate second regions forming troughs between said crests, said first and second regions being knitted over a plurality of courses, each of said courses comprising a plurality of knit stitches extending circumferentially around said longitudinal axis, said courses of said first regions being formed with knit stitches of a different stitch pattern from said courses of said second regions and thereby providing said second regions with a decreased capacity to expand radially relative to said first regions.
2. The knit tubular sleeve of claim 1 wherein said wall further includes cylindrical regions knitted over a plurality of courses, each of said cylindrical regions extending from one of said opposite ends toward an adjacent crest, said courses of said cylindrical regions being formed with a different pattern of knit stitches from said courses of said first and second regions.
3. The knit tubular sleeve of claim 1 wherein said first regions are formed by one of 1 X 1 jersey knit stitches or interlocking knit stitches.
4. The knit tubular sleeve of claim 1 wherein said second regions include missed-stitches.

5. The knit tubular sleeve of claim 3 wherein said second regions include missed-stitches.
6. The knit tubular sleeve of claim 5 wherein said second region missed-stitches skip at least 3 needles.
7. The knit tubular sleeve of claim 6 wherein said second region missed-stitches skip 4 needles.
8. The knit tubular sleeve of claim 2 wherein said cylindrical regions include missed-stitches.
9. The knit tubular sleeve of claim 8 wherein said cylindrical region missed-stitches skip 2 needles.
10. The knit tubular sleeve of claim 1 wherein said crests formed by said first regions extend from radially innermost courses adjacent said troughs to radially outermost courses forming peaks, said knit stitches of said peaks having stitch lengths greater than said knit stitches of said radially innermost courses.
11. The knit tubular sleeve of claim 9 wherein said knit stitches in alternating courses of each of said first regions increase in length from said radially innermost course to said course forming said peak.

12. A knit tubular sleeve for providing abrasion resistance and expansion restriction to an elongate member extending therethrough, comprising:

a knit tubular wall extending along a longitudinal axis between opposite ends, said wall having a plurality of coaxially aligned first regions forming crests spaced axially from one another by intermediate second regions forming troughs between said crests, said first and second regions being knitted over a plurality of courses, each of said courses comprising a plurality of knit stitches extending circumferentially around said longitudinal axis, said courses of said first regions being formed with different pattern of knit stitches from said courses of said second regions, wherein said first regions are formed by one of 1 X 1 jersey knit stitches or interlocking knit stitches and said second regions include missed-stitches, thereby providing said second regions with a decreased capacity to expand radially relative to said first regions; and

cylindrical regions knitted over a plurality of courses, each of said cylindrical regions extending from one of said opposite ends toward an adjacent crest, said courses of said cylindrical regions being formed with a different pattern of knit stitches from said courses of said first and second regions, wherein said cylindrical regions include missed-stitches.

13. A method of constructing a tubular sleeve, comprising:

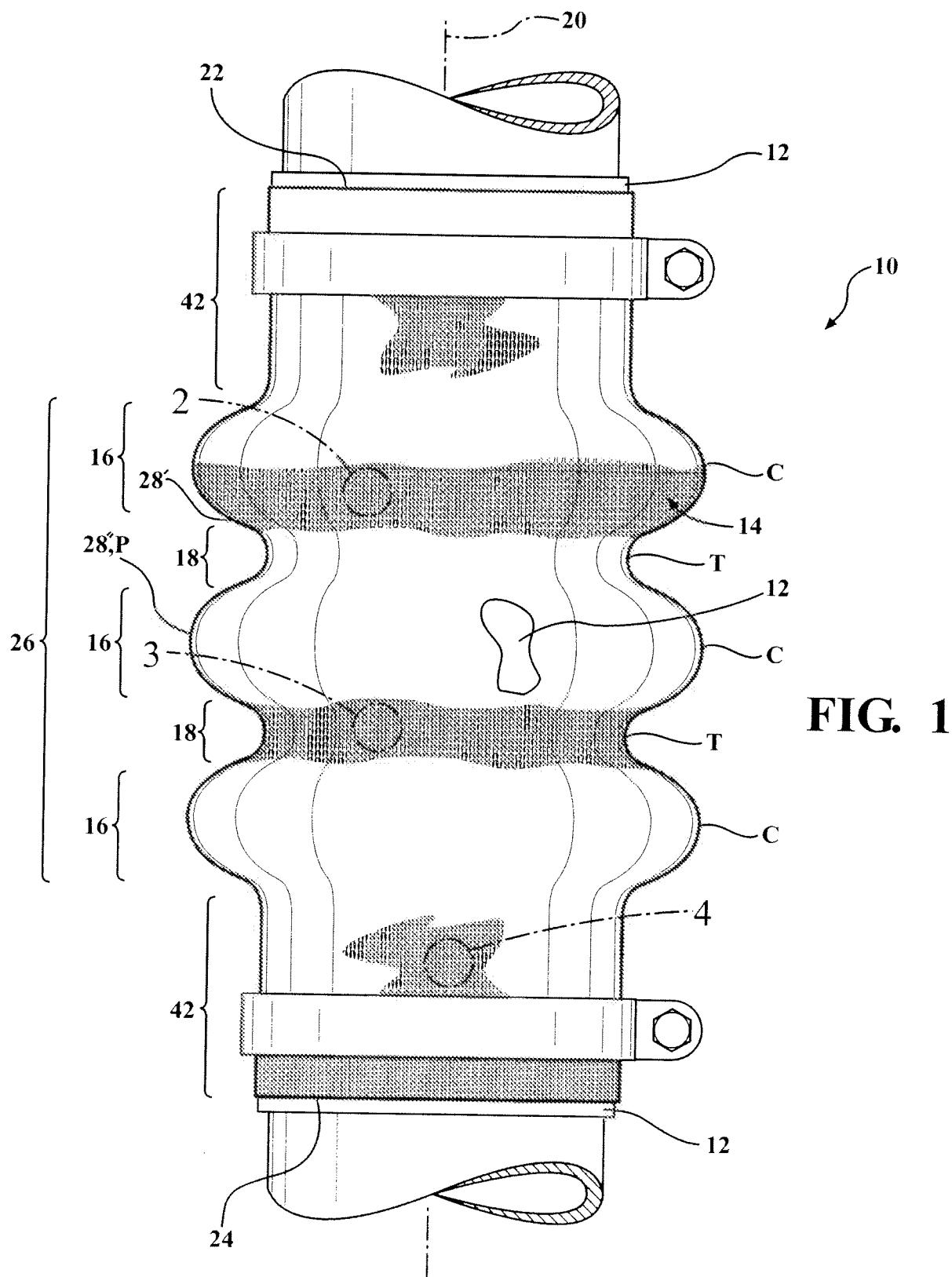
knitting a tubular wall from a plurality courses extending circumferentially about a longitudinal axis of the wall with the courses forming coaxially aligned first regions having crests and intermediate second regions forming troughs between adjacent crests; and

knitting the courses of the first regions having a different pattern of knit stitches from the courses of the second regions to provide the second regions with a decreased capacity to expand radially relative to the first regions.

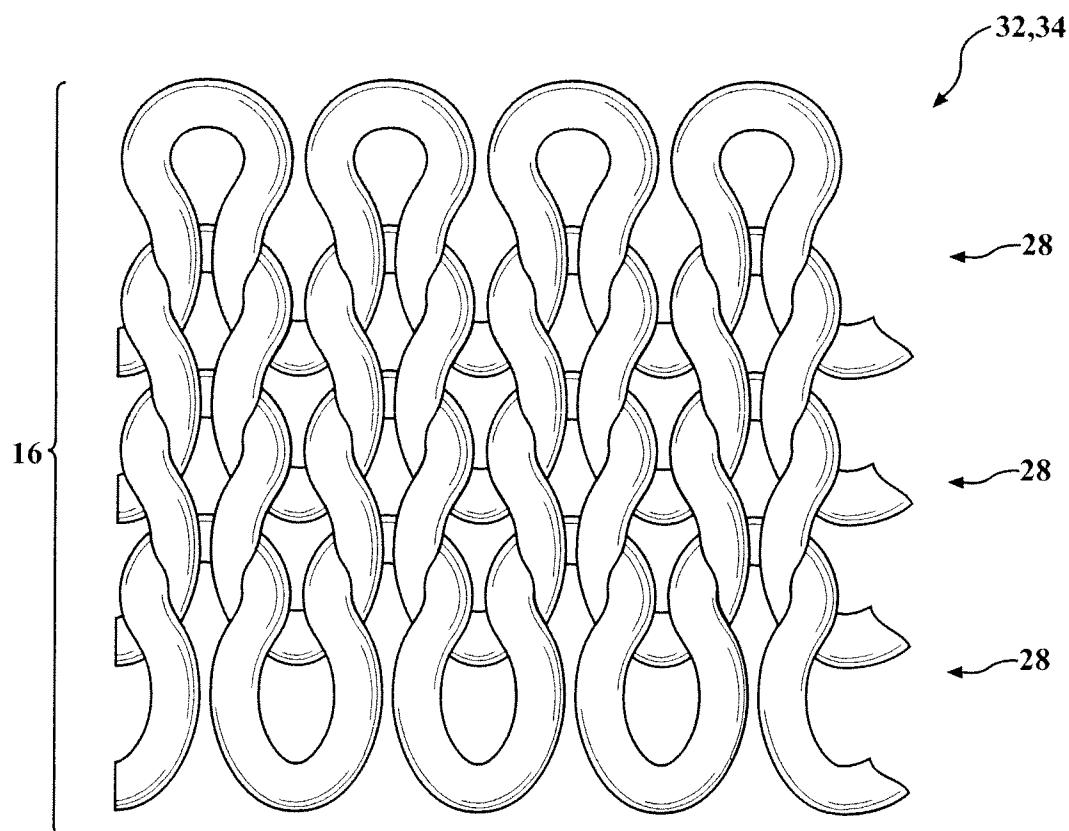
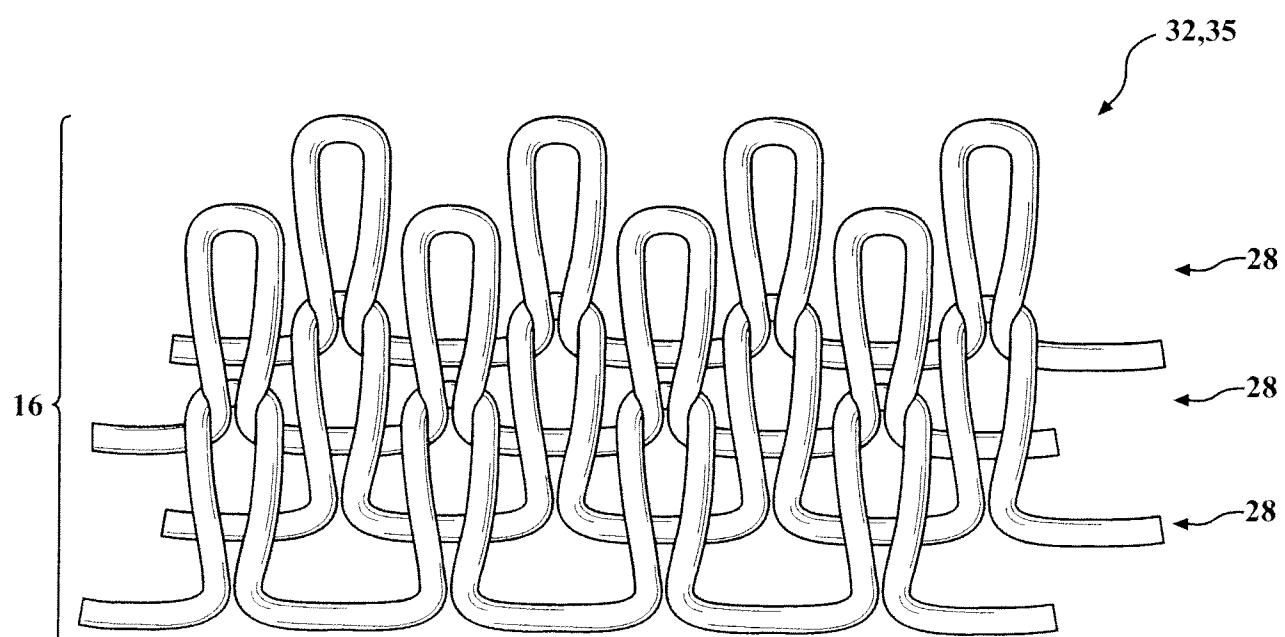
14. The method of claim 13 further including knitting cylindrical regions from a plurality of courses extending from opposite ends of the tubular wall toward an adjacent crest and knitting the courses of the cylindrical regions with knit stitches having a different pattern from the knit stitches in the courses forming the first and second regions.
15. The method of claim 13 further including knitting the first regions with one of 1 X 1 jersey knit stitches or interlocking knit stitches.
16. The method of claim 13 further including knitting the second regions with missed-stitches.
17. The method of claim 15 further including knitting the second regions with missed-stitches.
18. The method of claim 17 further including skipping at least 3 needles to form the second region missed-stitches.
19. The method of claim 18 further including skipping 4 needles to form the second region missed-stitches.
20. The method of claim 14 further including knitting the cylindrical regions with missed-stitches.
21. The method of claim 20 further including skipping 2 needles to form the cylindrical region missed-stitches.

22. The method of claim 13 further including forming the crests to extend from radially innermost courses adjacent the troughs to radially outermost courses forming peaks and knitting the stitches forming the peaks with stitch lengths greater than stitch lengths of the knit stitches forming the radially innermost courses.

23. The method of claim 22 further including knitting alternating courses of each of the first regions having knit stitches increasing in length moving from the radially innermost course to the course forming the peak.



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**FIG. 2A****FIG. 2B**

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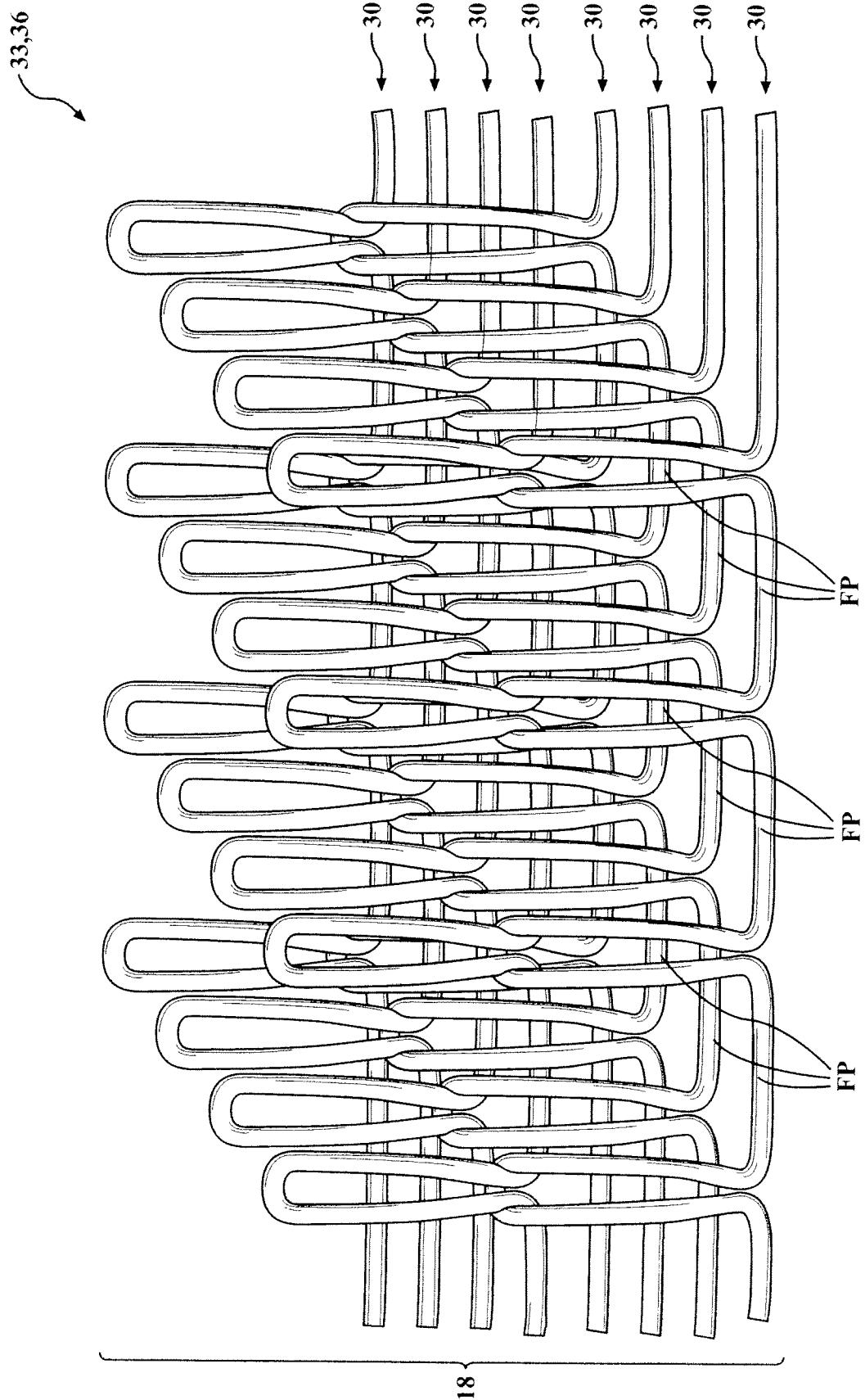
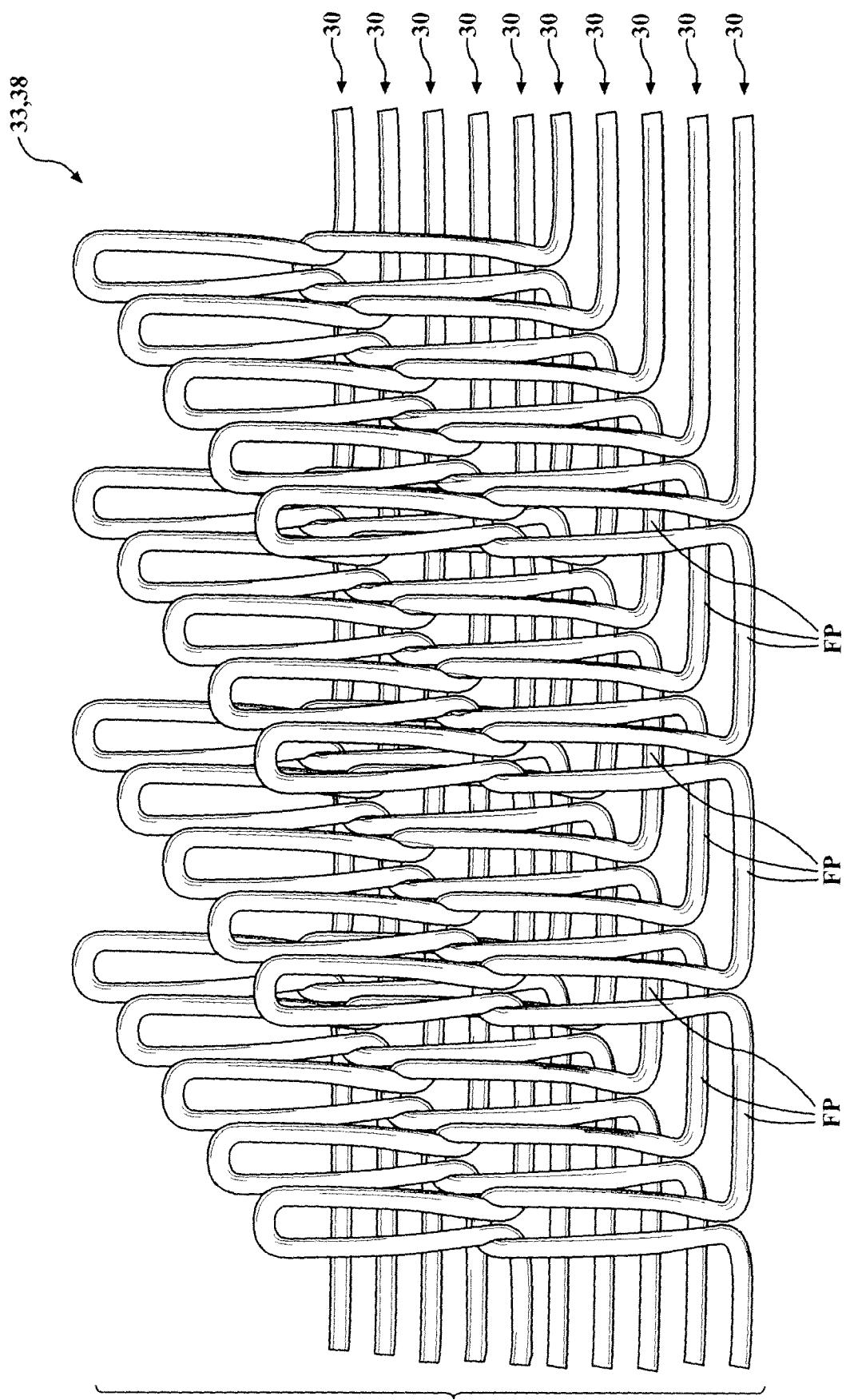


FIG. 3A

**FIG. 3B**

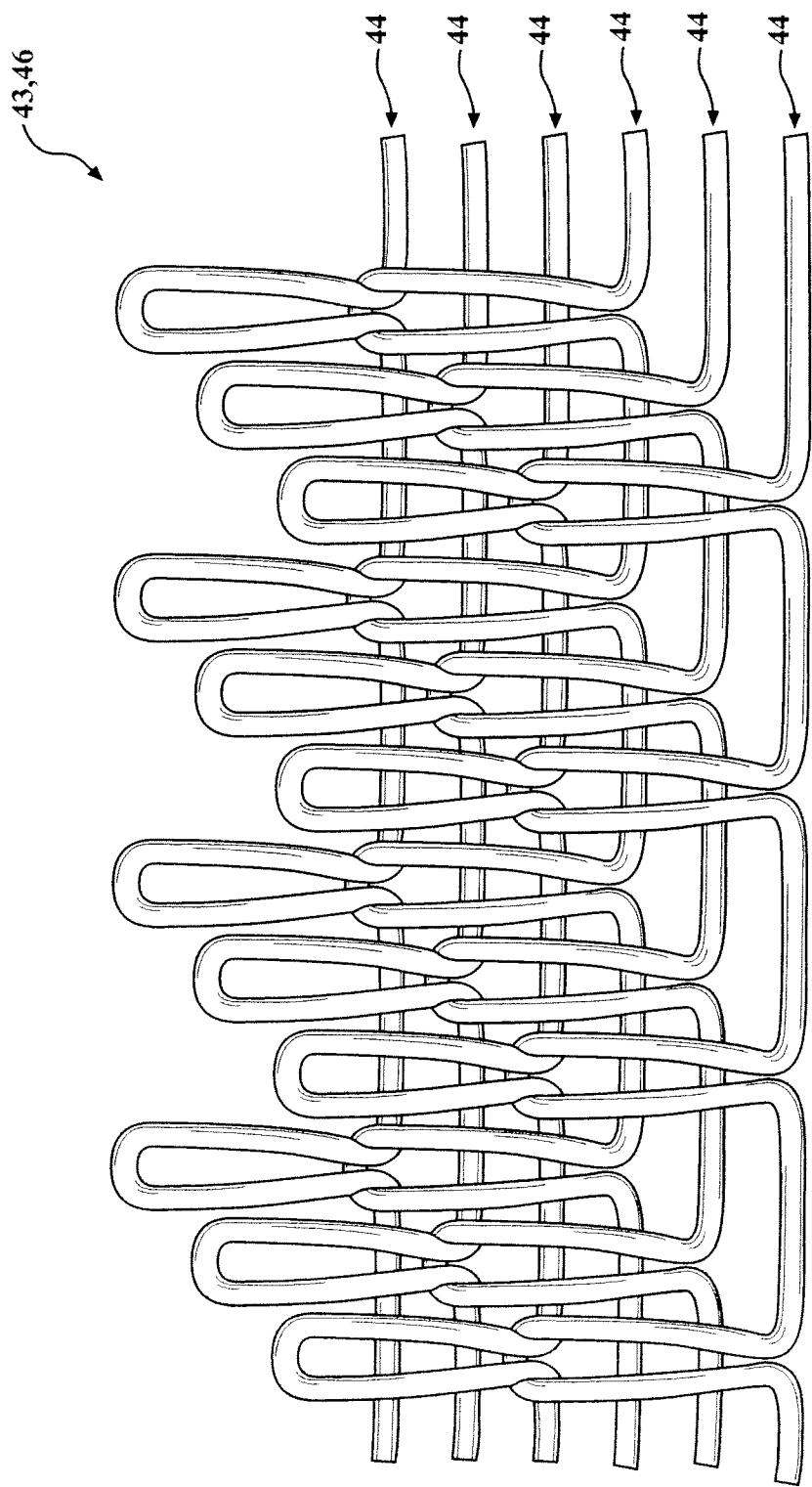


FIG. 4

INTERNATIONAL SEARCH REPORT

International application No
PCT/US2014/019717

A. CLASSIFICATION OF SUBJECT MATTER
INV. D04B1/22 F16L57/02 F16L57/06
ADD.

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)
D04B F16L

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 practicable, search terms used)

EPO-Internal, WPI Data

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	EP 2 312 192 A1 (FEDERAL MOGUL POWERTRAIN INC [US]) 20 April 2011 (2011-04-20) paragraphs [0008], [0029] - paragraph [0031]; figures 1-4 ----- EP 1 775 811 A1 (RELATS SA [ES]) 18 April 2007 (2007-04-18) paragraphs [0001], [0014]; figures 1-4 -----	1-23
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Further documents are listed in the continuation of Box C.

See patent family annex.

* Special categories of cited documents :

"A" document defining the general state of the art which is not considered to be of particular relevance
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Date of the actual completion of the international search

Date of mailing of the international search report

16 May 2014

26/05/2014

Name and mailing address of the ISA/
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INTERNATIONAL SEARCH REPORT

Information on patent family members

International application No PCT/US2014/019717

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