OPIC
OFFICE DE LA PROPRIÉTÉ INTELLECTUELLE DU CANADA

CIPO
CANADIAN INTELLECTUAL PROPERTY OFFICE

(12) (19) (CA) **Demande-Application**

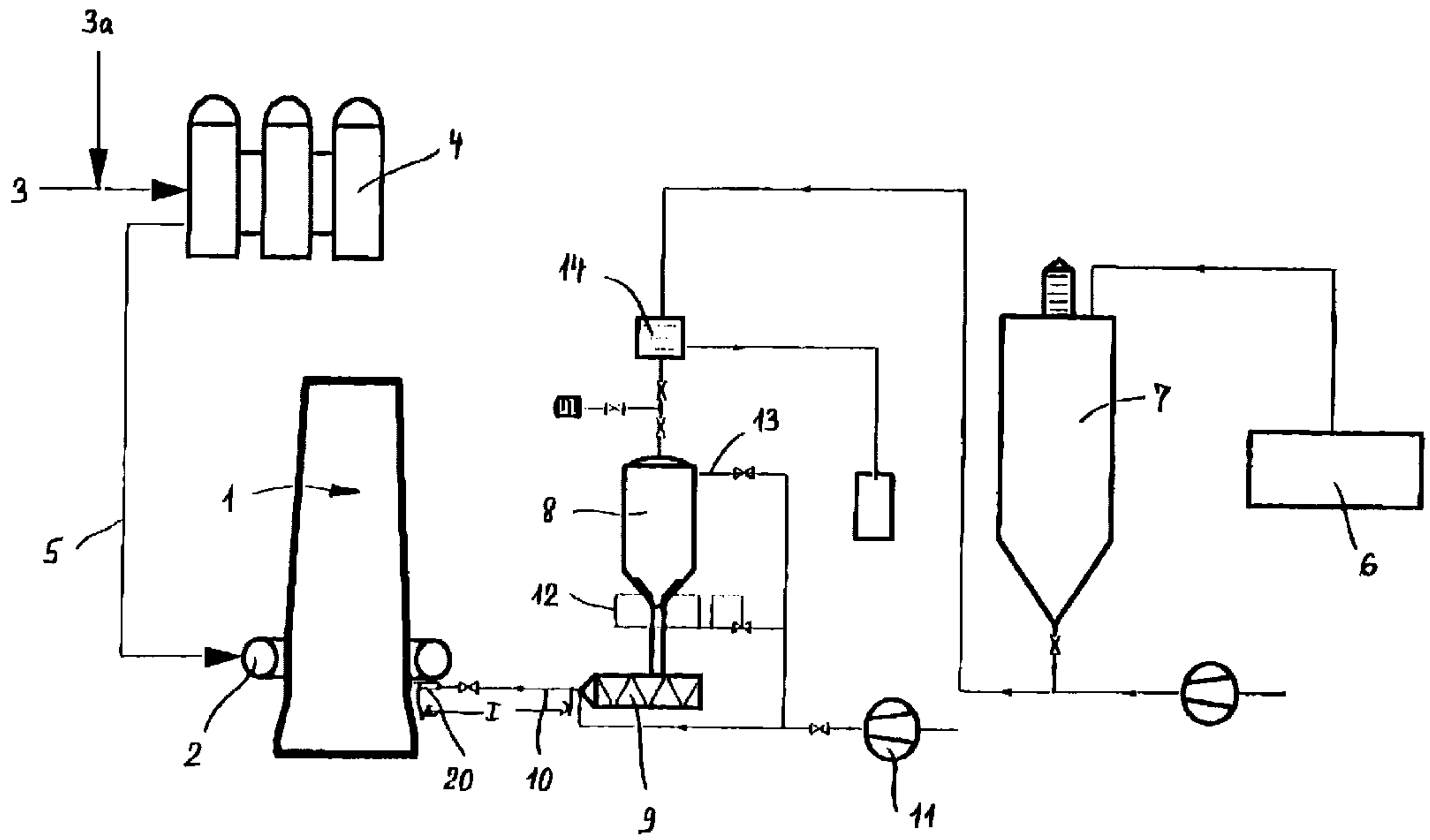
(21) (A1) **2,261,501**
(22) 1999/02/12
(43) 2000/06/22

(72) JANZ, Joachim, DE
(72) VOSS, Manfred, DE
(71) DER GRÜNE PUNKT - DSD DUALES SYSTEM DEUTSCHLAND AG, DE

(51) Int.Cl.^{6} C21B 5/00, C21B 7/00
(30) 1998/12/22 (198 59 354.6) DE

(54) **PROCEDE ET APPAREIL DE PRODUCTION DE METAL A PARTIR DE MINERAIS METALLIQUES**

(54) **PROCESS AND APPARATUS FOR PRODUCING METAL FROM METAL ORES**



(57) The invention concerns a process and en apparatus for producing metal from metal ores, in particular crude or pig iron from iron ore, in which the ore which contains metal oxides is brought into reaction contact with a reducing gas which contains carbon and/or hydrogen (and possibly compounds thereof) and which was previously obtained from solid, carbon-bearing and/or hydrocarbon-bearing substances, It is known that the ore which for the major part comprises metal oxides (being various ones, even in the case of iron) must be subjected to a reduction procedure before the metal can be obtained. Taking the known process as set forth in the opening part of this specification as its basic starting point, the object of the invention is to make plastic waste, including in organically and/or inorganically

OPIC
Office de la propriété intellectuelle du Canada

CIPO
Canadian Intellectual Property Office

(21) (A1) 2,261,501
(22) 1999/02/12
(43) 2000/06/22

contaminated form, useable as a supplier for the constituents of the reducing gas. Plastic waste occurs constantly in large amounts and represents a serious disposal problem. It occurs mostly if not exclusively in solid form, either as packaging waste - which is frequently heavily contaminated -, or as offcuts or the like in the course of the production of plastic articles. Accordingly the invention provides that the carbon-bearing and/or hydrocarbon-bearing substances, at least partially comprising plastic material, which in the process of the general kind set forth in the opening part of this specification are supplied to obtain the reducing gas, are injected in comminuted fluidised form as an agglomerate into the air flow in the hearth of the metallurgical shaft or pit furnace, in particular a blast furnace. That is effected by way of lances which project into the shaft furnace and which are connected to a transport conduit. The plastic material to be injected is fed to the lances by way of that transport conduit. In the event that, contrary to expectation, blockages should occur or hot air should blow back out of the blast furnace into the lance and thus into the transport conduit, a plurality of shut-off or check devices are proposed in the transport conduit, so that the transport conduit is not only protected but immediate resumption of overall operation of the installation and injection of the plastic materials occurs. To dissolve blockages of the plastic material in the transport conduit, there are provided a first and third shut-off device, while a second shut-off device is provided to prevent reverse transportation of plastic material or blow-back of the hot gas masses from the blast furnace into the transport conduit. The mode of operation thereof is set forth in greater detail in the claims but in particular also in the specific description.

Abstract

The invention concerns a process and an apparatus for producing metal from metal ores, in particular crude or pig iron from iron ore, in which the ore which contains metal oxides is brought into reaction contact with a reducing gas which contains carbon and/or hydrogen (and possibly compounds thereof) and which was previously obtained from solid, carbon-bearing and/or hydrocarbon-bearing substances. It is known that the ore which for the major part comprises metal oxides (being various ones, even in the case of iron) must be subjected to a reduction procedure before the metal can be obtained. Taking the known process as set forth in the opening part of this specification as its basic starting point, the object of the invention is to make plastic waste, including in organically and/or inorganically contaminated form, useable as a supplier for the constituents of the reducing gas. Plastic waste occurs constantly in large amounts and represents a serious disposal problem. It occurs mostly if not exclusively in solid form, either as packaging waste - which is frequently heavily contaminated -, or as offcuts or the like in the course of the production of plastic articles. Accordingly the invention provides that the carbon-bearing and/or hydrocarbon-bearing substances, at least partially comprising plastic material, which in the process of the general kind set forth in the opening part of this specification are supplied to obtain the reducing gas, are injected in comminuted fluidised form as an agglomerate into the air flow in the hearth of the metallurgical shaft or pit furnace, in particular a blast furnace. That is effected by way of lances which project into the shaft furnace and which are connected to a transport conduit. The plastic material to be injected is fed to the lances by way of that transport conduit. In the event that, contrary to expectation, blockages should occur or hot air should blow back out of the blast furnace into the lance and thus into the transport conduit, a plurality of shut-off or check devices are proposed in the transport conduit, so that the transport conduit is not only protected but immediate resumption of overall operation of the installation and injection of the plastic materials occurs. To dissolve blockages of the plastic material in the transport conduit, there are provided a first and third shut-off device, while a second shut-off device is provided to prevent reverse transportation of plastic material or blow-back of the hot gas masses from the blast furnace into the transport conduit. The mode of operation thereof is set forth in greater detail in the claims but in particular also in the specific description.

Figur 1

The invention concerns a process and an apparatus for producing metal from metal ores, in particular crude or pig iron from iron ore, in which the ore which contains metal oxides is brought into reaction contact with a reducing gas which contains carbon and/or hydrogen (and possibly compounds thereof) and which was previously obtained from solid, carbon-bearing and/or hydrocarbon-bearing substances.

It is known that the ore which for the major part comprises metal oxides (being various ones, even in the case of iron) must be subjected to a reduction procedure before the metal can be obtained. That reduction operation is effected by means of carbon and possibly hydrogen - or also compounds thereof - which are contained in a reducing gas which is caused to act on the metal ore.

The reduced metal ore then passes into a smelting procedure. In that case, the gas required for the reduction operation is obtained in the region of the reducing and smelting procedure itself, by carbon-bearing substances (for example coke, coal, oil, natural gas) being added to the zone of the metal which has already been reduced and heated, whereby, with the addition of oxygen (in the air), they are broken up or converted in carbon-bearing gas which is fed to the preceding reduction operation.

The conventional blast furnace process is known in that respect, in which both reduction of the metal ore and also formation of the reducing gas as well as subsequent smelting liquefaction of the metal occur in the blast furnace - progressively in a downward direction. In that blast furnace process, among additive substances, coke is possibly mixed with the iron ore, as a carbon carrier. It is also known for oil or carbon also to be injected by way of lances into the air flow in the region of the hearth of the blast furnace for better control of the blast furnace process and to save on coke, the consumption of coke thereby also being reduced. This material (oil or coal dust) which is additionally injected must be introduced in very finely distributed form in order to ensure clean adequate gasification. Two articles in the journal "Stahl und Eisen", 101 (1981) of 12 January 1981, pages 35 - 38 and 105 (1985), No 4 of 25 February 1985, pages 211-220 contain summaries relating to the injection of coal dust in blast furnaces. The injection of coal dust was forced upon operators in particular in the course of rising oil prices. In that respect it was found that when adopting the injection procedure, because of the short time available of about 10 ms, good results, more specifically almost complete gasification of the coal dust, were to be achieved only with grain sizes of below 0.1 mm, even if tests were also successfully carried out with some installations, using larger grain sizes.

It has also already been proposed that, instead of injecting oil and coal dust, other carbon-bearing waste substances such as for example dried sewage sludge or other carbon-bearing waste such as refuse, waste paper, lignite, as well as waste from wood, plastic material, rubber or the like can be introduced (DE-A 29 35 544). In regard to appropriate tests or results however, all that was put forward were assumptions as to the manner in which such substances are to be introduced into the blast furnace. DE-A 41 04 252 also proposes introducing plastic-bearing waste substances of that kind into a blast furnace in fine-grain and dust form by way of the tuyères, with the introduction of sewage sludge (dust capable of trickle flow) being referred to by way of example. With this process also the need for the substance which is to be injected to be of a fine-grain nature is expressly emphasised.

Taking the known process as set forth in the opening part of this specification as its basic starting point, the object of the invention is to make plastic waste, including in organically and/or inorganically contaminated form, useable as a supplier for the constituents of the reducing gas. Plastic waste occurs constantly in large amounts and represents a serious disposal problem. It occurs mostly if not exclusively in solid form, either as packaging waste - which is frequently heavily contaminated - , or as offcuts or the like in the course of the production of plastic articles.

Accordingly the invention provides that the carbon-bearing and/or hydrocarbon-bearing substances, at least partially comprising plastic material, which in the process of the general kind set forth in the opening part of this specification are supplied to obtain the reducing gas, are injected in comminuted fluidised form as an agglomerate into the air flow in the hearth of the metallurgical shaft or pit furnace, in particular a blast furnace. That is effected by way of lances which project into the shaft furnace and which are connected to a transport conduit. The plastic material to be injected is fed to the lances by way of that transport conduit. In the event that, contrary to expectation, blockages should occur or hot air should blow back out of the blast furnace into the lance and thus into the transport conduit, a plurality of shut-off or check devices are proposed in the transport conduit, so that the transport conduit is not only protected but immediate resumption of overall operation of the installation and injection of the plastic materials occurs. To dissolve blockages of the plastic material in the transport conduit, there are provided a first and third shut-off device, while a second shut-off device is provided to prevent reverse transportation of plastic material or blow-back of the hot gas masses from the blast furnace into the transport conduit. The mode of operation thereof is set forth in greater detail in the claims but in particular also in the specific description.

To dissolve blockages in the transport conduit, the invention makes use of the fact that the pressure in the transport conduit is a pressure which is

4 to 6 times as great as atmospheric pressure. If therefore the pressure in the interior of the transport conduit is reduced to atmospheric pressure (about 1 bar) by way of a vent opening, a very great pressure and suction effect is applied to the blockages which in that case are released and conveyed out of the system from the transport conduit.

So that the injection lances which project into the blast furnace do not overheat when the injection installation in a stopped condition, there is provided a connection for compressed air which is always activated then.

Further advantageous configurations of the invention are set forth in the appendant claims.

The invention is described in greater detail hereinafter by means of an embodiment by way of example with reference to the accompanying drawings in which:

Figure 1 is a diagrammatic view of a blast furnace including the appropriate devices for the feed of fluidised plastic material and including the appropriate devices for the feed of a heated air flow,

Figure 2 shows an alternative embodiment,

Figure 3 shows a nozzle-lance arrangement for the injection of fluidised plastic material into the tuyères or nozzles of a blast furnace, and

Figure 4 is a view on an enlarged scale of the transport conduit for transporting the plastic material to the lance.

Referring to Figure 1, shown therein is a blast furnace 1 which is of the usual structure and which in the lower hearth region has a plurality of nozzles or tuyères 20 (see Figure 3) which are distributed uniformly around the periphery and to which air 3 heated in an air heater 4 is fed by way of a conduit 5 and a ring conduit or manifold 2. In addition the air 3 can also be enriched with oxygen 3a (O_2). For the sake of simplicity, only one nozzle 20 is indicated in Figure 1.

Some or all of the nozzles 20 have one or more lances 18, by way of which the additional fuel can be injected. In the previously known blast furnaces, that was either coal dust or oil, whereby it was possible to achieve an improved operating performance for the blast furnace 1 and a saving on coke. The usual number of nozzles 20 of the tuyère arrangement is for example 32 and each nozzle is of a diameter of for example 140 mm. In regard to the feed of coal dust or oil, there are usually two lances which are of a diameter of typically 12 or 8 mm. In the present case, there is in each nozzle 20 only one lance 18 for the feed of fluidised plastic material, and it is for example of a diameter of 28 mm.

In the tuyère arrangement, either all lances 18 can be supplied with fluidised plastic material, or the nozzles 20 are equipped in a mixed or hybrid fashion, that is to say some nozzles have for example two oil lances while other nozzles 20 are in turn equipped with a plastic material lance 18. It is however desirable for the distribution of plastic material lances 18 and oil lances to be effected in uniform relationship around the periphery of the tuyère arrangement.

In the present embodiment preparation and processing of the plastic material is effected in the following manner:

From a plastic material preparation installation 6, comminuted plastic material is fed to a silo 7, in the form of an agglomerate of high specific surface area and with a grain size of 1 to 10 mm, preferably 5 mm. The use of plastic material which results in an agglomerate with a bulk density of greater than 0.35×10^3 kg/m^3 has proved itself worthwhile. Plastic material packaging cups or the like are suitable for those purposes, while for example plastic films or sheets, upon comminution thereof, result in a lower bulk density, so that special precautions must be taken prior to or upon injection, in order to be able to inject an adequate quantity.

Figure 1 then shows an injection vessel 8 into which the plastic material agglomerate is introduced by way of a course grain sieve 14 and fluidised by the injection of a fluidisation gas by means of a blower 11 by way of conduits 12 and 13. With an injection vessel of a volume for example of 3m^3, about 2 to 25 m^3 of fluidisation gas/h is required. The fluidised plastic material is then metered in a separate metering device 9, for example a mechanical screw-type metering device or a cellular-wheel metering device, and uniformly fed by way of a conduit 10 to the appropriate lances 18 of the tuyère arrangement. In this case, the plastic material particles are conveyed by means of flying flow conveyance, that is to say with a high proportion of gas, for example with a ratio of 5 to 30 kg of plastic material per 1 kg of fluidisation gas. In the present example air under pressure is used as the fluidisation gas as there is no risk of explosion, due to the size of the plastic material particles of from 1 to 10 mm.

The amount of plastic material injected can be varied over wide limits (for example 30-150 kg of plastic material/t pig iron). It was also found that, with equally good gasification, an amount of plastic material in comparison with oil, that is higher by a factor of 1.5, can be injected. If the injection amount of plastic material is above 70 kg/t pig iron, then desirably O_2 is added to the air flow for the purposes of good gasification, as already mentioned above. For each kg of plastic material/t pig iron above the value of 70 kg/t pig iron, the air should then be enriched with 0.05 to 0.1% O_2, preferably 0.08%. For a good gasification effect the mixed air temperature from the air heater 4 is above 1100°C. The injection pressure at the lances 18 is desirably 0.5×10^5 to 1.5×10^5 Pa above the pressure in the blast furnace 1.

As plastic material melts at relatively high temperatures - in contrast to coal dust or oil - there is the danger of the plastic material suffering from baking-on phenomena before issuing from the injection lance 18 due to heat being radiated back from the nozzle. For that reason the flow speed of the gas with the plastic material particles in suspension must be sufficiently high, in comparison with the tube cross-section of the lance 18, in order to prevent the plastic material from starting to melt or fuse on and thus suffer from baking phenomena in the lance 18 due to heat being radiated back. A suitable ratio of the linear velocity to the lance cross-section is in the range of 20000 to 40000 $s^{-1}m^{-1}$, preferably at 25000 $s^{-1}m^{-1}$. If that value is too low, there is the risk of baking phenomena occurring, while if the value is too high, a too high level of wear occurs in the lances 18. In addition, in all transport conduits, in particular also in the connecting region 18a of the lances 18, it is necessary to avoid discontinuities and non-uniformities and constrictions in the flow configuration and radii of smaller than 1 m in the case of bends and curves.

In the arrangement shown in Figure 1 the metering effect is implemented by a separate metering device 9. Another construction is shown in Figure 2 and can provide that fluidisation and metering are effected in one operation. For that purpose a ball valve 19 is provided as the metering device in the lower region of the injection vessel. Fine setting is effected by way of the pressure setting and the amount of fluidisation gas. That construction however requires fast accurate regulation of the feed of air under pressure at the upper conduit 13 of the injection vessel 8 in dependence on the fluctuating internal pressure in the blast furnace 1. Therefore, provided for that purpose at a suitable location in the blast furnace 1 is a pressure sensor which rapidly adjusts a valve in the conduit 13 by way of a regulating loop 17 in order to arrive at an accurate metering effect.

Fluidisation and metering of the plastic material particles can also be implemented by means of a pressure-tight cellular-wheel lock assembly. In this case the injection vessel 8 can be omitted.

Figure 4 is a view on an enlarged scale of the portion, indicated at I in Figures 1 and 2, of the conduit 10 by way of which the plastic materials to be injected into the blast furnace 1, in particular plastic waste, in agglomerated form, are transported to the lance 18. Adjoining the fittings in the injection tower (they include for example the metering device 9 but also for example the connection for the compressed air or the supply for flushing air/nitrogen) that transport conduit 10 is formed by a hose portion 21. Joined thereto is a shut-off block or unit 22 of the transport conduit 10 and joined in turn to the shut-off block or unit 22 in the direction of the injection lance 18 is an essential lance fitting portion 23 including the injection lance 18.

The shut-off block or unit 22 includes as a first shut-off device 24 a shut-off valve which is closed to eliminate blockages (will be referred to hereinafter). In addition, a vent conduit (opening) 25 extends in the shut-off block or unit 22 from the transport conduit 10. The vent conduit (opening) 25 has a shut-off valve 26.

Connected to the shut-off block or unit 22 is the region of the transport conduit 10, which is also referred to hereinafter as the fitting portion 23 of the lance. Disposed within that fitting portion 23 is a hose portion 27 which connects the transport conduit 10 of the shut-off block or unit 22 to a heat shut-off or check valve 28 as a second shut-off device. Joined to that second shut-off device is a third shut-off device 29 for shutting off the lance 18. Positioned downstream of the third shut-off device (as viewed from the shut-off block or unit 22) is a mouth portion 30 by way of which compressed air can be injected by means of a connecting portion 31 into the lance 18 and thus into the blast furnace 1.

The mode of operation of the above-described arrangement is as follows: if for any reason no plastic material or other reducing agent is being injected into the blast furnace, the shut-off device 29 is closed and the connection 31 is opened and compressed air is then blown into the lance, when the injection installation is in a stopped condition. The operation of injecting that compressed air is implemented either manually or automatically whenever the transport of plastic materials to the lance is interrupted. That introduction of compressed air prevents the injection lance from heating up to an undesirably high degree, and heat damage is thus precluded. The connection 31 for the introduction of compressed air into the lance is opened whenever the feed of plastic materials to the lance is closed by the third shut-off device. The connecting portion 31 itself essentially comprises a valve which is connected to a compressed air reservoir.

So that, in the event of pressure fluctuations in the tuyère - which repeatedly undesirably occur - a return flow of hot tuyère gas from the tuyère (blast furnace) into the lance and the injection system behind same can be prevented, the heat shut-off valve which is in the form of a non-return valve is provided as the second shut-off device. That heat shut-off valve can be a simple flap which permits the transport of material/air to the lance (and is therefore then opened), but it is automatically closed in the opposite direction by the material/gas reverse flow.

The plastic agglomerates which are to be injected into the blast furnace have a tendency to cause blockages in the conduit 10 in dependence on their grain shape and size but also their specific composition, and that should be prevented as described hereinbefore. If nonetheless such a blockage (plug) occurs, a rapid blockage-removal operation must be effected. The shut-off block or unit is designed for that purpose, wherein, in the event of a blockage occurring, after closure of the shut-off valves (first and/or third shut-off device), a vent fitting or the vent valve 26 is opened. That venting action is effected by way of the outside atmosphere, with the consequence that a pressure drop of nearly 4 to 6 bars is to be recorded between the transport conduit 10 in the part in question by way of the vent conduit 25 while the total pressure drop by way of the conduit from the injection fittings to the injection lance is only about 0.5 to 0.8 bar. Due to the extremely high air pressure drop, a considerable pressure is applied to the plastic material causing the blockage, and that results in the abrupt removal of blockages in the transport conduit so that the transport conduit is then again available, after closure of the valve 26, for injection of the agglomerated plastic materials.

CLAIMS

1. A process for producing metal from metal ores, in particular pig iron from iron ore, wherein the ore containing metal oxides is brought into reaction contact with a reducing gas which contains carbon and/or hydrogen (and possibly compounds thereof) and which was previously obtained from solid, carbon-bearing and/or hydrocarbon-bearing substances, characterised in that plastic material is injected in comminuted, fluidised form as an agglomerate into the air flow in the hearth of a metallurgical shaft furnace, in particular a blast furnace (1), that the plastic material is injected into the air flow by way of lances (18) which are arranged in air nozzles of a blast furnace, that the plastic material is conveyed by way of a transport conduit (10) to the lances (18), that the plastic material transport conduit (10) has a first shut-off device (24), a second shut-off device (28) and a third shut-off device (29), that further provided in the transport conduit or in the lance are means (31) for coupling in compressed air, that the first shut-off device (24) is closed when blockages of the plastic material in the transport conduit (10) or the lance (18) occur, that the second shut-off device (28) is closed when hot air penetrates by way of the injection lance (18) into the transport conduit (10) and/or the lance (18) in the opposite direction to the usual transport direction (R_T) and that the third shut-off device (29) is closed when compressed air is supplied by way of the injection lance (18) for cooling same.

2. A process according to claim 1 characterised in that a vent outlet (26) is provided in the transport conduit (10) between the first and second shut-off devices and upon blockage of the transport conduit with plastic material the first shut-off device (24) blocks further transportation of plastic material and a vent opening (26) in the conduit (10) is opened so that plastic material particles forming a blockage can be discharged from the transport conduit (10).

3. A process according to claim 1 or claim 2 characterised in that the second shut-off device (28) is a heat shut-off valve with the function of a check valve which permits the transportation of plastic material in the prescribed direction in the transport conduit but closes when plastic material particles or gas are moved in the opposite direction to the prescribed transport direction.

4. A process according to one of the preceding claims characterised in that the third shut-off device (29) is activated when no plastic material is

injected and that then compressed air is simultaneously injected for cooling the lance (18).

5. A process according to one of the preceding claims characterised in that the plastic material to be injected is discharged into the transport conduit from a plastic material reservoir by way of a lock assembly.

6. A process according to one of the preceding claims characterised in that the pressure drop by way of the transport conduit to the blast furnace is about 0.3 to 1 bar and that the pressure difference between the interior of the transport conduit and the outer atmosphere is about 4 to 6 bars.

7. A process according to one of the preceding claims characterised in that the plastic material is in the form of an agglomerate with a high specific surface area with a particle size of about 3 to 25 mm and a bulk density of greater than 0.25×10^3 kg/m^3.

8. A process according to one of the preceding claims characterised in that the injection pressure in the lances is 0.5×10^5 to 1.5×10^5 Pa above the pressure in the blast furnace.

9. A process according to one of the preceding claims characterised in that before being introduced into the transport conduit the plastic material particles are successively fluidised and metered in separate devices.

10. A process according to one of the preceding claims characterised in that the plastic material particles are fluidised and metered in a combined fluidising and metering device, wherein the injection pressure is constantly adapted in dependence on the furnace pressure by way of a fast regulating loop (17).

11. A process according to claim 10 characterised in that a pressure-tight cell-wheel lock assembly is used as the combined fluidising and metering device.

12. Apparatus for carrying out the process according to one of the preceding claims comprising a lance (18), by means of which plastic material can be injected in comminuted, fluidised form as an agglomerate into the air flow in the hearth of a metallurgical shaft furnace, in particular a blast furnace (1), characterised in that the lance (18) is supplied by way of a transport conduit (10) with plastic material or another reducing agent, that

provided in the transport conduit (10) are a first shut-off device (24), a second shut-off device (28) and a third shut-off device (29), that there is further provided a connection (31) for the introduction of air into the transport conduit (10) and/or the lance (18), that the first shut-off device (24) is activated when the transport conduit (10) becomes blocked with plastic material, that the second shut-off device (28) is activated when plastic material or gas is transported in the opposite direction to the intended transport direction, and that the third shut-off device (29) is activated when no plastic material is injected and that then a gas is injected by way of the connection (31) to cool the lances (19).

13. Apparatus according to claim 12 characterised in that a vent outlet (26) is provided in the transport conduit (10) between the first and second shut-off devices and upon blockage of the transport conduit with plastic material the first shut-off device (24) blocks the further transportation of plastic material and the vent opening (26) is opened so that plastic material particles forming the blockage can be discharged from the transport conduit (10).

14. Apparatus according to claim 12 or claim 13 characterised in that the second shut-off device (28) is a heat shut-off valve with the function of a check valve which permits the transportation of plastic material in the prescribed direction (R_T) in the transport conduit (10) but which closes when plastic material or gas is moved in the opposite direction to the intended transport direction.

15. Apparatus according to claim 12, claim 13, or claim 14 characterised in that the third shut-off device (29) is activated when no plastic material is injected and that compressed air is then injected to cool the lance.

16. A blast furnace for producing metal from metal ores, in particular pig iron from iron ore, in which the ore containing metal oxide is brought into reducing contact with a reducing gas which contains carbon and/or hydrogen (and possibly compounds thereof) and which was previously obtained from solid, carbon-bearing and/or hydrocarbon-bearing substances, comprising a device for injecting plastic material in comminuted, fluidised form as an agglomerate into the air flow in the hearth of the blast furnace, wherein the plastic material is injected into the air flow by way of lances (18) which are arranged in air nozzles of the blast furnace, and that the plastic material is conveyed by way of a transport conduit (10) to the lances (18), that the plastic material transport conduit (10) has a first shut-off device (24), a

second shut-off device (28) and a third shut-off device (29), and that means (31) for coupling in compressed air are further provided in the transport conduit (10) or in the lance (18), that the first shut-off device (24) closes when blockages of the plastic material occur in the transport conduit (10) or the lance (18), that the second shut-off device (28) closes when hot air/plastic material penetrates by way of the injection lance in the transport conduit in the opposite direction to the usual transport direction and that the third shut-off device (29) closes when compressed air is supplied by way of the injection lance for cooling thereof.

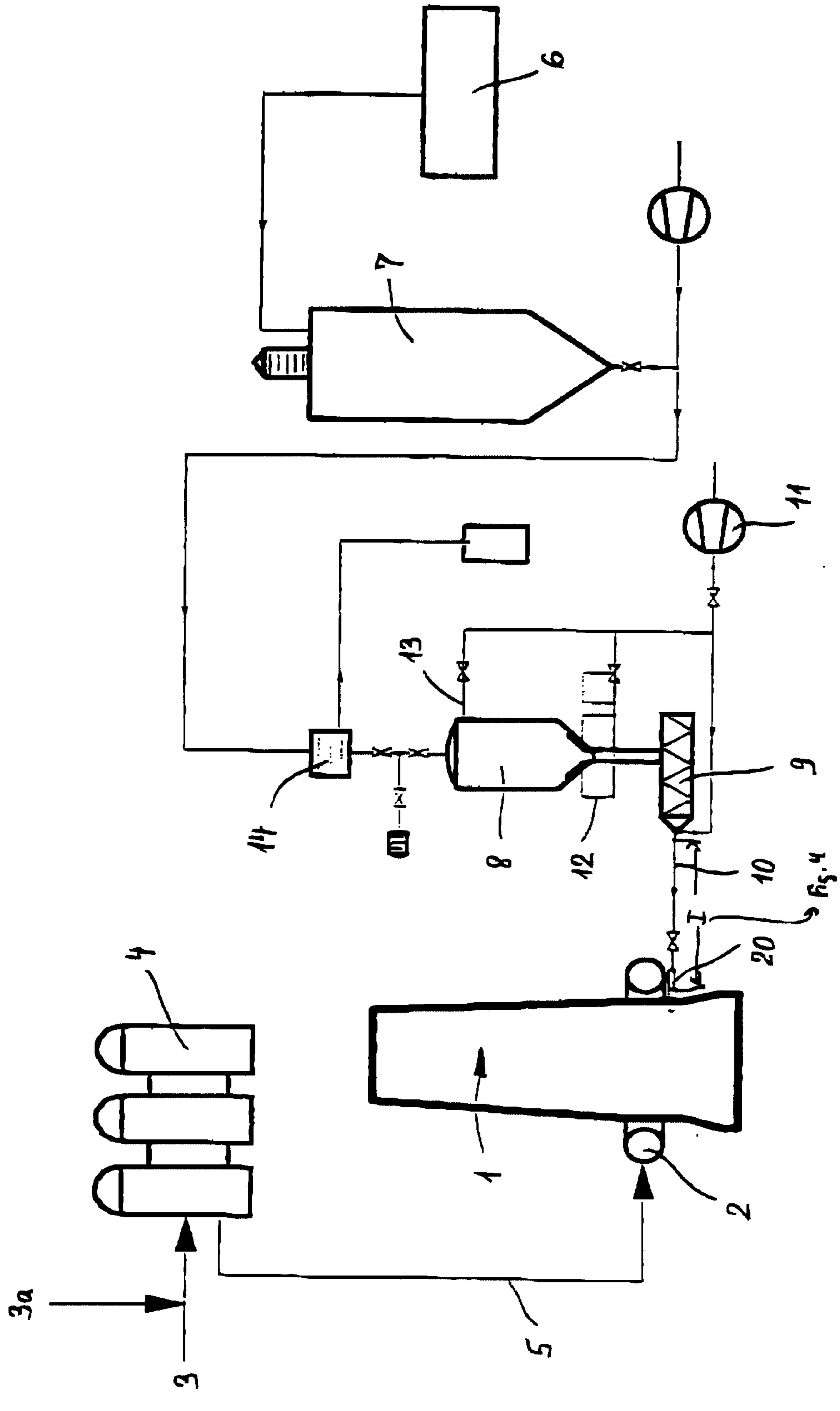


Fig. 1

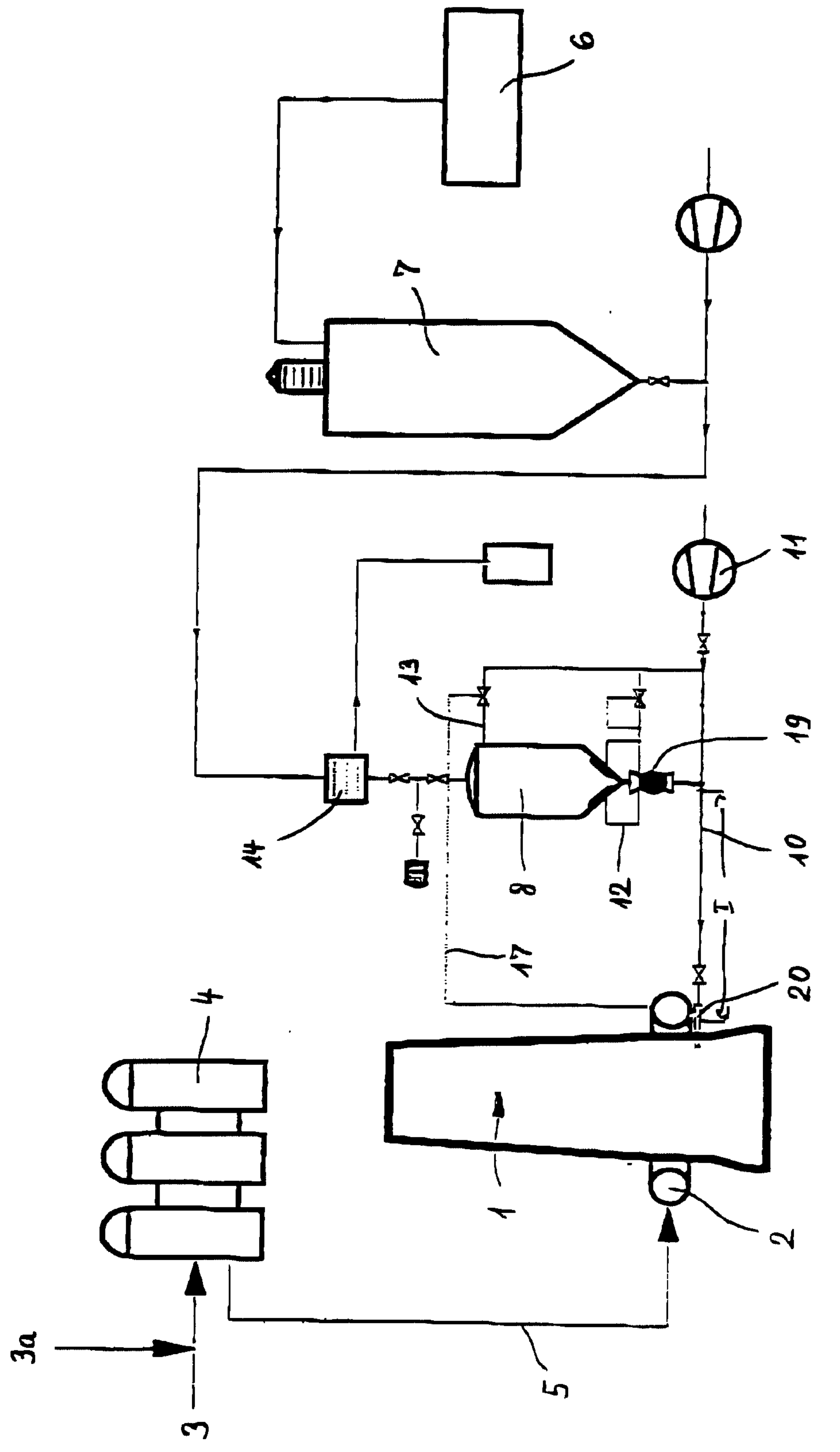


Fig. 2

CA 02261501 1999-02-12

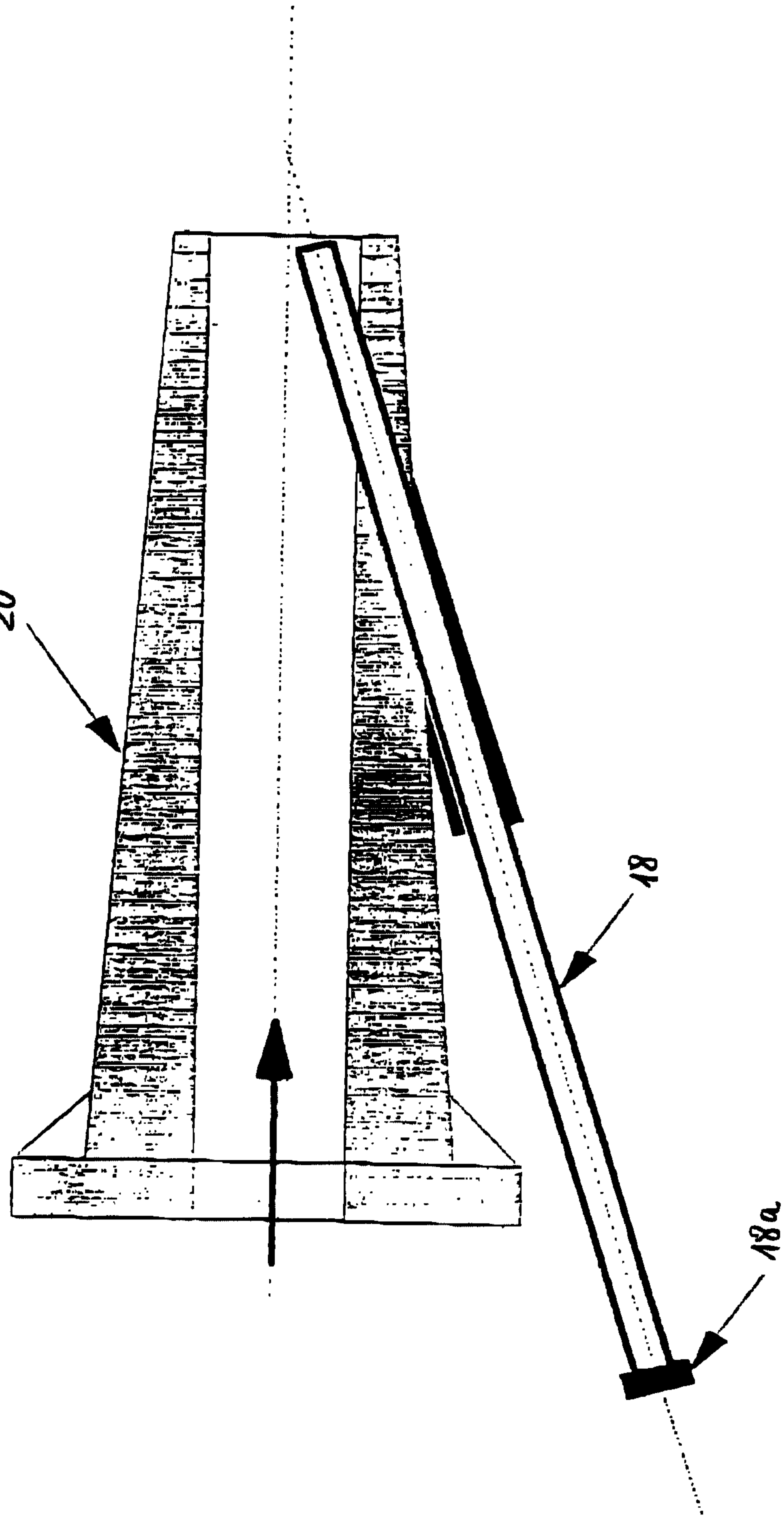


Fig. 3

CA 02261501 1999-02-12

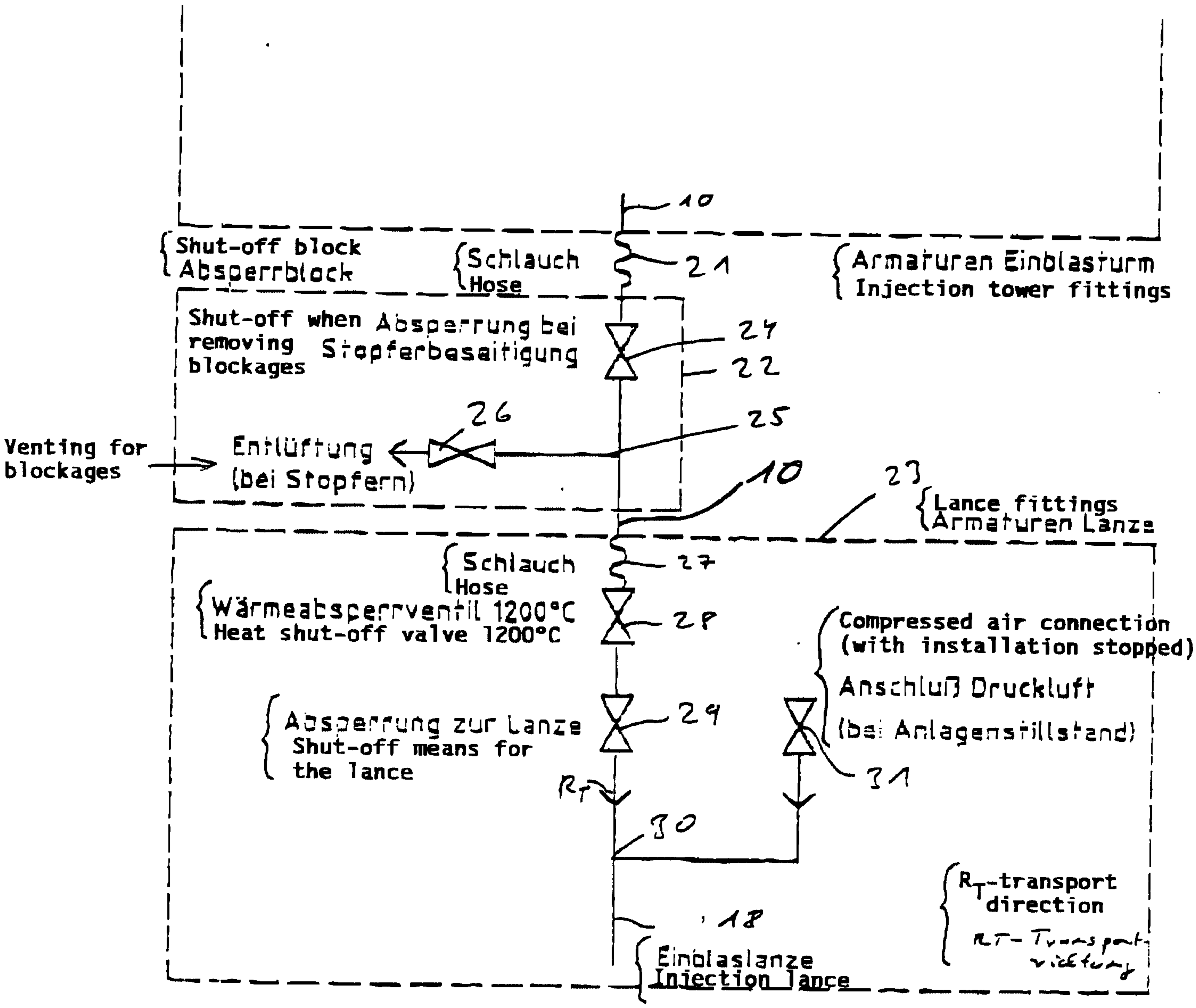


Fig. 4

CA 02261501 1999-02-12