June 11, 1974 R. E. HINELINE Re. 28,043

METHOD OF BUILDING A TIRE CASING FROM A STRIP OF RUBBER

Original Filed July 26, 1967 4 Sheets-Sheet 1

FIG. 1

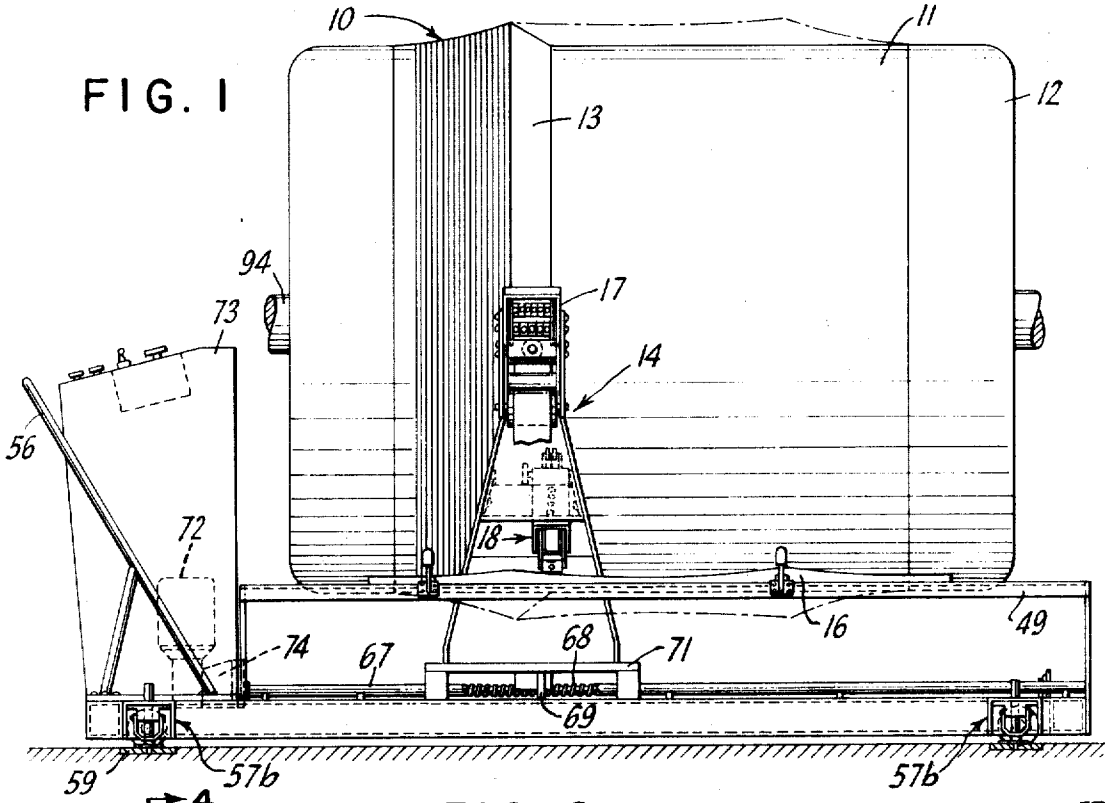
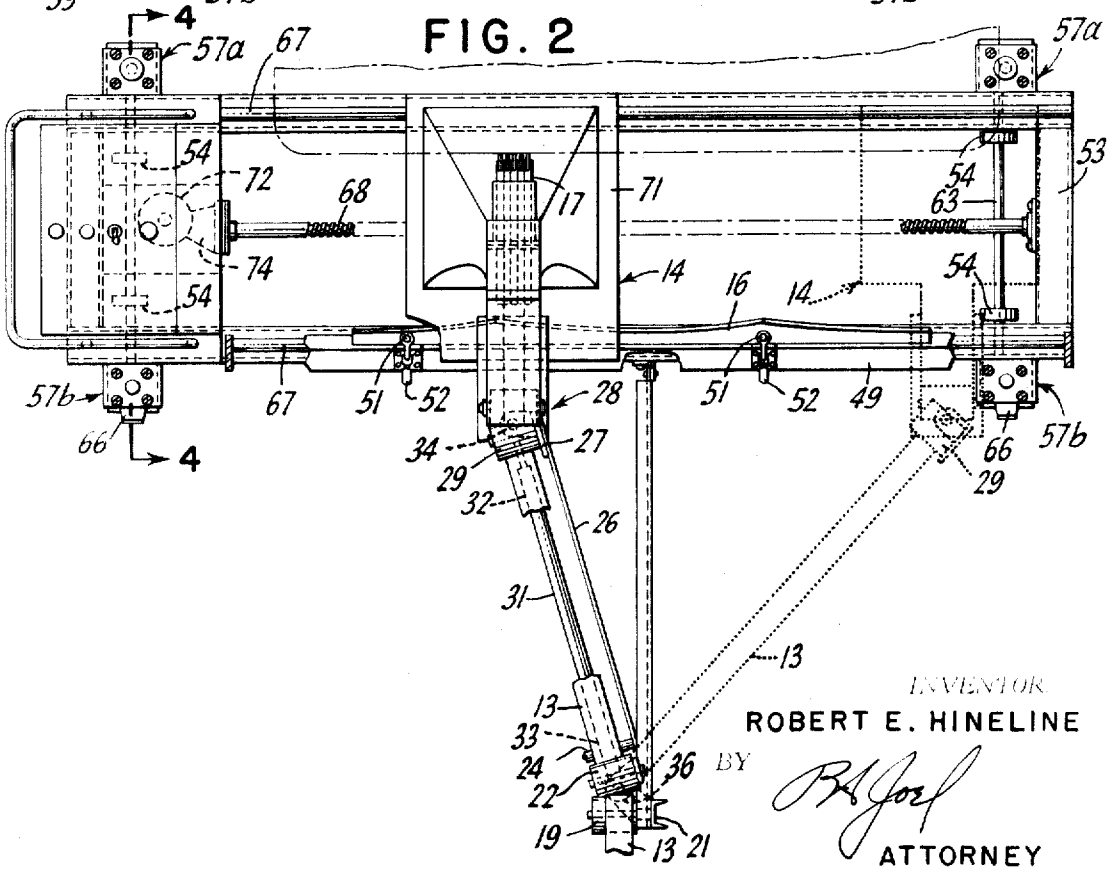


FIG. 2



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Original Filed July 26, 1967 4 Sheets-Sheet 2

FIG. 4

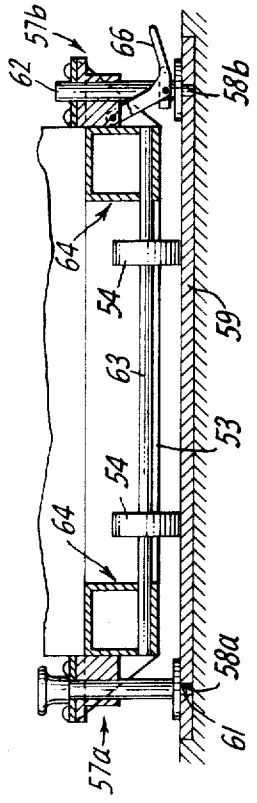
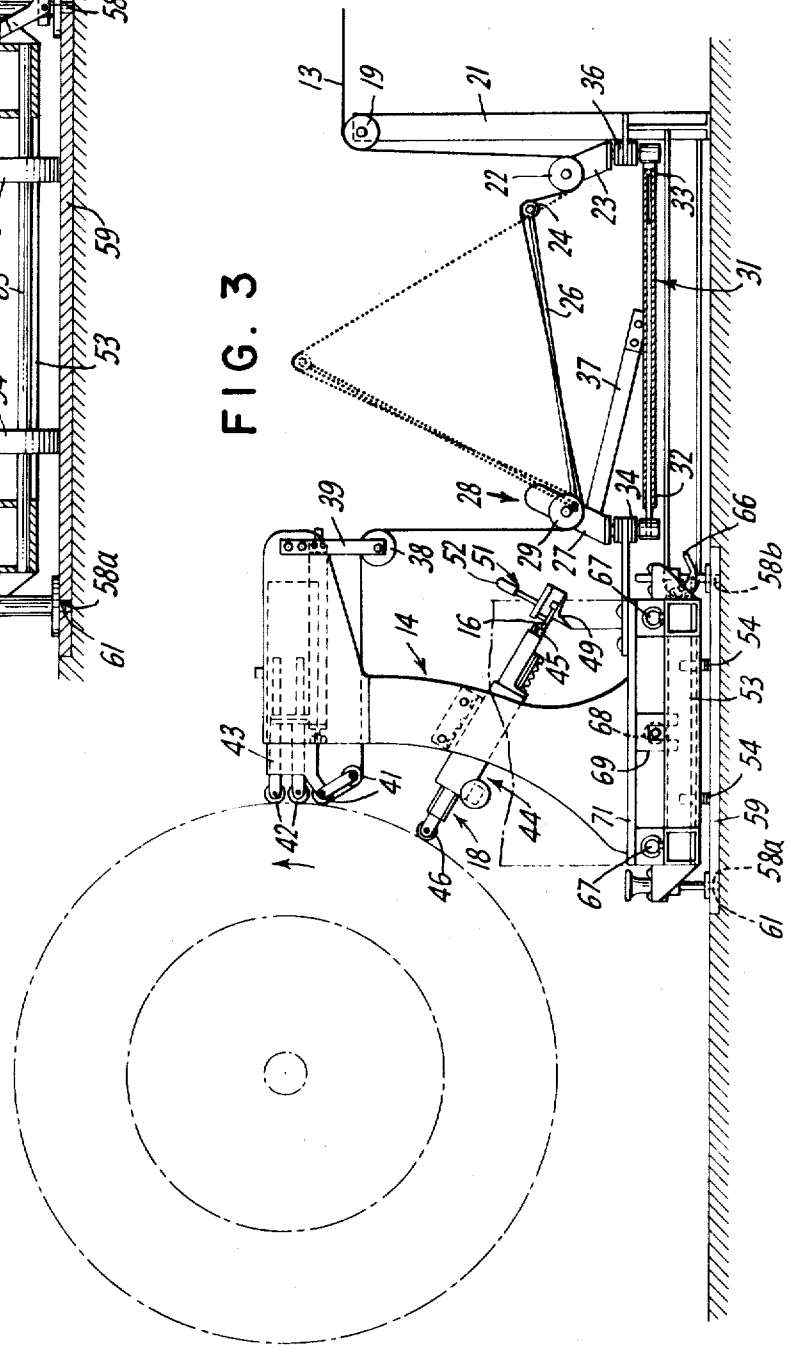


FIG. 3



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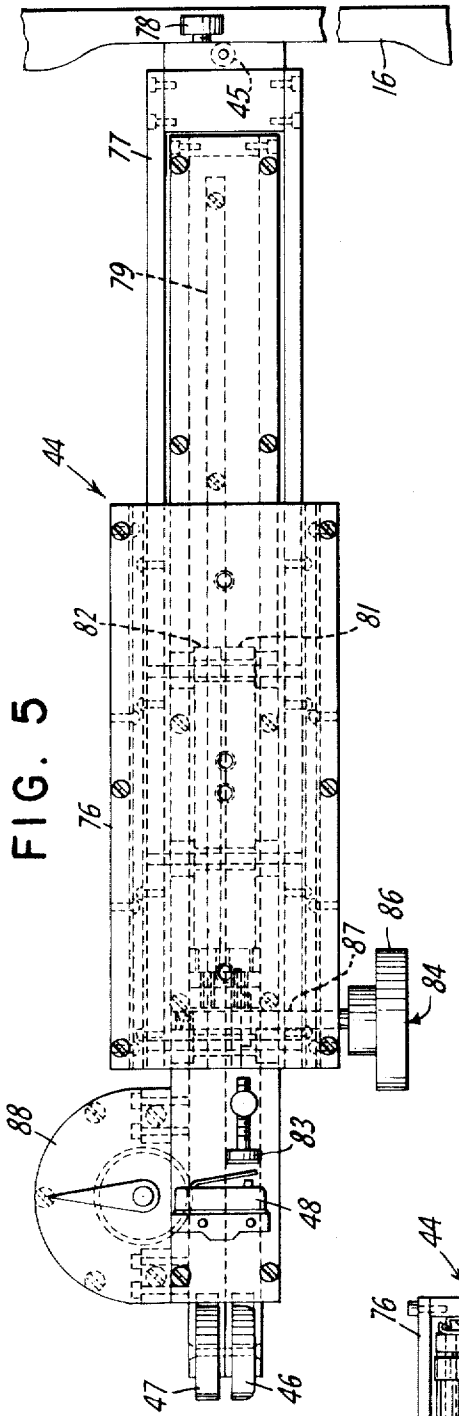


FIG. 5

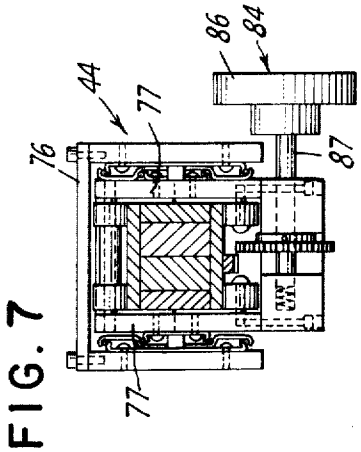


FIG. 7

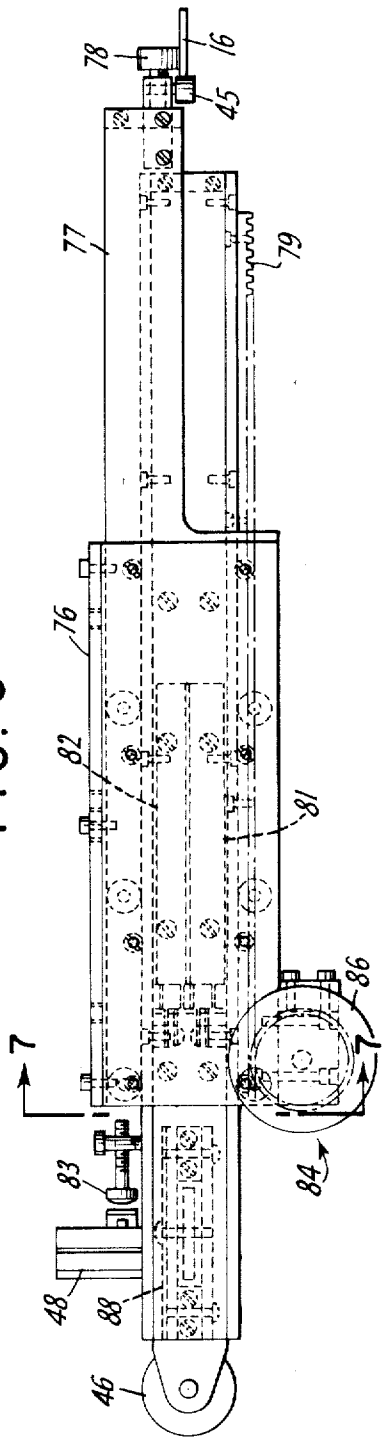


FIG. 6

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FIG. 8

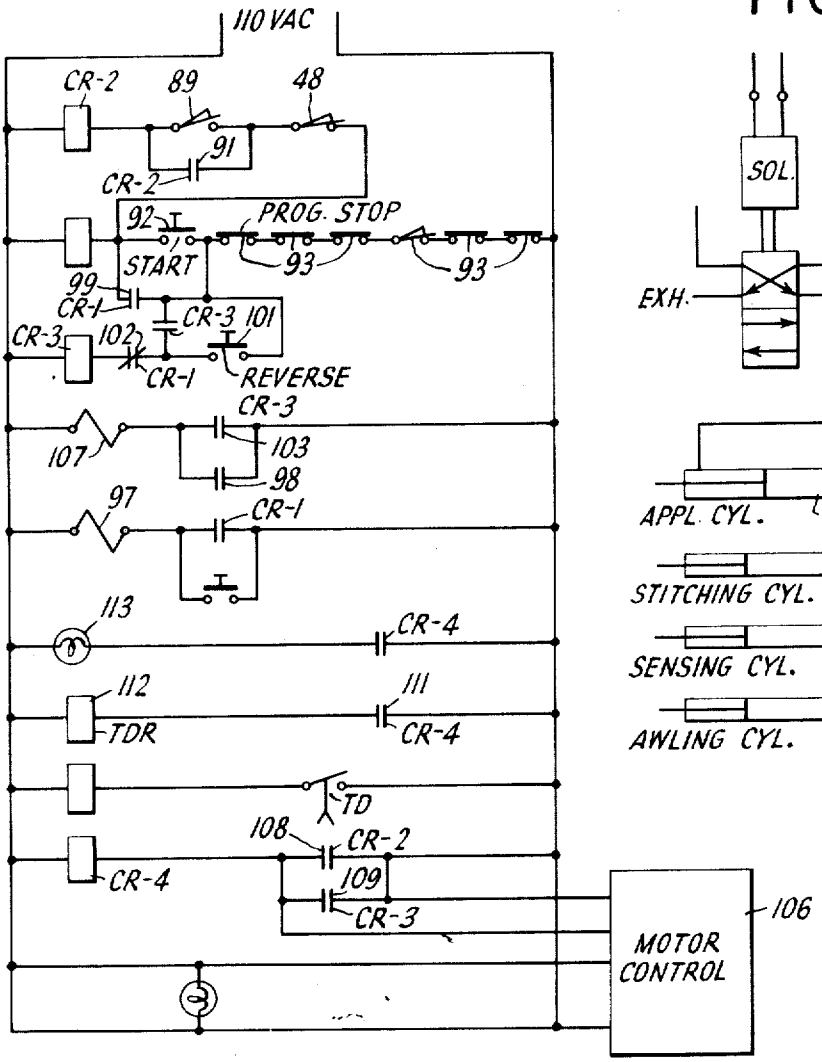


FIG. 10

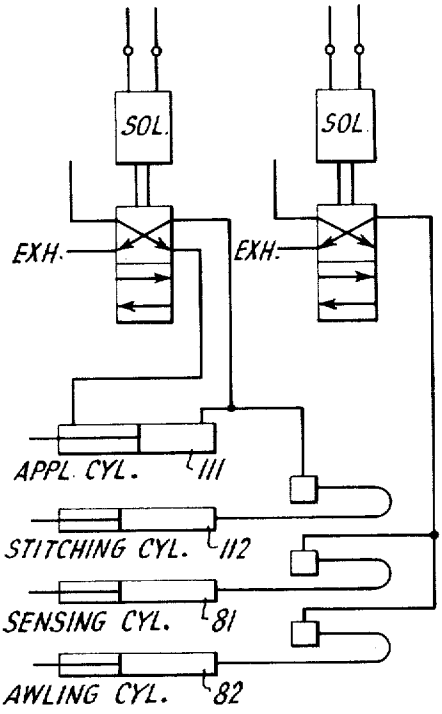
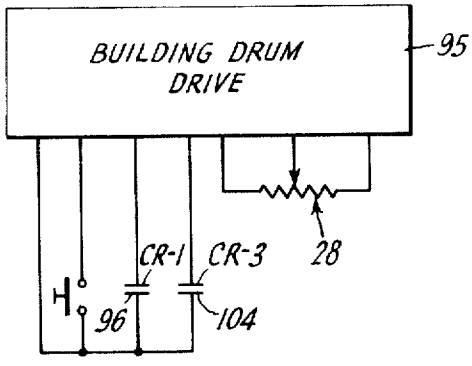


FIG. 9



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28,043

METHOD OF BUILDING A TIRE CASING FROM A STRIP OF RUBBER

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Original No. 3,549,442, dated Dec. 22, 1970, Ser. No. 656,283, July 26, 1967. Application for reissue Oct. 27, 1972, Ser. No. 301,470

Int. Cl. B29h *17/20*

U.S. Cl. 156—117 10 Claims

Matter enclosed in heavy brackets [ ] appears in the original patent but forms no part of this reissue specification; matter printed in italics indicates the additions made by reissue.

ABSTRACT OF THE DISCLOSURE

A method of building tires, such as new off-the-road tires, on a drum arrangement whereby a strip of rubber is placed thereon as the drum continually rotates. The apparatus includes an application and sensing arm which guides the material onto the drum in a predetermined pattern in accordance with a straight line template. The application and sensing arm moves in a straight line across the surface of the building drum to build a tire contour in accordance with the template configuration. The apparatus is portable and may be removed from a building station when not required and thus used to serve a number of building stations.

BACKGROUND OF THE INVENTION

This invention relates to tire manufacture and particularly to an apparatus for applying a predetermined tread thickness to a green tire casing. The present invention is particularly suited to the manufacture of new off-the-road tires and while portions of a similar machine and process are broadly disclosed in my prior filed co-pending application S.N. 576,888, filed Sept. 14, 1965, the present invention discloses in detail a new and improved method and apparatus to produce new off-the-road tires. This requires a distinctly different machine from the retread tire machine since new tires are produced on a rotating stationary drum rather than a movable hub.

Other apparatus for building a tire tread by applying a ribbon to a base structure are disclosed in Pats. 3,268,-380 to L. J. Guichon et al., 3,223,572 to R. L. Holloway et al., and 3,177,918 to R. G. Holman. The present invention, however, is custom designed to produce a particular product such as new off-the-road tires and is readily distinguishable over the aforementioned patents. There is no machine which currently produces off-the-road tires in the unique and economical manner which applicant proposes herein. Furthermore, the apparatus of the present invention is a portable, self-contained unit which can be moved to any drum station in a manufacturing facility.

SUMMARY OF THE INVENTION

Accordingly, the object of this invention is to provide a new and improved method and apparatus for producing new off-the-road tires.

With the above and other objects and advantages in view, the present invention pertains to a unique method and apparatus for producing tires such as large size off-the-road tires. The apparatus comprises a drum arrangement whereby a strip of rubber is positioned thereon as the drum continually rotates. The apparatus includes an application and sensing arm which guides the extruded material onto the rotating drum in accordance with a predetermined straight line template. During the tire building operation the application and sensing arm moves in a straight line across the surface of the building drum to build a tire contour in accordance with the template configuration.

BRIEF DESCRIPTION OF THE DRAWINGS

The features of the present invention will be more clearly understood when viewed in conjunction with the accompanying drawings, wherein:

FIG. 1 is a front view of the new and improved apparatus of the present invention for producing off-the-road tires;

FIG. 2 is a top view of the subject apparatus with portions omitted in order to more clearly illustrate the operation thereof and with the movement of the application and sensing arm shown in phantom;

FIG. 3 is a side view of the present invention;

FIG. 4 is a broken-away view of the base portion of the apparatus taken along the lines **4**—**4** of FIG. 2;

FIG. 5 is a top view of the sensing head arrangement;

FIG. 6 is a side view of said sensing arm arrangement;

FIG. 7 is an end view of the sensing arm arrangement;

FIG. 8 is a schematic representation of the electrical circuit employed in the present invention;

FIG. 9 illustrates the electrical circuit for the drum control arrangement; and

FIG. 10 illustrates the pneumatic control circuit for the present invention.

DESCRIPTION OF THE PREFERRED EMBODIMENTS

Referring now to the drawings, the invention comprises an apparatus for building new off-the-road tires **10** on a base structure such as a green tire casing **11** which is mounted on a drum arrangement **12**. A strip of rubber **13** which is locally extruded from a cold feed extruder, not shown, is placed upon the drum **12** in a predetermined manner in order to form the finished tire contour which is shown in phantom in FIG. 1. The apparatus includes an application and sensing arm **14** which guides the strip **13** onto the drum **12** in accordance with a straight line template **16**. The application and sensing arm **14** moves in a straight line across the surface of the rotating building drum **12** to build a tire contour conforming to the template configuration. As the strip **13** is applied to the casing **11** by an application head **17** mounted on the arm **14**, it is continuously monitored by a sensing head **18** which is also mounted on the arm **14** in a fixed relation to the application head **17**.

As shown in FIGS. 2 and 3 the extruded strip **13** is fed to the tire building machine by means of an overhead conveyor not shown which includes a gate or other means for feeding the strip to the building apparatus. Since the present apparatus is self-contained and portable in nature it may be used to feed several machines from a single cold feed extruder. In the illustrated embodiment, the strip **13** passes over roller **19** which is mounted on bracket **21** and then onto roller **22** which is mounted on the pivotal bracket arrangement **23**. The strip **13** passes over the pivotal dancer roller **24** mounted on dancer arm **26** at one end and affixed to the swivel bracket **27** which in turn is coupled to a potentiometer arm arrangement **28** for regulating the speed of the drum **12** to prevent excess slack from accumulating in the strip feed.

Roller **22** is coupled to roller **29** on the potentiometer arrangement **28** by means of the telescoping arm **31** which is coupled at its ends **32** and **33** to the respective rollers **29** and **22** through the bearing arrangements **34** and **36** respectively. Thus, the rollers **22** and **29** are maintained in a parallel relationship while the application and sensing arm **14** traverses the drum **12**. A counter weight arm **37** is also provided for the dancer arrangement.

The strip **13** passes over roller **38** which is mounted to the application head **17** by means of bracket **39** and is then fed to the plurality of application rollers **41** which apply the strip to the casing **11**. A plurality of stitching rollers **42** mounted in the retractable stitching head **43** stitch the rubber strip to the casing **11** at approximately the center portion of the drum **12**. A sensing head **44** is mounted to the arm **14** below the application head **17** with the sensing rollers **46** being aligned with the trailing edge of the strip **13**. The sensing head **44** which will be described later in greater detail includes a cam follower **45** which follows the outline of the template **16**. The sensing head **44** continuously contacts both the template and the applied strip **13** and actuates a motor **72** to move the arm **14** when the desired tread contour has been reached at the particular position on the tire. The applied strip **13** makes an approximately 330° wrap before the sensing roll **46** senses the increase in gage. Since the tire building drum **12** is generally concentric, no spin switch such as employed in my co-pending application S.N. 576,888 is required. The traversing movement of the arm **14** is halted when a switch **48** located on the sensing head opens signifying that the finished tread contour has not been reached at that particular point.

The template **16** is mounted on a member **49** and held in position by one or more locking members **51**. The locking members **51** include a handle portion **52** which may be readily gripped to either secure or release the template **16** from the member **49**. In the ordinary instance, the template **16** will be full size and may be dismounted in order to compare the template contour with that of the finished tire. A variety of templates **16** may be stored in a particular plant in order to permit the manufacture of various tire gages with the same equipment. The apparatus as described herein may be used in conjunction with drums **12** which vary from about 32 inches in diameter to about 62 inches in diameter.

The invention as thus described may comprise a portable unit which includes a frame portion **53** which is supported by a plurality of rollers **54**. The apparatus may be readily located in a building position by rolling said apparatus into position using the transporting handle arrangement **56**. When the unit is properly positioned the four floor jacks **57a** and **57b** engage predetermined apertures **58a** and **58b** in the floor plate **59**. The two forward floor jacks **57a** include threaded shafts **61** which engage threaded apertures **58a** in the floor plate **59**. The rear floor jacks **57b** include pins **62** which engage the apertures **58b** in the floor plate **59**. This arrangement is more clearly shown in FIG. 4 which also illustrates rollers **54** mounted on shaft **63** and journaled at its ends in bearing arrangements **64**. The floor jack portions **57a** and **57b** extend outwardly from the frame portions **53** and the rear floor jacks include a position lock **66**.

The application and sensing arm is slidably mounted on a pair of guide rails **67** and is driven back and forth therealong by a drive screw **68** which engages a downwardly extending portion **69** on the base **71** of the arm **14**. The drive means for the arm **14** comprise a motor **72** which may be mounted within the control panel **73** at one end of the apparatus and coupled to the screw **68** through a gear reduction means **74**. In a typical embodiment the motor may comprise a ¼ horsepower D.C. motor and the gear reduction arrangement may be on a 10:1 ratio. A typical drive screw may comprise a 1" ball screw having a ¼" pitch. Since a 10:1 gear reduction does not provide self-locking, an A.C. brake may be provided in the subject embodiment. Furthermore, since an A.C. brake is not rated for the number of stops that will normally occur during operation, a dynamic braking resistor may be used for stopping in cooperation with a time delay relay which activates the A.C. brake for static holding, see FIG. 8.

The sensing head **44** as shown in FIGS. 5, 6 and 7 comprises a frame portion **76** which is mounted to the application and sensing arm **14**. A cam follower **45** is mounted to the slide **77** at one end thereof and is maintained in continuous contact with the template **16**. In fact, a second roller **78** also rides on the template **16**. The slide **77** is connected to a rack **79** which moves back and forth in accordance with the template configuration.

A sensing roller **46** and a stitching roller **47** are mounted to the air cylinders **81** and **82** respectively at the other end of the sensing head **44**. A switch **48** is mounted to be engaged by an adjustable stop **83**. When the sensing switch **48** is closed the drive motor **72** is activated to cause the application and sensing arm to move along the guide rails **67** until the switch **48** is opened. The arm **14** remains in place as layers of ribbon **13** are applied to the drum casing **11** until the sensing roller **46** closes the sensing switch **48**. This sequence is continuously repeated in order to build the desired tire contour. In operation, the sensing roller **46** is positioned in line with the trailing edge of the applied rubber ribbon **13** and the sensing switch is provided with a differential travel of approximately $\frac{1}{32}$ of an inch. A stop limit switch may be provided on the sensing arm to ride on the template **16** in order to stop the program.

The sensing head is also provided with a hand adjustment **84** which includes a handle **86** coupled to a spring-loaded shaft **87** to initially position the sensing roller **46** according to an indication which appears on the scale **87**.

Referring to the electrical drawings of FIGS. 8 and 9 the spin switch **89**, if provided, is closed once during each revolution and if at that time the sensing switch **48** is open, control relay CR–2 will not be operated. Relay CR–2 controls the drive motor **72** which moves the application arm **14** in a straight line opposite the drum surface. Consequently, the motor **72** will not be operated if the sensing switch **48** is open and the application arm **14** will continue to apply the rubber strip **13** to the same portion of the tire casing **11**. On the other hand, the sensing switch **48** will close if the sensing roller detects adequate gage on the casing surface corresponding to the template configuration. The drive motor **72** will be operated by the closing of the spin switch **89** which locks across contacts **91** of relay CR–2 causing the roller **46** to move across the strip surface until a point where the next strip **13** is required to fulfill the contour requirements. The switch **48** will then open, stopping the traversing movement of the application arm **14**.

As shown in FIGS. 8 and 9 of the drawings, program control relay CR–1 is operated when the start switch **92** is closed. The circuit is completed through a plurality of switches **93** which are used for various control purposes. Relay CR–1 controls the drum driving means **95** which drives shaft **94** through contacts **96** and also the air solenoid **97** for the sensing cylinders through contacts **98**. Contacts **99** of relay CR–1 provide a locking arrangement after the start switch **92** is released.

Control relay CR–3 is operated by the reverse switch **101** through normally closed contacts **102** of relay CR–1. The relay CR–3 also operates the solenoid **97** through contacts **103** and the drum driving arrangement through contacts **104**. In the circuit drawing, the conventional connections with the driving motor **72** are not shown in detail since such arrangements are well-known and conventional in the prior art. The motor control is merely indicated at **106** and may, for example, include a Boston Gear Ratiotrol with provision for an A.C. brake.

The application and stitching solenoid **107** is also controlled through contacts **108** of relay CR–1 and control relay CR–4 is operated through contacts **108** of CR–2 and **109** of CR–3. Contacts **111** of control relay CR–4 operate the time delay relay **112** and the light **113**.

The fluid drive control arrangement is shown schematically in FIG. 10. Solenoid **107** controls the application

cylinders **111** and the stitching cylinders **112** while solenoid **97** controls the sensing cylinders **81** and awling cylinders **82**. The latter cylinders **81** and **82** are connected in parallel while the application and stitching cylinders **111** and **112** are connected in series.

The invention, as described above, comprises a new and improved apparatus for producing primarily off-the-road tires although the concepts embodied herein may be employed to produce other tires as well. The ribbon size customarily employed is 3 inches x .180 inch; however, variations in width up to ⅜ inch and thickness up to .05 inch may be readily handled. It is to be noted that the present invention is also adaptable for programming with other arrangements than a straight line template and numerous other programming means may be employed to produce the desired tire contour. The self-contained portable nature of the subject apparatus is a distinct advantage over present commercially available equipment and permits greater flexibility in the use of plant equipment.

What has been described above are merely illustrative examples of the application of the principles of the invention. Numerous other arrangements may be readily devised by those skilled in the art which will embody the principles of the invention and fall within the spirit and scope thereof.

What is claimed is:

1. A method of making a tire casing, comprising the steps of:

feeding a continuous strip of tread material to a rotating tire casing,

winding the strip on said casing in a series of overlapping turns,

sensing the strip position after it has been applied to the casing,

developing an electrical signal in response to the sensing of a predetermined tread contour at the sensed position, and

coupling said electrical signal to a drive motor to move the tread feeding and winding to a new portion of the rotating tire casing.

2. A method of applying rubber to a cylindrical casing, comprising the steps of:

feeding a strip of rubber to a casing,

applying the strip of rubber to the casing by rotating the casing,

providing a template representative of a desired contour of rubber to be placed on the casing,

sensing the rubber being wound on the casing,

sensing the template at the position thereon corresponding to the position on the casing whereat the rubber strip is being applied, and

moving the application of rubber strip along the casing upon the sensing of a rubber buildup at the location where it is being applied corresponding to that set by the template configuration.

3. A method according to claim 2, wherein the step of feeding the strip of rubber includes:

extruding a strip of rubber, and

passing the extruded strip of rubber over a series of rollers toward the cylindrical casing.

4. A method according to claim 3, wherein the step of applying the strip of rubber to the casing includes:

passing the extruded strip of rubber to an application roller adjacent the rotating casing, and

stitching the strip to the casing as it rotates.

5. A method according to claim 2, wherein the rubber strip application means is moved along the casing in a path spaced from and parallel to the axis of the casing.

6. A method according to claim 5, wherein the rubber strip application means is moved parallel to the axis of the casing in one direction only.

7. A method according to claim 2, wherein the sensing of the rubber being wound on the casing includes:

mounting a roller for movement with respect to the casing adjacent the situs whereat the rubber strip is applied,

biasing said roller into engagement with the casing, and

mounting a switch in the path of movement of the roller whereby a rubber buildup of predetermined thickness will actuate the switch.

8. A method according to claim 7, wherein the sensing of the template configuration at the position thereon corresponding to the position on the casing whereat rubber is being applied includes:

mounting a roller for movement with respect to the template,

biasing the roller into engagement with the template, and

coupling the template roller to the casing sensing roller so that the travel of the latter roller needed to actuate the switch is determined by the template.

9. A method of applying rubber to a cylindrical casing, comprising the steps of:

feeding a strip of rubber to a casing,

applying the strip of rubber to a situs on the casing by rotating the casing,

sensing the rubber being wound on the casing,

developing an electrical signal in response to the sensing of a predetermined amount of rubber applied at that situs, and

moving the feeding and applying of rubber strip in one direction along the casing to a new situs in response to said electrical signal.

10. A method according to claim 9, wherein the step of developing an electrical signal in response to the sensing of a predetermined amount of rubber includes:

mounting a roller for movement with respect to the casing adjacent the situs whereat the rubber strip is applied,

biasing said roller into engagement with the casing,

mounting a switch in the path of movement of the roller whereby a rubber buildup of predetermined thickness will actuate the switch,

providing a template representative of a desired contour of rubber to be applied to the casing,

mounting a roller for movement with respect to the template,

biasing the roller into engagement with the template, and

coupling the template roller to the casing sensing roller so that the travel of the latter roller needed to actuate the switch is determined by the template.

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CLIFTON B. COSBY, Primary Examiner

U.S. Cl. X.R.

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