



(51) International Patent Classification:
B02C 18/16 (2006.01) *B02C 18/14* (2006.01)

(21) International Application Number:
PCT/SE2018/050322

(22) International Filing Date:
26 March 2018 (26.03.2018)

(25) Filing Language: English

(26) Publication Language: English

(30) Priority Data:
1750543-9 04 May 2017 (04.05.2017) SE

(71) Applicant: **RAPID GRANULATOR AB** [SE/SE]; Box 9,
333 02 Bredaryd (SE).

(72) Inventors: **JUGO, Ernad**; Mogatan 7, 335 73 Hiller-
storp (SE). **SJÖBERG, Kurt**; Hamra Knutsgård 2, 333 74
Bredaryd (SE). **BUKARIC, Jasmin**; Vasagatan 57, 331 41
Värnamo (SE). **KARLSSON, Henrik**; Jönköpingsvägen 9,
331 34 Värnamo (SE).

(74) Agent: **BERGENSTRÄHLE & PARTNERS SMÅ-
LAND AB**; Box 116, 331 21 Värnamo (SE).

(81) Designated States (unless otherwise indicated, for every
kind of national protection available): AE, AG, AL, AM,
AO, AT, AU, AZ, BA, BB, BG, BH, BN, BR, BW, BY, BZ,
CA, CH, CL, CN, CO, CR, CU, CZ, DE, DJ, DK, DM, DO,
DZ, EC, EE, EG, ES, FI, GB, GD, GE, GH, GM, GT, HN,
HR, HU, ID, IL, IN, IR, IS, JO, JP, KE, KG, KH, KN, KP,
KR, KW, KZ, LA, LC, LK, LR, LS, LU, LY, MA, MD, ME,
MG, MK, MN, MW, MX, MY, MZ, NA, NG, NI, NO, NZ,
OM, PA, PE, PG, PH, PL, PT, QA, RO, RS, RU, RW, SA,
SC, SD, SE, SG, SK, SL, SM, ST, SV, SY, TH, TJ, TM, TN,
TR, TT, TZ, UA, UG, US, UZ, VC, VN, ZA, ZM, ZW.

(84) Designated States (unless otherwise indicated, for every
kind of regional protection available): ARIPO (BW, GH,

GM, KE, LR, LS, MW, MZ, NA, RW, SD, SL, ST, SZ, TZ,
UG, ZM, ZW), Eurasian (AM, AZ, BY, KG, KZ, RU, TJ,
TM), European (AL, AT, BE, BG, CH, CY, CZ, DE, DK,
EE, ES, FI, FR, GB, GR, HR, HU, IE, IS, IT, LT, LU, LV,
MC, MK, MT, NL, NO, PL, PT, RO, RS, SE, SI, SK, SM,
TR), OAPI (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW,
KM, ML, MR, NE, SN, TD, TG).

Published:
— with international search report (Art. 21(3))

(54) Title: GRANULATOR MILL

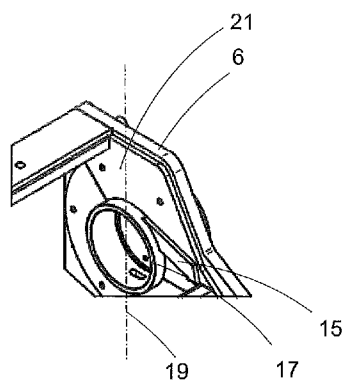


Fig. 4

(57) Abstract: Granulator mill (1) comprising granule chamber (3) comprising at least one non-rotatable blade (4), rotatable rotor (8) arranged inside the granule chamber (3), the rotor (8) comprising a number of blades (10) which are arranged for cooperation with the non-rotatable blade (4), a infeed hopper (5) for feeding waste into the granule chamber, a grid arranged in the granule chamber, where through granulated waste is allowed to pass to an outfeed hopper (30). A scraping device (15) is provided in a space (14) located axially in between a housing (2) and the rotatable rotor (8) and the scraping device (15) is attached to the housing (2).

GRANULATOR MILL

Technical field

[0001] The present invention relates generally to a granulator mill according to claim 1.

Background art

[0002] In prior art it is known granulator mills used within the plastics industry for recycling or reuse of plastic waste. During the granulation of the plastic waste, the granulator mill granulate the plastic waste into plastic chips. The smaller chips, the greater probability that the chips wedge into narrow spaces within the granulator mill.

[0003] One area, within which granulated plastic chips tend to wedge is in a space extending in an axial direction between a rotatable rotor and the static housing of the granulator mill. In the beginning of the granulator process the plastic waste is too large to get stuck in the axial space when tumbled around inside the granule chamber by means of the rotor. When the granulated waste has been granulated for a while and starts to take the size of the mesh within the grid then there is an increased risk that the chips get stuck in between the static housing and the rotatable rotor. When one or more of chips has got stuck, the harder for the rotor to rotate and the larger friction force is exerted between the rotor and the static housing and this leads to heated plastic chips which may get sticky and thus get stuck between the rotatable rotor and the static housing and deteriorate the function of the granulator mill. Thus, the wedged plastic chips may also restrain the rotary speed of the rotor. Further, the friction force may result in overheating of the granulator mill.

[0004] Another drawback when one or more plastic chips wedge between the rotatable rotor and the static housing, is that when the wedged plastic chip is heated, the solid plastic of the chip may melt and transform into disintegrated plastic threads during the rotation of the rotor. These disintegrated plastic threads

are equipped with other material properties than the correct granulated chips, and are of this reason not wanted in the final plastic granulate.

Summary of invention

[0005] An object of the present invention is to create a granulator mill which eliminate that granulated plastic chips get stuck and restrain the rotary speed of the rotor. Another object of the present invention is to prevent the plastic chips to transform into disintegrated plastic threads during the granulation process.

[0006] The object is met by the granulator mill according to claim 1. The granulator mill comprises a granule chamber comprising at least one non-rotatable blade and a rotatable rotor arranged inside the granule chamber. Further the rotor of the granulator mill comprises a number of blades which are arranged for cooperation with the at least one non-rotatable blade, and an infeed hopper for feeding waste into the granule chamber. A grid is arranged in the granule chamber, where through granulated waste is allowed to pass to an outfeed hopper. A scraping device is provided in a space located axially in between the housing and the rotatable rotor and the scraping device is attached to the housing.

[0007] The scraping device is provided to extend radially towards an outer circumference periphery of the granule chamber, this to guide the granulated waste away from the axial space between the housing and the rotatable rotor. The scraping device is provided on the housing, facing the side of the rotor which is subjected to downward rotation and/or upward rotation. Preferably, the rotor is arranged to rotate clockwise and the scraper is provided on the side of the rotor which is subjected to downward rotation of the rotor.

[0008] The scraping device extends radially towards the outer circumference periphery in a tangential direction with starting point in an imaginary vertical center line of the rotatable rotor in the granule chamber. The scraping device has an axial extension which is equal to or less than the axial space between the housing and the rotatable rotor, this to allow the rotor to rotate without restricting the rotation of the rotor. During the granulation process the rotatable rotor makes the plastic

granulate to circulate within the granule chamber. In the point where the imaginary vertical centerline meets the outer periphery of the rotor, the circulated plastic granules change their direction of motion, from upwards to downwards due to the force of gravity and the risk that the plastic chips tend to fasten in the axial space is greater. Thus, the scraping device prevents the plastic chips from entering the axial space between the housing and the rotatable rotor.

[0009] The scraping device is provided on a wall of the granule chamber in such a way that that the scraping device extend at least to the periphery of the rotating rotor, this to guide the granulated plastic chips to a region of the granulation chamber where wedging of the plastic chips are of less importance. The scraping device is an elongated metal plate.

[0010] The scraping device can be provided on a wear plate which is attached to the walls of the granule chamber. The walls of the granule chamber can be provided with projecting flanges, which project from the walls and encircle the rotating rotor. The projecting flanges are arranged to extend into a corresponding groove arranged on the rotating rotor, this to establish an enclosure around the rotating rotor.

Brief description of drawings

[0011] The invention is now described, by way of example, with reference to the accompanying drawings, in which:

[0012] Fig. 1 is a perspective view of a granulator mill seen from above,

[0013] Fig. 2A is a detailed view of a rotor of the granulator mill,

[0014] Fig. 2B is an enlarged detailed view according to Fig. 2A,

[0015] Fig. 3 is a vertical cross section through the rotor perpendicular to the rotational axis,

[0016] Fig 4 is a detailed view of the granulator mill with a rotor excluded,

[0017] Fig. 5A is a substantially vertical cross-section through the rotor and a scraping device along the rotational axis, and

[0018] Fig. 5B is an enlarged detailed view according to Fig. 5A.

Description of embodiments

[0019] In the description below, various directions will be given with reference to a granulator mill arranged in a position ready for use. In the description below, terms as axial and radial are used and these are seen in view of the orientation of an axle of a rotor. The axial direction is to be interpreted as the direction along the extension of the axis of rotation of the rotor, and radial direction is to be interpreted as the direction across the rotor axle. Further, in the description directions such as up and down are also used and these relate to when the granulator mill is in a state ready for use.

[0020] In the following, a detailed description of a granulator mill according to the invention is disclosed in detail. In Fig. 1-5B a granulator mill 1 is disclosed. The granulator mill 1 comprises a granulator mill housing 2 which accommodates a granule chamber 3. The granulator mill housing 2 is provided with at least one blade 4 which is fixedly arranged on the housing 2.

[0021] On an upper side of the granulator mill housing 2, an infeed hopper or hopper section 5 is provided. By means of the infeed hopper or hopper section 5, plastics that are to be recycled or reused are fed into the granule chamber 3.

[0022] The granule chamber 3 is provided with two internal walls 6, 7 which are parallel to each other, between which a rotor 8 is rotatably journaled. Driving of the rotor 8 is put into effect by means of a motor 9.

[0023] The rotatable rotor 8 is provided with at least one or preferably a number of blades 10 at its periphery which are provided to cooperate with the fixed blade 4 provided on the housing 2 during a granulation process. The fixed blade 4 may be one or more. In the example of fig. 3 there are three fixed blades 4 spaced apart around the circumference of the rotatable rotor 8. The fixed blades 4 are disposed

closely adjacent to and co-operate with the rotatable blades 10 around the peripheral surface of the rotor 8.

[0024] The blades 4, 10 on either or both of the rotor 8 and the housing 2 are preferably detachable so that the blades 4, 10 may be exchanged when necessary.

[0025] Within the interior granule chamber 3 a grid (not shown) is provided. Preferably, the grid is provided within the lower part of the granulation chamber 3 which communicate with an outfeed hopper 30. Further, the grid is provided with a mesh, which determine the size of the plastic chips that is allowed to pass the grid and further into the outfeed hopper 30. The waste plastics is granulated by means of the blades 4, 10 of the rotor 8 and the housing 2 when they are ground towards each other.

[0026] Internally in granulate chamber 3, the granulation of the plastic material takes place. When the granulation process has proceeded sufficiently, the finely-divided particles or granulate pass through the grid, which may have varying mesh size. This grid surrounds the rotor 8 along a part of its periphery. On the underside or outside of the grid, the outfeed hopper 30 is situated, in which the granulated material is collected and from which the granulate material is conveyed off via an outlet.

[0027] Within the granulate chamber there are numeral regions where plastic chips may get jammed. One region which is especially subjected to jamming is a space 14 situated in between the rotatable rotor 8 and the static housing 2 within the granule chamber 3. Each end of the rotor 8, is provided with a projecting shaft 11, 12 which is provided in the internal walls 6, 7 of the granulate chamber 3. The projecting shafts 11, 12 are journaled in a bearing 24 arranged in the internal walls 6, 7. The bearing 24 can for example be ball bearings. Further, the projecting shafts 11, 12 of the rotor 8 are arranged in the prolongation of the axis of rotation 13. The projecting shafts constitute a rotational axle that is driven to rotate by the motor 9 in order to rotate the rotor 8.

[0028] To minimize and prevent plastic chips from entering this space 14 between the rotatable rotor 8 and the static housing 2, a projecting part 15 is provided within the space 14 extending in the axial direction between the rotor 8 and the internal walls 6, 7 of the granule chamber 3. The projecting part 15 is attached to a wear plate 21 which is attached to each of the walls 6, 7 of the granule chamber 3. The projecting part 15 extend radially toward an outer circumference periphery of the granule chamber 3, as shown in Fig. 4. The wear plate 21, which is optional, has the purpose to increase the wear resistance of the walls 6, 7 in the area where the scraping device 15 is provided. In another embodiment, the projecting part may be attached directly to one or more of the internal walls 6, 7. The projecting part 15 is a scraping device which has as purpose to guide away the plastic chips which end up in a space 14 between the rotor 8 and the walls 6, 7 of the granule chamber 3, and preventing them from entering this area and getting stuck. The chips that are guided away during the granulating process are guided from this area, and back to the granulate chamber to get granulated again.

[0029] The scraping device 15 is preferably elongated and provided to extend radially towards an outer circumference periphery of the granule chamber 3. Thus the scraping device 15 has the function of a guide which direct the plastic chips from this area. The scraping device 15 extend from a radially inner part of the internal walls 6, 7 of the granule chamber 3 to a radially outside part corresponding to outside the circumference of the cross section of the rotor 8, this to be able to lead off chips from staying in the space 14. Irrespective of the rotor 8 is arranged to rotate clockwise or counterclockwise, the scraping device 15 can be provided on the side of the rotor 8 which is subjected to downward rotation of the rotor 8 and/or provided on the side of the rotor 8 which is subjected to upward rotation.

[0030] The scraping device 15 is mounted on the internal wall 6, 7 of the granule chamber 3 in such a way that that the scraping device 15 extend at least to the periphery of the rotating rotor 8 and preferably extend past the periphery of the rotating rotor 8.

[0031] The scraping device 15 is provided on the internal walls 6, 7 of the granule chamber 3, facing the side of the rotor 8, and extend in a tangential direction from the periphery of the rotating rotor 8 towards the fixed blade 4 on the granulator mill housing 2. The shaft of the rotor 8 comprises an axis of rotation 13 and from this axis of rotation 13 an imaginary vertical center line 19 and an imaginary horizontal center line 20 have their origin. In one embodiment the scraping device 15 is provided on the wear plate 21 which is attached to the walls 6, 7 of the granule chamber 3. The scraping device 15 is arranged to extend from a starting point on or in the vicinity of the imaginary vertical center line 19 towards an end point at or beyond the periphery of the rotating rotor 8. Around the part of the circumference where the rotor 8 is subjected to downward rotation the scraping device 15 may have the starting point on or in the vicinity of the rotor 8 and the imaginary vertical center line 19 which is provided in an upper section of the circumference of the rotor 8. The upper section is preferably above the imaginary horizontal center line 20. Thus, if the rotor rotates clockwise the scraping device 15 is provided in an upper right quadrant of the circumference of the rotor.

[0032] Around the part of the circumference where the rotor 8 is subjected to upward rotation, the scraping device 15 has a starting point on or in the vicinity of the rotor 8 and the imaginary vertical center line 19 which is provided in a lower section of the circumference of the rotor. The lower section is preferably below the imaginary horizontal center line 20. Thus, if the rotor rotates clockwise the scraping device 15 is provided in a lower left quadrant of the circumference of the rotor.

[0033] The scraping device 15 has an axial extension which is equal to or less than the axial space 14 between the housing 2 and the rotatable rotor 8. The scraping device 15 can be a part integrated into the internal walls 6, 7 of the granule chamber 3 or be a plate which is retrofitted. The scraping device 15 is preferably a plate which is an elongated metal plate.

[0034] In Fig. 4 and Fig. 5A-5B a part of the granule chamber 3 is shown. One of the two internal walls 6, 7 of the granule chamber 3 is shown, which internal walls 6, 7 are parallel to each other. Further, the rotor 8 is rotatably journaled between these parallel walls 6, 7. In an alternative embodiment, the internal walls 6, 7 can be provided with projecting flanges 17 which project from the internal walls 6, 7 towards the granule chamber 3. The projecting flanges 17 are ring shaped and encircle the rotating rotor 8 360 degrees around its circumference.

[0035] Further, the projecting flanges 17 are arranged to extend into a corresponding groove 18 arranged on the rotating rotor 8, this to establish an enclosure around the rotating rotor 8 to obstruct the plastic chips from entering and jamming the rotating shaft of the rotor 8. The projecting flanges 17 are fixedly attached to the housing 2, and each of the projecting flanges 17 are provided to extend into each one of the grooves 18. The grooves 18 are provided on the rotor 8 which is arranged to rotate around its axis of rotation 13. In an assembled state, each of the projecting flanges 17 are provided with a small gap to each of the grooves 18, this to allow the rotor 8 to rotate while the housing is stationary. The projecting flanges 17 and the grooves 18 constitute together a labyrinth solution which obstruct the plastic chips to wedge in between the granulator mill housing 2 and the rotating rotor 8. The labyrinth solution is shown in Fig. 5A and 5B comprises a small gap in between the rotor 8 and the housing 2 and its projecting parts 11, 12. The small gap extend at least in first, second and third radial directions 26, 27, 28 and at least first and second axial directions 22, 23. In the case a plastic chip is about to pass through the labyrinth solution it has to change its direction of motion at least four times. Thus, to be able to pass the labyrinth solution the plastic chip first needs to enter between the scraping device 15 and the rotor 8 in an first radial direction 26, and then turn 90 degrees into the groove 18 of the rotor 8 to an first axial direction 22 of the rotor, then turn 90 degrees to a second radial direction 27 of the rotor 8, then turn 90 degrees to an second axial direction 23 of the rotor 8, then turn 90 degrees to a third radial direction 28 of the rotor 8.

[0036] In the case the projecting flanges 17 are used, the scraping device 15 is arranged to abut against an outer directed surface of the projecting flanges 17, either on the side of the rotor 8 which is subjected to downward rotation and/or the side of the rotor 8 which is subjected to upward rotation.

CLAIMS

1. A granulator mill (1) comprising
a housing (2) with a granule chamber (3), the granule chamber comprises at least one non-rotatable blade (4),
a rotatable rotor (8) arranged inside the granule chamber (3), the rotor (8) comprising a number of blades (10) which are arranged for cooperation with the at least one non-rotatable blade (4),
a infeed hopper (5) for feeding waste into the granule chamber (3),
a grid arranged in the granule chamber (3), where through granulated waste is allowed to pass to an outfeed hopper (30),

characterised in that

a scraping device (15) is provided in a space (14) located axially in between the housing (2) and the rotatable rotor (8) and in that the scraping device (15) is attached to the housing (2).

2. Granulator mill according to claim 1, wherein the scraping device (15) is provided to extend radially towards an outer circumference periphery of the granule chamber (3).

3. Granulator mill according to any of claims 1-2, wherein the scraping device (15) is provided on the housing (2), facing a side of the rotor (8) which is subjected to downward rotation or upward rotation or both downward and upward rotation.

4. Granulator mill according to any of claims 1-2, wherein the rotatable rotor (8) is arranged to rotate clockwise and the scraping device (15) is provided on the housing, facing a side of the rotor (8) which is subjected to downward rotation of the rotor.

5. Granulator mill according to any of claims 1-4, wherein the scraping device (15) extends radially towards an outer circumference periphery in a

tangential direction with starting point in an imaginary vertical center line (19) of the rotatable rotor (8) in the granule chamber (3).

6. Granulator mill according to any of claims 1-5, wherein the scraping device (15) has an axial extension which is equal to or less than the axial space (14) between the housing (2) and the rotatable rotor (8).

7. Granulator mill according to any of claims 1-6, wherein the scraping device (15) is provided on a wall (6, 7) of the granule chamber (3) in such a way that that the scraping device (15) extend at least to the periphery of the rotating rotor (8).

8. Granulator mill according to any of claims 1-7, wherein the scraping device (15) is an elongated metal plate.

9. Granulator mill according to any of claims 1-8, wherein the scraping device (15) is provided on a wear plate (21) which is attached to the walls (6, 7) of the granule chamber (3).

10. Granulator mill according to claim 7, wherein the walls (6, 7) are provided with projecting flanges (17), which flanges project from the walls (6, 7) and encircle the rotating rotor (8).

11. Granulator mill according to claim 10, wherein the projecting flanges (17) are arranged to extend into a corresponding groove (18) arranged on the rotating rotor (8), this to establish an enclosure around the rotating rotor (8).

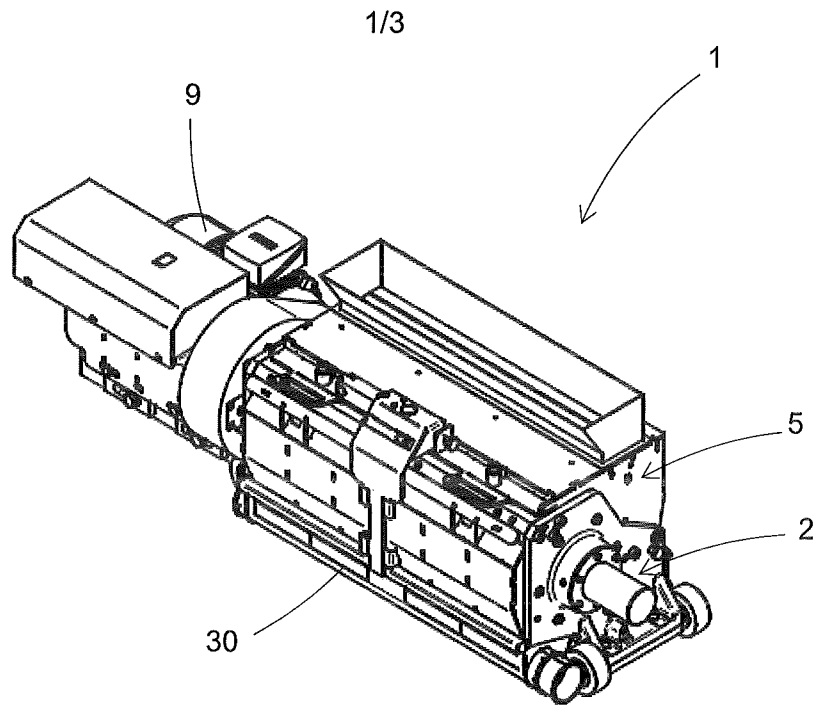


Fig. 1

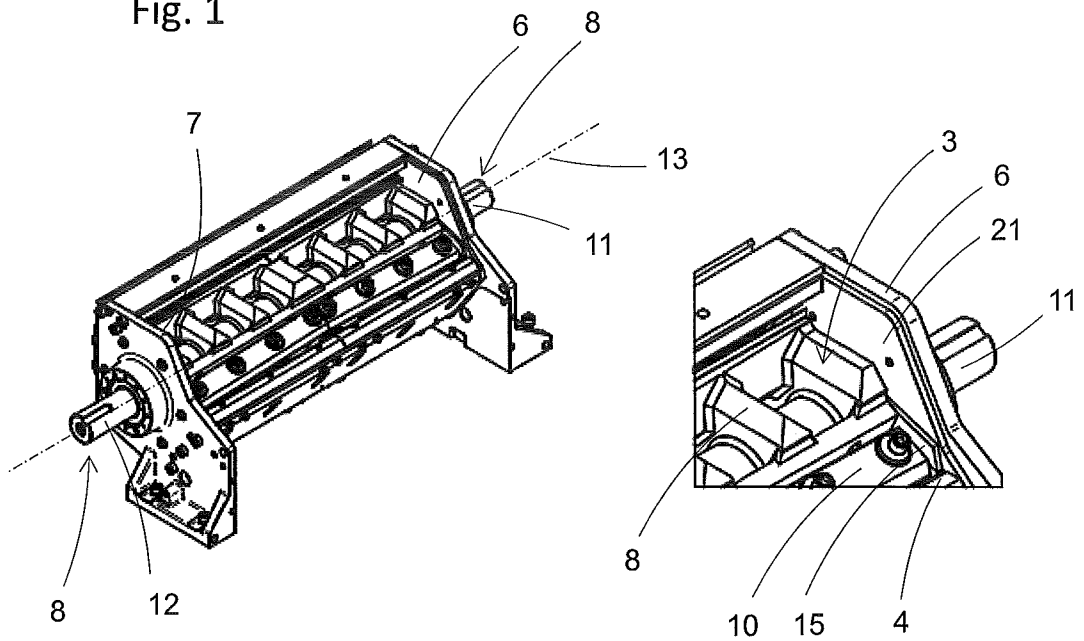


Fig. 2A

Fig. 2B

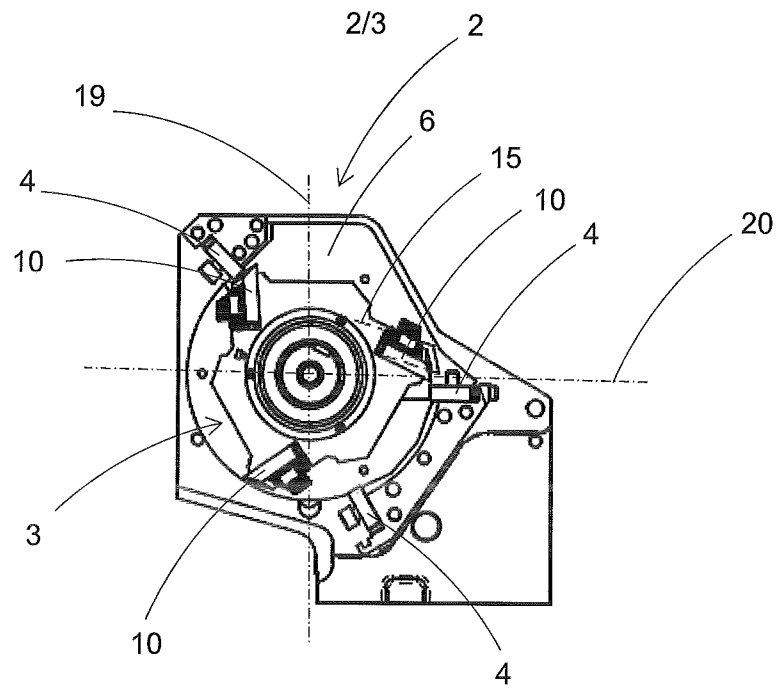


Fig. 3

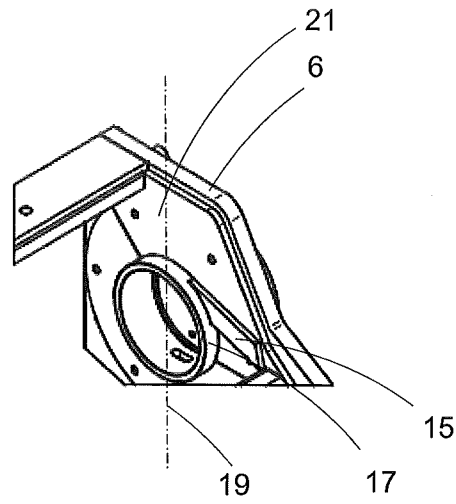


Fig. 4

3/3

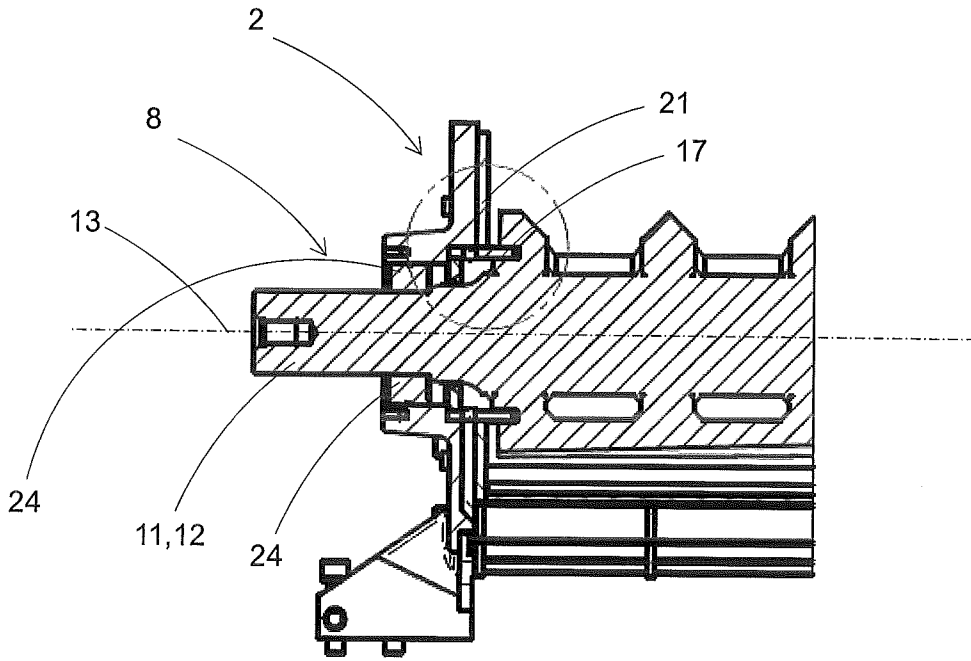


Fig. 5A

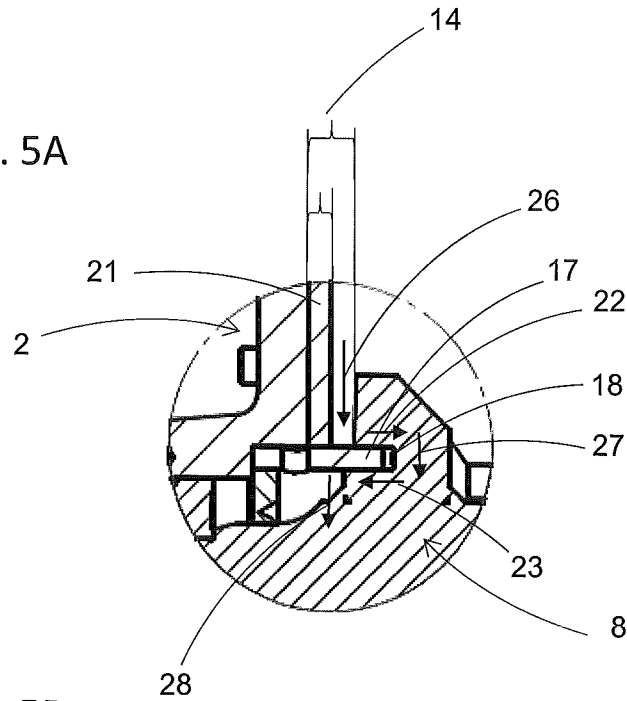


Fig. 5B

INTERNATIONAL SEARCH REPORT

International application No.
PCT/SE2018/050322

A. CLASSIFICATION OF SUBJECT MATTER		
IPC: see extra sheet		
According to International Patent Classification (IPC) or to both national classification and IPC		
B. FIELDS SEARCHED		
Minimum documentation searched (classification system followed by classification symbols)		
IPC: B02C		
Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched		
SE, DK, FI, NO classes as above		
Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)		
EPO-Internal, PAJ, WPI data		
C. DOCUMENTS CONSIDERED TO BE RELEVANT		
Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	JP 2011104537 A (KAWATA MFG), 2 June 2011 (2011-06-02); abstract; figure 5 --	1-11
A	JP 2010042384 A (MATSUI MFG CO), 25 February 2010 (2010-02-25); abstract; figures 1-3, 5-7 --	1-11
A	JP 09150071 A (SHIN MEIWA IND CO LTD), 10 June 1997 (1997-06-10); abstract; figure 1 --	1-11
A	JP 2002233780 A (KURIMOTO LTD), 20 August 2002 (2002-08-20); abstract; figures --	1-11
<input checked="" type="checkbox"/> Further documents are listed in the continuation of Box C. <input checked="" type="checkbox"/> 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 "E" earlier application or patent but published on or after the international filing date "L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified) "O" document referring to an oral disclosure, use, exhibition or other means "P" document published prior to the international filing date but later than the priority date claimed "T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention "X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone "Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art "&" document member of the same patent family		
Date of the actual completion of the international search 02-05-2018		Date of mailing of the international search report 02-05-2018
Name and mailing address of the ISA/SE Patent- och registreringsverket Box 5055 S-102 42 STOCKHOLM Facsimile No. + 46 8 666 02 86		Authorized officer Katarina Ekman Telephone No. + 46 8 782 28 00

INTERNATIONAL SEARCH REPORT

International application No.
PCT/SE2018/050322

C (Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT		
Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	US 20130175379 A1 (VANTREASE DALE L), 11 July 2013 (2013-07-11); paragraphs [0033], [0035]-[0036]; figure 2 -- -----	1-11

Continuation of: second sheet

International Patent Classification (IPC)

B02C 18/16 (2006.01)

B02C 18/14 (2006.01)

INTERNATIONAL SEARCH REPORT

Information on patent family members

International application No.

PCT/SE2018/050322

JP	2011104537 A	02/06/2011	CN	102059168 B	16/03/2016
JP	2010042384 A	25/02/2010	CN	101653738 B	08/01/2014
			JP	4759599 B2	31/08/2011
JP	09150071 A	10/06/1997	NONE		
JP	2002233780 A	20/08/2002	JP	3635240 B2	06/04/2005
US	20130175379 A1	11/07/2013	US	9033270 B2	19/05/2015