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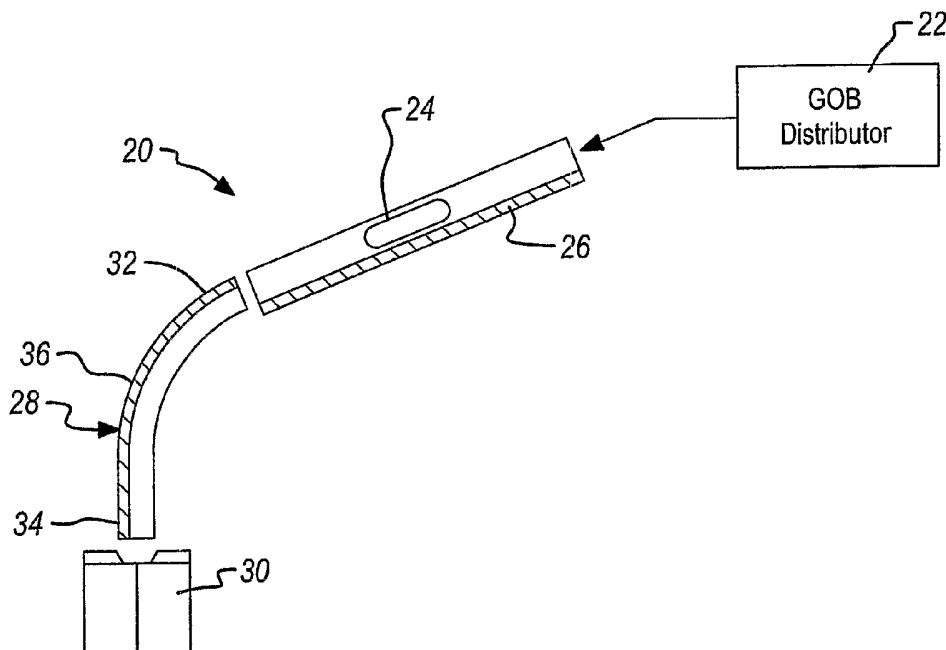
- as to applicant's entitlement to apply for and be granted a patent (Rule 4.17(ii))
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(54) Title: VARIABLE RADIUS DEFLECTOR



(57) Abstract: A gob deflector (28) has an entry end (32) for receiving molten glass gobs, an exit end (34) for directing the glass gobs into a blank mold (30) of a glassware forming machine, and a curved portion (36) between the entry and exit ends. The curved portion has an arc defined by an upper curve contiguous with the inlet end of the deflector and a lower curve contiguous with the entry end of the deflector. The upper and lower curves have differing radii as a function of angle along the curved portion of the deflector. 10



For two-letter codes and other abbreviations, refer to the "Guidance Notes on Codes and Abbreviations" appearing at the beginning of each regular issue of the PCT Gazette.

VARIABLE RADIUS DEFLECTOR

The present invention relates to glassware forming machines, and more particularly to the curvature of the deflector that directs molten glass gobs into the blank mold of a glassware forming machine.

Background and Objects of the Invention

5 In individual section glassware forming machines, mold charges or gobs of molten glass are fed by a gob distributor along troughs to the machine sections in sequence, and then by deflectors at each machine section into the blank molds at that section. The deflectors have an arcuate contour to convert the downwardly angled motion along the troughs to vertical motion into the blank molds. U.S. Patent 4,772,306 teaches that the centerline of the deflector lies along
10 a spiral curve in which the radius varies as a function of angle. Thus, in FIG. 8 of the present application, the radius of the centerline of the deflector curve varies according to the equation $r = C/\theta^P$, where θ is angle from the deflector exit end, C is a constant that is determined at a selected (r, θ) coordinate pair, and P is an exponent that controls the shape of the curve. The deflector curve has a minimum radius at the entrance end from the associated trough, and a
15 maximum radius at the exit end above the associated blank mold. The height of the deflector is controlled by the layout of the machine, and is specified as the intersection height a, which is the vertical distance above the deflector exit to a point that intersects the trough centerline.

A major concern in the design of gob deflectors is the normal or radial force exerted by the deflector on the gob due to centrifugal acceleration during travel of the glass gob
20 along the deflector. A positive normal force throughout travel along the deflector is necessary to maintain control of the gob, and to control loading of the gob into the blank mold. However, excessive normal force increases heat transfer from the gob to the deflector, increases friction

between the gob and the surface of the deflector, causes greater elongation of the gob, and cools the gob on the side in contact with the deflector, which undesirably can lead to distortion of the blow molded glass container. Furthermore, a high normal force at the exit end of the deflector would allow the gob to continue to travel outward as the gob leaves the exit end of the deflector, rather than vertically downwardly into the associated blank mold. A general object of the present invention is to provide a gob deflector that addresses these areas of concern.

Summary of the Invention

In accordance with the present invention the curved portion of the deflector is defined by two spiral curves that connect at a central portion of the deflector. The spiral curves are reflected about a line perpendicular to the intersection of the two curves, so that the minimum radius of each spiral curve is at the point where the curves meet. The exponent P and constant C for each curve can be specified independently.

Thus, a gob deflector in accordance with one aspect of the present invention has an entry end for receiving molten glass gobs, an exit end for directing the glass gobs into a blank mold of a glassware forming machine, and a curved portion between the entry and exit ends. The curved portion has an arc defined by an upper curve contiguous with the entry end of the deflector and a lower curve contiguous with the exit end of the deflector. The upper and lower curves have radii as differing functions of angle along the curved portion of the deflector.

In the preferred embodiments of the invention, the lower curve adjacent to the exit end of the deflector is defined by the equation $r_1 = C_1/\theta_1^{P_1}$, where r_1 is the radius at angle θ_1 , and C_1 and P_1 are constants. The upper curve adjacent to the entry end of the deflector is defined by the equation $r_2 = C_2/\theta_2^{P_2}$, where r_2 is the radius at angle θ_2 , and C_2 and P_2 are constants. The curves have minimum radii $r_{1_{\min}} = r_{2_{\min}}$ where the curves meet at the central portion of the deflector curved portion. At least one of the constants P_1 and P_2 is non-zero. In

the preferred embodiments, the constant P1 is non-zero, and the constant P2 may be non-zero or may be equal to zero such that the upper curve has a constant radius $r_2 = C_2$.

Brief Description of the Drawings

5 The invention, together with additional objects, features, advantages and aspects thereof, will best be understood from the following description, the appended claims and the accompanying drawings, in which:

FIG. 1 is a schematic diagram of a gob feed system in accordance with one presently preferred embodiment of the invention;

10 FIG. 2 is a graph that illustrates curvature of the gob deflector in the system of FIG. 1;

FIG. 3 is a graphic illustration of deflector curvature in accordance with two preferred embodiments of the invention as compared with the prior art;

FIG. 4 is a schematic diagram that illustrates normal force applied to the glass gob during travel along the deflector;

15 FIGS. 5-7 are graphs that illustrate operation of two presently preferred embodiments of the invention; and

FIG. 8 is graph that illustrates deflector curvature in accordance with the prior art.

Detailed Description of Preferred Embodiments

FIG. 1 illustrates a molten glass gob delivery system 20 to one blank mold of an individual section glassware forming machine. A gob distributor 22 receives molten glass gobs 24 from a suitable source (not shown), and feeds the glass gobs along troughs 26 to the individual machine sections. At each machine section, one or more deflectors 28 receive and deflect gobs 24 into associated blank molds 30. Each gob deflector 28 has an entry end 32 for receiving gobs from an associated trough 26, an exit end 34 for directing the gobs vertically downwardly into an associated blank mold 30, and a curved portion 36 that extends between the entry and exit ends. It will be appreciated that FIG. 1 schematically illustrates only one trough 26 and deflector 28 associated with one blank mold 30 of one machine section. Each machine section may contain several blank molds 30 with associated deflectors 28 and troughs 26, with associated gobs 24 being fed to troughs 26 by gob distributor 22.

FIG. 2 illustrates the curvature of the center line of deflector central portion 36 between entry end 32 and exit end 34. The curvature of central portion 36 has an arc defined by an upper curve 40 contiguous with entry end 32 and a lower curve 42 contiguous with exit end 34. Lower curve 42 has a radius $r_1 = C_1/\theta_1^{P_1}$, where r_1 is the radius of curvature, θ_1 is the angle from a line 44 perpendicular to the exit angle of the deflector (preferably horizontal), and C_1 and P_1 are constants. Upper curve portion 40 has a radius of curvature $r_2 = C_2/\theta_2^{P_2}$, where r_2 is radius of curvature, θ_2 is angle from a line 46 perpendicular to the entrance angle to the deflector (trough angle ϕ), and C_2 P_2 are constants. At the central portion of the deflector where curves 40, 42 meet, at the angle θ_M from line 44, $r_1 = r_2 = r_{\min}$. Intersection height a and trough angle ϕ are determined by the design of the glassware forming machine. Upper curve 40 preferably is tangent with trough angle ϕ , and lower curve 42 preferably is tangent with the vertical centerline of blank mold 30.

FIG. 3 illustrates the curvature of three exemplary deflectors, design 15 and design 16 in accordance with embodiments of the present invention, and a standard deflector 17 in accordance with the prior art. The following table gives parameters for the three designs:

Design	Min. Radius (r min, cm)	P1	C1	P2	C2	Match Angle (θ_M , degrees)
17	32.61	0.6193	14.0153	N/A	N/A	66.0000
15	63.5	0.6	13.9097	0	25	21.5650
16	63.5	0.4	24.1950	0	25	52.7945

Intersection height a for each deflector is 76.1 cm, and trough angle ϕ for each design is 24° .

FIG. 4 is a schematic illustration of normal or radial force exerted by the deflector on the glass gob due to centrifugal acceleration, with the magnitude of the normal force being illustrated by the lengths of the arrows perpendicular to the curvature of the deflector. Normal accelerations for designs 15, 16 and 17 are shown in FIG. 5. For all examples, the gob entrance velocity is 6 m/s and coefficient of friction is 0.125. The upper right of each curve is the acceleration at the entrance to the deflector and the lower left is acceleration at the exit. The analysis shows that the normal acceleration at the entry end of the deflector is drastically reduced by designs 15 and 16 in accordance with the present invention. Also, the normal acceleration approaches zero asymptotically in design 15, and approaches zero more abruptly in design 16. (The normal acceleration approaches zero approximately linearly for $P1 = 0.5$.) Constant $P1$ preferably is in the range of 0.4 to 0.7. Constant $P2$ preferably is in the range of zero to 0.5.

FIGS. 6 and 7 respectively illustrate tangential acceleration and velocity for designs 15, 16 and 17, with the right end of each curve at the entrance to the deflector and the

left end of each curve at the exit end of the deflector. As shown in FIG. 6, the glass gob has less deceleration at the entrance end of deflector designs 15 and 16, and therefore slightly higher velocities (FIG. 7) throughout the length of the deflector.

There thus has been disclosed a gob deflector that fully achieves all of the objects and aims previously set forth. The present invention has been disclosed in conjunction with a number of presently preferred embodiments, and various modifications and variations have been discussed. Other modifications and variations readily will suggest themselves to persons of ordinary skill in the art without departing from the scope of the present invention. The present invention is intended to embrace all such modifications and variations as fall within the spirit and broad scope of the appended claims.

Claims

1.

1 A gob deflector having an entry end (32) for receiving molten glass gobs and exit
2 end (34) for directing the glass gobs into a blank mold (30) of a glassware forming machine,
3 said deflector having a curved portion (36) between said entry and exit ends,
4 said curved portion having an arc defined by an upper curve contiguous with said
5 entry end and a lower curve contiguous with said exit end,
6 said lower curve being defined by the equation $r_1 = C_1/\theta_1^{P_1}$, where r_1 is radius
7 at angle θ_1 , and C_1 and P_1 are constants,
8 said upper curve being defined by the equation $r_2 = C_2/\theta_2^{P_2}$, where r_2 is radius
9 at angle θ_2 , and C_2 and P_2 are constants,
10 said curves having minimum radii $r_{1_{\min}} = r_{2_{\min}}$ where said curves meet at a central
11 portion of said curved portion,
12 at least one of said constants P_1 and P_2 being non-zero.

2.

1 The deflector set forth in claim 1 wherein said constant P_1 is non-zero.

3.

1 The deflector set forth in claim 1 wherein said constant P_2 is non-zero.

4.

1 The deflector set forth in claim 1 wherein said constant P2 is zero, such that said
2 upper curve portion has a constant radius $r_2 = C_2$.

5.

1 The deflector set forth in claim 2 wherein said constant P1 is in the range of 0.4
2 to 0.7.

6.

1 A gob deflector having an entry end (32) for receiving molten glass gobs and an
2 exit end (34) for directing the glass gobs into a blank mold (30) of a glassware forming machine,
3 said deflector having a curved portion (36) between said entry and exit ends,
4 said curved portion having an arc defined by an upper curve contiguous with said
5 entry end and lower curve contiguous with said exit end,
6 said upper and lower curves having radii as differing functions of angle along said
7 curved portion.

7.

1 The deflector set forth in claim 6 wherein both of said curves have radii that vary
2 with angle.

8.

1 The deflector set forth in claim 6 wherein said upper curve has a constant radius
2 as a function of angle.

9.

1 The deflector set forth in claim 6 wherein said lower curve is defined by the
2 equation $r_1 = C_1/\theta_1^{P_1}$, where r_1 is radius at angle θ_1 , and C_1 and P_1 are constants,
3 said upper curve is defined by the equation $r_2 = C_2/\theta_2^{P_2}$, where r_2 is radius at
4 angle θ_2 , and C_2 and P_2 are constants,
5 said curves having minimum radii $r_{1_{\min}} = r_{2_{\min}}$ where said curves meet at a central
6 portion of said curved portion, and
7 at least one of said constants P_1 and P_2 is non-zero.

10.

1 The deflector set forth in claim 9 wherein said constant P_1 is non-zero.

11.

1 The deflector set forth in claim 9 wherein said constant P_2 is non-zero.

12.

1 The deflector set forth in claim 9 wherein said constant P_2 is zero, such that said
2 upper curve portion has a constant radius $r_2 = C_2$.

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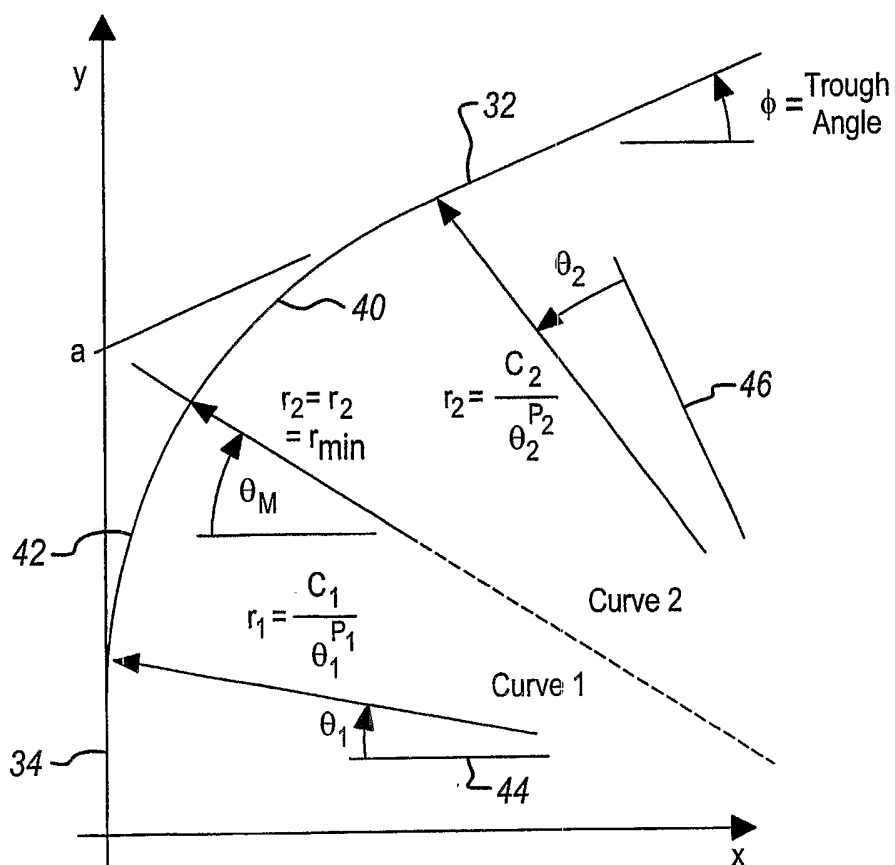
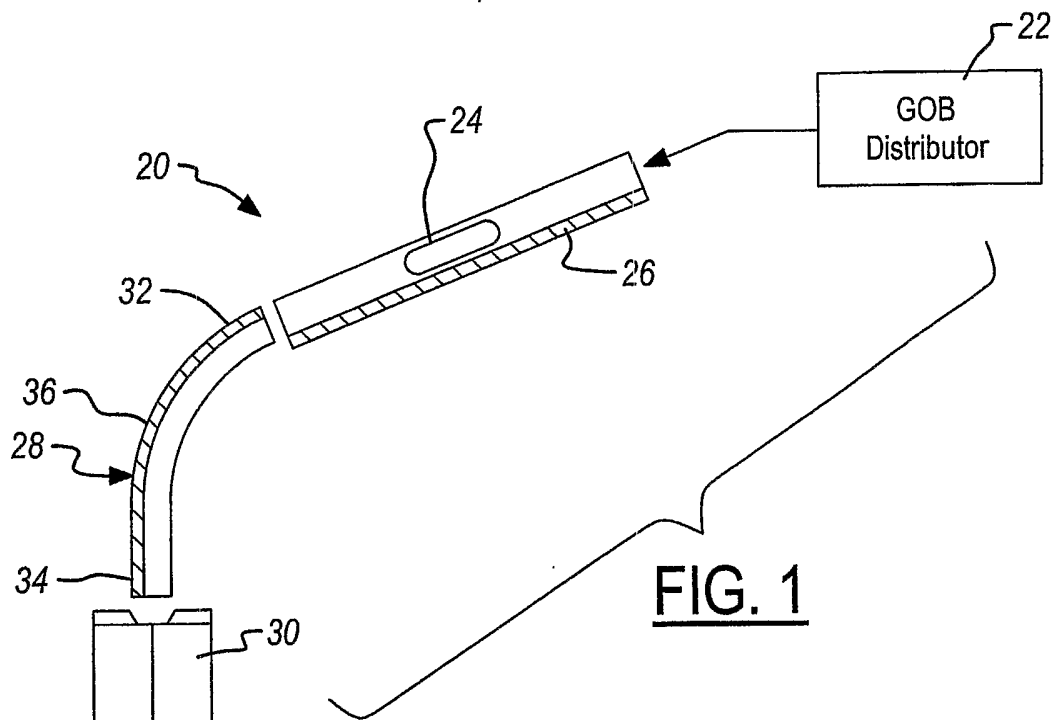


FIG. 2

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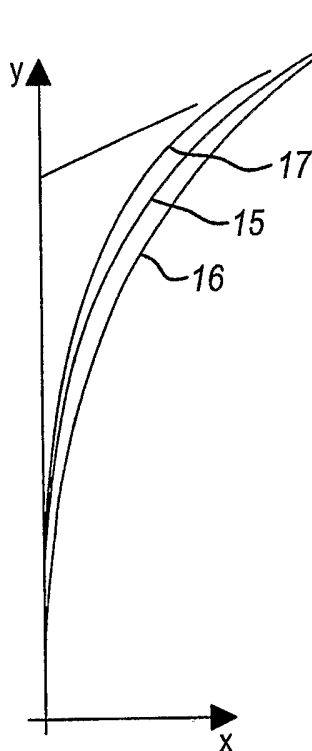


FIG. 3

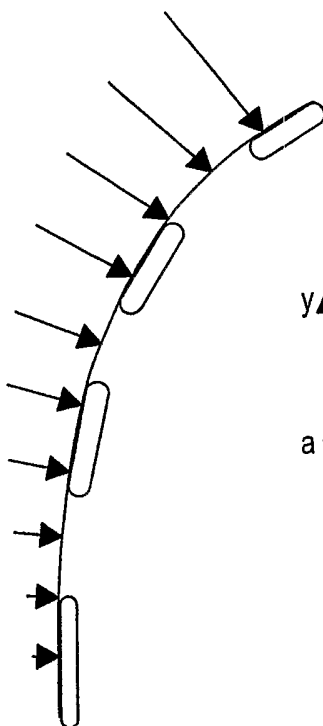
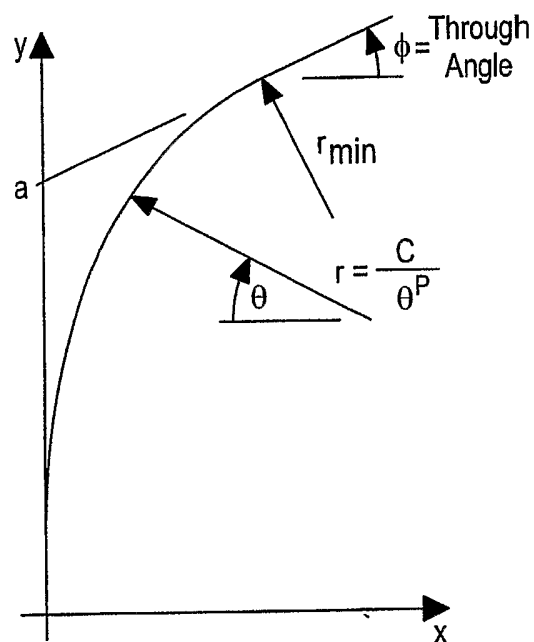


FIG. 4



(Prior Art)

FIG. 8

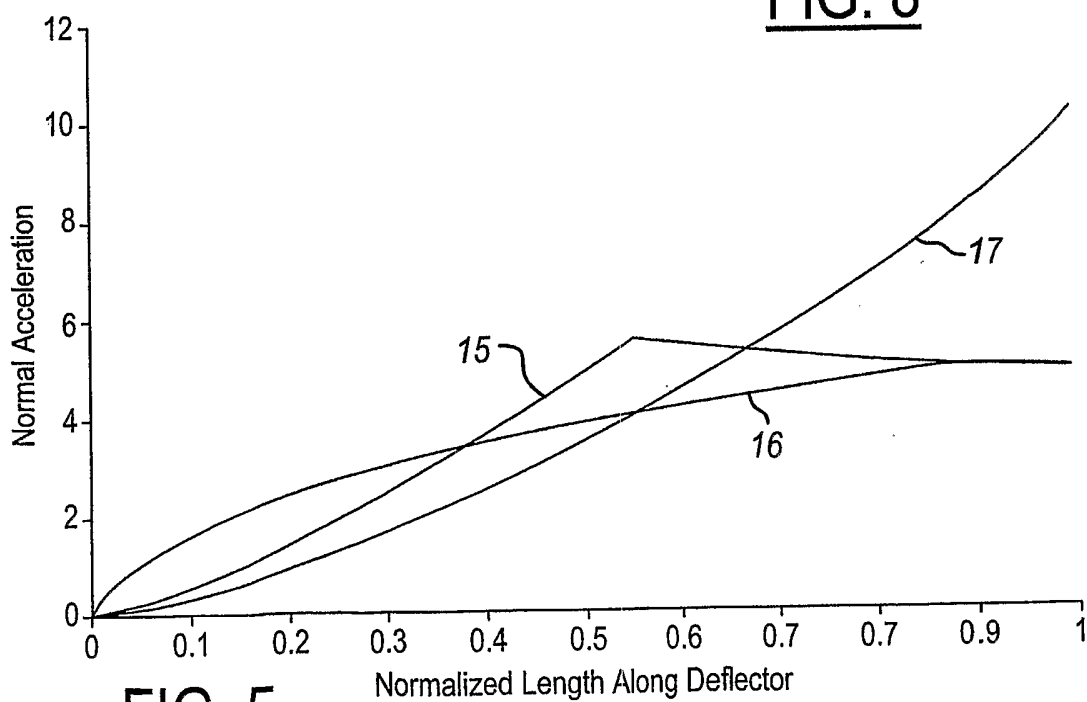
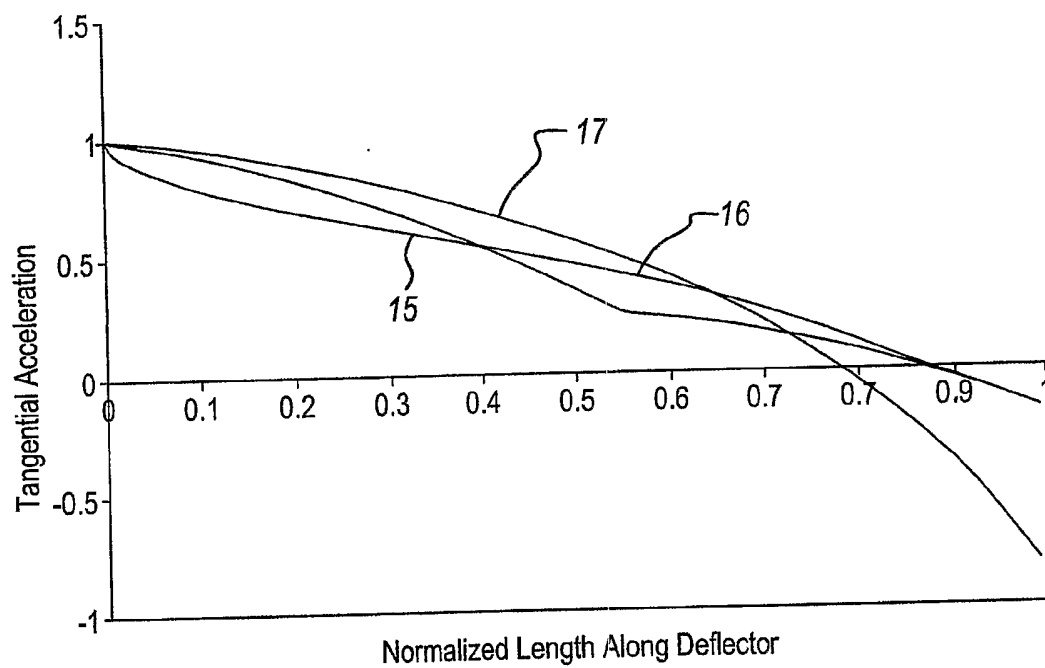
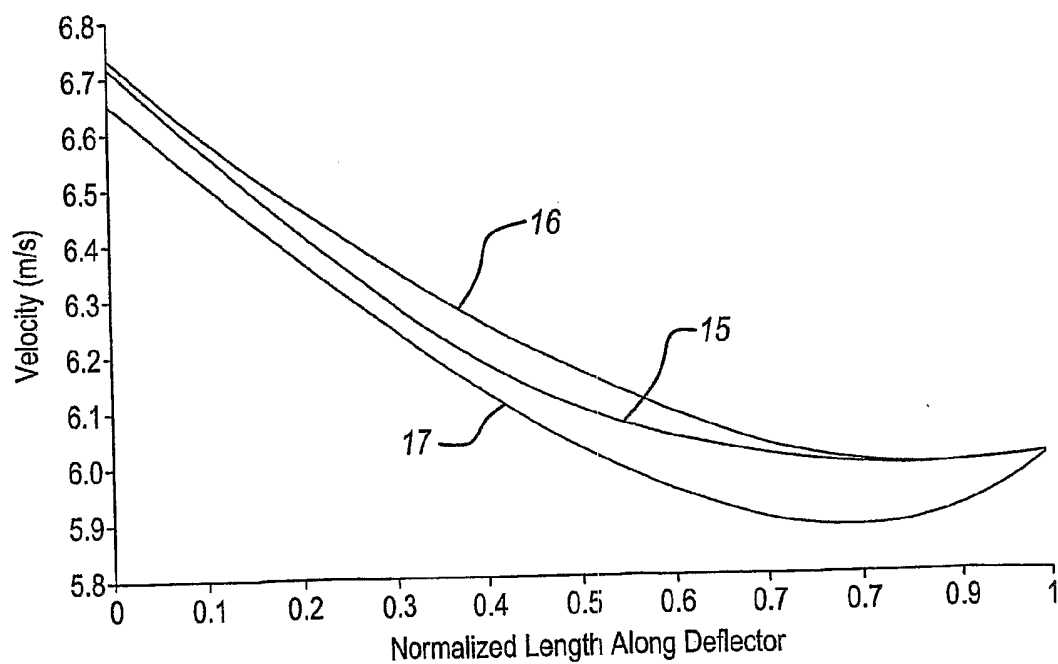


FIG. 5

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FIG. 6FIG. 7

INTERNATIONAL SEARCH REPORT

International Application No
PCT/US2005/033545

A. CLASSIFICATION OF SUBJECT MATTER C03B7/16

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)
C03B

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 practical, 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	US 4 772 306 A (DAVEY ET AL) 20 September 1988 (1988-09-20) column 1, line 43 - line 51; figure 3 column 3, line 38 - column 4, line 7 -----	1-5,7-12
X	US 5 846 283 A (STRUCKMEIER ET AL) 8 December 1998 (1998-12-08) column 3, line 27 - line 62; figures 1,32,33 column 8, line 53 - line 67 column 9, line 42 - line 46 column 14, line 20 - line 35; claim 15 -----	1,2,4,6, 8-10,12
A	US 5 935 287 A (GRAEFE ET AL) 10 August 1999 (1999-08-10) column 8, line 8 - column 9, line 45; claims 1,15-21; figures 11,12 ----- -/--	1-12

☒ Further documents are listed in the continuation of box C.

☒ Patent family members are listed in annex.

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Name and mailing address of the ISA

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INTERNATIONAL SEARCH REPORT

International Application No
PCT/US2005/033545

C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT		
Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	DE 101 52 962 A1 (BAYERISCHE FLASCHEN-GLASHUETTENWERKE WIEGAND & SOEHNE GMBH & CO. KG) 15 May 2003 (2003-05-15) paragraphs '0008!', '0012! - paragraph '0013!; figure 1 -----	1-12

INTERNATIONAL SEARCH REPORT

Information on patent family members

International Application No
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US 5846283	A	08-12-1998	NONE	
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