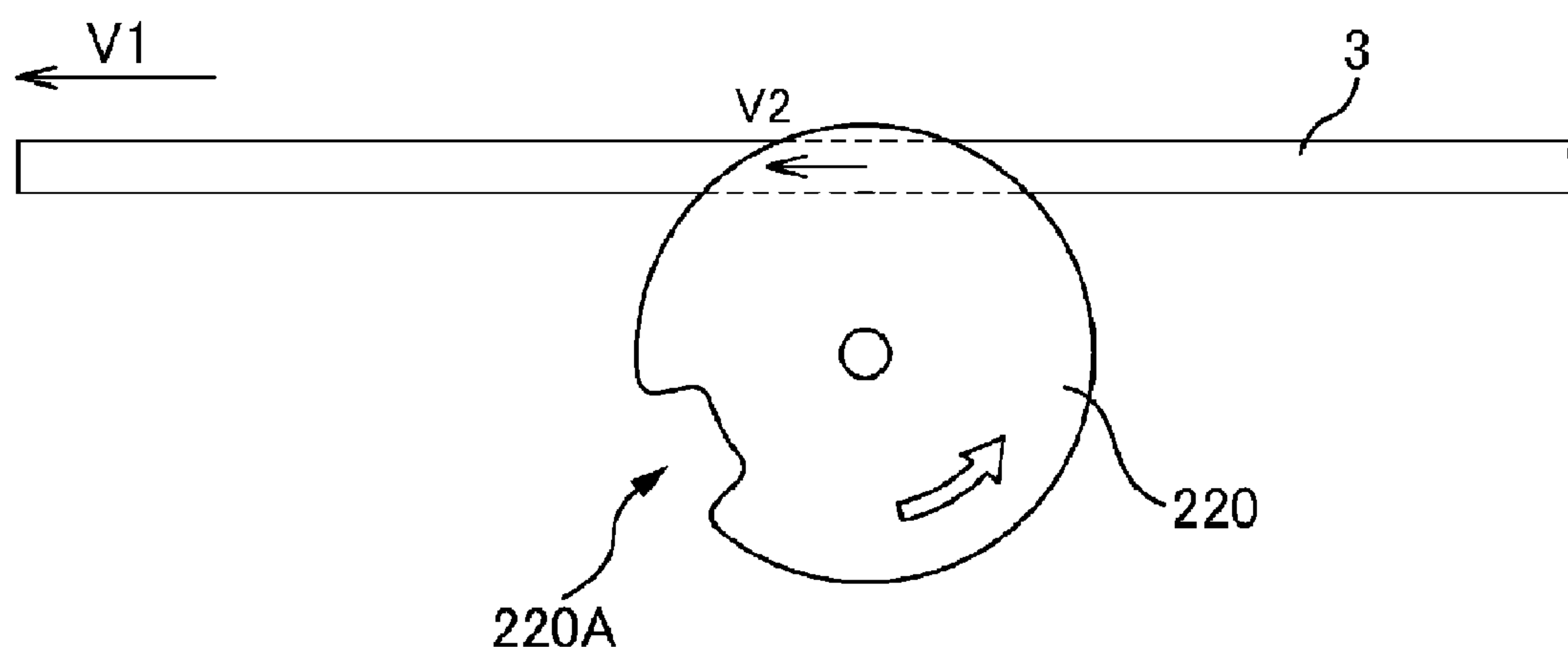




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(54) Titre : PROCEDE ET DISPOSITIF DE FABRICATION DE RUBAN DE FIBRE OPTIQUE
(54) Title: METHOD AND DEVICE FOR MANUFACTURING OPTICAL FIBER RIBBON



(57) Abrégé/Abstract:

Disclosed is a method for manufacturing an optical fiber ribbon 1 in which adjacent optical fibers 3 are connected intermittently in a length direction. The method involves: feeding the optical fibers 3 along the length direction; and applying a resin 9 intermittently in the length direction by rotating, between adjacent ones of the optical fibers 3, a rotating member 220 having a recess 220A. The moving speed V2, in the length direction, of a peripheral edge part of the rotating member 220 at a position where the peripheral edge part of the rotating member blocks the resin 9 between the optical fibers 3 is slower than the feeding speed V1 of the optical fibers 3.

ABSTRACT

Disclosed is a method for manufacturing an optical fiber
5 ribbon 1 in which adjacent optical fibers 3 are connected
intermittently in a length direction. The method involves:
feeding the optical fibers 3 along the length direction; and
applying a resin 9 intermittently in the length direction by
rotating, between adjacent ones of the optical fibers 3, a
10 rotating member 220 having a recess 220A. The moving speed
V2, in the length direction, of a peripheral edge part of the
rotating member 220 at a position where the peripheral edge
part of the rotating member blocks the resin 9 between the
optical fibers 3 is slower than the feeding speed V1 of the
15 optical fibers 3.

DESCRIPTION

Title of Invention: METHOD AND DEVICE FOR MANUFACTURING
OPTICAL FIBER RIBBON

5

Technical Field

[0001]

The present invention relates to a method and device for
manufacturing an optical fiber ribbon.

10

Background Art

[0002]

Optical fiber ribbons in which a plurality of optical
fibers are arranged side by side in the radial direction to
form a ribbon shape are conventionally known in the art. For
example, Patent Literature 1 discloses an optical fiber
ribbon wherein adjacent optical fibers are connected by
connection parts that are provided intermittently in the
length direction of the optical fibers.

20

Citation List

Patent Literature

[0003]

Patent Literature 1: JP 2010-33010A

25

Summary of Invention

Technical Problem

[0004]

In such optical fiber ribbons as those disclosed in Patent
Literature 1, if the strength of the connection parts is weak,
the connection parts may break when a force, such as a bending
force, is applied thereto.

30

[0005]

An objective of the invention is to provide a method and

device for manufacturing an optical fiber ribbon with which the strength of connection parts connecting adjacent optical fibers can be increased.

5 Solution to Problem
[0006]

 A primary aspect of the invention for achieving the
aforementioned objective is a method for manufacturing an
optical fiber ribbon in which adjacent optical fibers are
10 connected intermittently in a length direction, the method
involving: feeding the optical fibers along the length
direction; and applying a resin intermittently in the length
direction by rotating, between adjacent ones of the optical
fibers, a rotating member having a recess, wherein a moving
15 speed, in the length direction, of a peripheral edge part of
the rotating member at a position where the peripheral edge
part of the rotating member blocks the resin between the
optical fibers is slower than a feeding speed of the optical
fibers.

20 [0007]

 Other features of the invention are disclosed in the
present description and accompanying drawings.

Advantageous Effects of Invention

25 [0008]

 The invention can increase the strength of connection
parts connecting adjacent optical fibers.

Brief Description of Drawings

30 [0009]

 [Fig. 1] Fig. 1A is a perspective view illustrating an
example of a configuration of an optical fiber ribbon
according to an embodiment of the invention. Fig. 1B is a
cross-sectional view taken along line A-A of Fig. 1A.

[Fig. 2] Fig. 2A is a perspective view illustrating an example of a configuration of an optical fiber ribbon manufacturing device. Fig. 2B is a plan view illustrating a state in which adjacent optical fibers are connected by connection parts.

[Fig. 3] Fig. 3 is an explanatory diagram illustrating a relationship between an optical fiber and a rotating member.

[Fig. 4] Fig. 4A is a schematic diagram illustrating an optical fiber ribbon of Examples 1 to 5. Fig. 4B is an explanatory diagram illustrating a tearing test in Examples 1, 3, 4, and 5.

[Fig. 5] Fig. 5A is a table showing test results for Example 1. Fig. 5B is a table showing test results for Example 2.

[Fig. 6] Fig. 6 is a table showing test results for Example 3.

[Fig. 7] Fig. 7 is a table showing test results for Example 4, wherein Fig. 7A shows the results for when the diameter is 5 mm, and Fig. 7B shows the results for when the diameter is 25 mm.

[Fig. 8] Fig. 8 is a table showing test results for Example 5, wherein Fig. 8A shows the results for when the thickness is 20 μm , Fig. 8B shows the results for when the thickness is 50 μm , and Fig. 8C shows the results for when the thickness is 110 μm .

Description of Embodiments

[0010]

At least the following matters are disclosed in the present description and accompanying drawings.

[0011]

Disclosed is a method for manufacturing an optical fiber ribbon in which adjacent optical fibers are connected intermittently in a length direction, the method involving:

feeding the optical fibers along the length direction; and applying a resin intermittently in the length direction by rotating, between adjacent ones of the optical fibers, a rotating member having a recess, wherein a moving speed, in the length direction, of a peripheral edge part of the rotating member at a position where the peripheral edge part of the rotating member blocks the resin between the optical fibers is slower than a feeding speed of the optical fibers.

[0012]

10 With this optical fiber ribbon manufacturing method, the strength of connection parts connecting adjacent optical fibers can be increased, and the connection parts are less likely to break even when force, such as bending force, is applied.

15 [0013]

In this optical fiber ribbon manufacturing method, preferably, the feeding speed of the optical fibers is at least 2.9 times the moving speed, in the length direction, of the peripheral edge part caused by rotation of the rotating member at the position where the resin is blocked between the optical fibers.

[0014]

20 With this optical fiber ribbon manufacturing method, the strength of connection parts connecting adjacent optical fibers can be further increased.

[0015]

30 In this optical fiber ribbon manufacturing method, preferably, the feeding speed of the optical fibers is at most 35.1 times the moving speed, in the length direction, of the peripheral edge part caused by rotation of the rotating member at the position where the resin is blocked between the optical fibers.

[0016]

With this optical fiber ribbon manufacturing method, the

strength of connection parts connecting adjacent optical fibers can be further increased.

[0017]

Also disclosed is an optical fiber ribbon manufacturing device that manufactures an optical fiber ribbon according to the aforementioned optical fiber ribbon manufacturing method.

[0018]

With this optical fiber ribbon manufacturing device, it is possible to manufacture an optical fiber ribbon in which connection parts connecting adjacent optical fibers are less likely to break.

[0019]

Embodiments:

{Configuration of Optical Fiber Ribbon 1}

The configuration of an optical fiber ribbon 1 according to an embodiment is described with reference to Figs. 1A and 1B.

[0020]

Fig. 1A is a perspective view illustrating an example of a configuration of an optical fiber ribbon 1. Fig. 1B is a cross-sectional view taken along line A-A of Fig. 1A.

[0021]

The optical fiber ribbon 1 has a ribbon-like shape wherein a plurality of optical fibers 3 are arranged side by side in a direction intersecting with the optical axis direction and wherein adjacent optical fibers 3 are connected. Figs. 1A and 1B illustrate an optical fiber ribbon 1 formed by arranging four optical fibers 3 side by side.

[0022]

In the description below, the optical axis direction of the optical fibers 3 is referred to as "length direction" and the direction in which the optical fibers 3 are lined up is referred to as "ribbon width direction".

[0023]

Adjacent ones of the optical fibers 3 are connected by a plurality of connection parts 5 that are arranged intermittently in the length direction. The connection parts 5 are arranged intermittently in a two-dimensional pattern in the length direction and the ribbon width direction. As illustrated in Fig. 1B, each connection part 5 is formed by a resin 9 that covers the outer circumference of the optical fibers 3.

10 [0024]

Between adjacent optical fibers 3, the adjacent optical fibers 3 are not connected in regions other than the connection parts 5, and separated parts 7 (non-connected parts) are formed therebetween. Stated differently, in each separated part 7, the adjacent optical fibers 3 are not bound with one another. In this way, the optical fiber ribbon 1 can be rolled up into a tubular shape or be folded up, and a multitude of optical fibers 3 can be bundled with high density.

[0025]

20 As illustrated in Fig. 1B, each optical fiber 3 includes a glass fiber 3A, and a cover layer 3B that covers the outer circumference of the glass fiber 3A. The resin 9 covers the outer circumference of the cover layer 3B, and a portion of the resin 9 constitutes the connection part 5, as described above. For example, a UV-curable resin can be used for the resin 9.

[0026]

{Configuration of Manufacturing Device 2 and Method for Manufacturing Optical Fiber Ribbon 1}

30 Next, the configuration of a manufacturing device 2 for manufacturing the optical fiber ribbon 1, and a method for manufacturing the optical fiber ribbon 1 are described with reference to Figs. 2A, 2B, and 3.

[0027]

Fig. 2A is a perspective view illustrating an example of a configuration of a manufacturing device 2 for manufacturing the optical fiber ribbon 1. Fig. 2B is a plan view illustrating a state in which adjacent optical fibers 3 are connected by connection parts 5. Fig. 3 is an explanatory diagram illustrating a relationship between an optical fiber 3 and a rotating member 220.

[0028]

As illustrated in Fig. 2A, the manufacturing device 2 includes: a feeding unit (not illustrated) configured to feed a plurality of optical fibers 3 (four in Fig. 2A); an application unit 21 configured to apply molten resin (resin 9) to the plurality of optical fibers 3; a removing unit 22 configured to remove the molten resin; and a light source unit 23 configured to irradiate the molten resin with UV rays.

[0029]

The feeding unit is a section for feeding the plurality of optical fibers 3 along the length direction. The application unit 21 is a section for applying molten resin to the outer circumference of the optical fibers 3 and between adjacent optical fibers 3. The removing unit 22 includes a plurality of rotating members 220 (three in Fig. 2A), and is a section that rotates the rotating members 220 between the adjacent optical fibers 3 and blocks the molten resin, to thereby remove the molten resin.

[0030]

As illustrated in Fig. 3, each rotating member 220 has a disk shape that rotates about an axis along the ribbon width direction, and includes a recess 220A in a portion of its peripheral edge part. In Fig. 3, the rotating member 220 includes only one recess 220A. However, the number of recesses 220A is not necessarily limited to one, and the size and number of recesses 220A can be varied depending on the use.

[0031]

When each rotating member 220 is rotated (in the counter-clockwise direction in Fig. 3) and the peripheral edge part where no recess 220A is formed comes between adjacent optical fibers 3, the peripheral edge part blocks the molten resin. This thereby forms a section that becomes a separated part 7 (see Figs. 1A, 1B, and 2B). On the other hand, when the recess 220A comes between adjacent optical fibers 3, the molten resin is not blocked and flows into the recess 220A. This thereby forms a section that becomes a connection part 5 (see Figs. 1A, 1B, and 2B).

[0032]

The moving speed V2, in the length direction, of the peripheral edge part (i.e., the peripheral edge part where no recess 220A is formed) of the rotating member 220 at the position where the peripheral edge part blocks the molten resin between adjacent optical fibers 3 is set so as to be slower than the feeding speed V1 of the plurality of optical fibers 3 (the optical fiber ribbon 1) (i.e., $V2 < V1$). Herein "the moving speed V2, in the length direction, of the peripheral edge part of the rotating member 220 at the position where the peripheral edge part blocks the molten resin between adjacent optical fibers 3" is the speed found by converting the rotation speed (rpm) of the rotating member 220 into meters per minute (m/min) on the basis of the circumference (m) of the rotating member.

[0033]

Heretofore, the feeding speed V1 of the optical fibers 3 was the same as the moving speed V2, in the length direction, of the peripheral edge part of the rotating member 220 ($V1 = V2$). In contrast, Inventors have found that setting the speed to $V2 < V1$ increases the strength of the connection parts 5 and the resin 9 (i.e., sections illustrated in Fig. 1B; hereinafter "thin parts 90") formed continuously from the

respective connection parts 5 and adjacent thereto. The reason to this is thought to be that, compared to when the speed is $V1=V2$, a greater amount of molten resin is blocked by the peripheral edge part where no recess 220A is formed, and the blocked molten resin flows into the sections that become the connection parts 5 and the thin parts 90—i.e., the spreading of the molten resin is improved—and thus the connection parts 5 and the thin parts 90 are formed thicker (“d” illustrated in Fig. 1B) and their strength is increased. The relationship between the feeding speed $V1$, the moving speed $V2$, and the thickness d of the thin part 90 will be described further below.

[0034]

The light source unit 23 is a section for irradiating the molten resin applied to the optical fibers 3 with UV rays to cure the molten resin. As illustrated in Fig. 2A, the light source unit 23 includes temporary curing light sources 231 and a permanent curing light source 232.

[0035]

The molten resin is irradiated with UV rays by the temporary curing light sources 231 and is temporarily cured, and then irradiated with UV rays by the permanent curing light source 232 and is permanently cured. Herein, “temporarily cured” refers to a state where the resin has not been completely cured yet but curing has progressed on the surface. “Permanently cured” refers to a state where curing has progressed also on the inside. Note that, even in a permanently cured state, the optical fiber ribbon 1 has a degree of elasticity capable of being rolled up into a tubular form or being folded up.

[0036]

As illustrated in Fig. 2B, the optical fibers 3 immediately after exiting the application unit 21 and the removing unit 22 are separated from one another with spacings

therebetween. In this state, the molten resin is irradiated with UV rays by the temporary curing light sources 231 and the molten resin is temporarily cured. Then, the spacings between adjacent optical fibers 3 are gradually narrowed, to align the optical fibers 3 and gather them into a ribbon form. In Fig. 2B, the temporary curing light source 231 is illustrated with a broken line.

[0037]

At the time of gathering the optical fibers 3, even if adjacent optical fibers 3 contact one another at sections that become the separated parts 7, these sections do not get connected together, since the molten resin is in a temporarily cured state. Also, because the molten resin has yet to be permanently cured, the spacings between adjacent optical fibers 3 can be narrowed easily, even in sections that become the connection parts 5.

[0038]

As described above, an optical fiber ribbon 1 is manufactured through the steps of: feeding a plurality of optical fibers 3 along the length direction; applying molten resin (resin 9) intermittently in the length direction by rotating a rotating member 220 between adjacent ones of the optical fibers 3; irradiating the molten resin with UV rays to cure the resin; and gathering the optical fibers 3 together.

[0039]

{Examples}

In Examples 1 to 5, optical fiber ribbons 1 were manufactured by varying the feeding speed V1 of the optical fibers 3 and the moving speed V2, in the length direction, of the peripheral edge part of the rotating member 220. Examples 1 to 5 are described with reference to Figs. 4A and 4B. As for the evaluation of the connection parts 5, Examples 1 and 2 are described with reference to Figs. 5A and 5B, Example 3 is described with reference to Fig. 6, Example 4 is described

with reference to Figs. 7A and 7B, and Example 5 is described with reference to Figs. 8A to 8C.

[0040]

Fig. 4A is a schematic diagram illustrating an optical fiber ribbon 1 of Examples 1 to 5. Fig. 4B is an explanatory diagram illustrating a tearing test in Examples 1, 3, 4, and 5. Fig. 5A is a table showing test results for Example 1. Fig. 5B is a table showing test results for Example 2. Fig. 6 is a table showing test results for Example 3. Fig. 7 is a table showing test results for Example 4, wherein Fig. 7A shows the results for when the diameter is 5 mm, and Fig. 7B shows the results for when the diameter is 25 mm. Fig. 8 is a table showing test results for Example 5, wherein Fig. 8A shows the results for when the thickness is 20 μm , Fig. 8B shows the results for when the thickness is 50 μm , and Fig. 8C shows the results for when the thickness is 110 μm .

[0041]

{Example 1}

In Example 1, a 12-fiber optical fiber ribbon 1 as illustrated in Fig. 4A was prepared by using twelve optical fibers 3 having a diameter of 250 μm . In this Example, a molten resin having a viscosity of 0.1 Pa·s was used. The feeding speed V1 of the twelve optical fibers 3 was varied within a range from 150.0 to 900.0 m/min, and the moving speed V2, in the length direction, of the peripheral edge part of the rotating member 220 was varied within a range from 113.1 to 282.6 m/min. The concrete relationships (speed ratios) between the feeding speed V1 and the moving speed V2 are as shown in Fig. 5A.

[0042]

As illustrated in Fig. 4A, the size and number of recesses 220A in the respective rotating members 220 were adjusted such that all of the connection parts 5 had the same size. In Example 1, the length of each connection part 5 in the length

direction was 15 mm, and the length of each separated part 7 in the length direction was 55 mm. The rotating member 220 used had a diameter of 15 mm and a thickness of 80 μ m.

[0043]

5 In the optical fiber ribbon 1 illustrated in Fig. 4A, the thickness d of the thin part 90 in each of the twelve optical fibers 3 was measured. The measurement result of the thickness d of the thin part 90 is as shown as "minimum thickness d of resin" in Fig. 5A. More specifically, the
10 "minimum thickness d of resin" is a value calculated by averaging the thicknesses of the respective thin parts 90 (i.e., the minimum values of the thickness of the resin 9) in the respective twelve optical fibers 3.

[0044]

15 As illustrated in Fig. 5A, it can be understood that, by delaying the moving speed V2 with respect to the feeding speed V1, the value of the minimum thickness d of the resin becomes greater (thicker). Breakage of a connection part 5 occurs as a result of the resin 9 peeling from the thin parts 90 and
20 the connection part 5 thus getting split and breaking. Thus, by increasing the minimum thickness d of the resin by adjusting the speed ratio V1:V2, it is possible to increase the strength of the connection parts 5 and the thin parts 90 and thus inhibit the connection parts 5 from breaking.

25 [0045]

 The optical fiber ribbon 1 illustrated in Fig. 4A was subjected to a tearing test at thirty-three connection parts 5. The tearing test was performed, as illustrated in Fig. 4B, by: fixing an end of one optical fiber 31 among a pair
30 of adjacent optical fibers 31, 32; pulling the other optical fiber 32 at 100 mm/min in the direction of the arrow illustrated in Fig. 4B; and measuring the load (gf) applied to the connection part 5 at this time.

[0046]

More specifically, one optical fiber 31 is fixed at a position 10 cm away from one end (the end on the side to be torn) of the connection part 5, and the other optical fiber 32 is pulled. The unfixed end of the one optical fiber 31 and the non-pulled end of the other optical fiber 32 are located at a position 15 cm away from one end (the end on the side to be torn) of the connection part 5.

[0047]

In this tearing test, the load applied to the connection part 5 is considered the tearing force. Fig. 5A shows the maximum value, the minimum value, and the average value of the tearing force for when the feeding speed V1 of the optical fibers 3 and the moving speed V2, in the length direction, of the peripheral edge part of the rotating member 220 were varied.

[0048]

Next, the optical fiber ribbons 1 illustrated in Fig. 4A were used to prepare a 144-fiber optical fiber cable, and the cable was subjected to a strain/bend test. The strain/bend test was performed according to IEC 60794-1-2-E18 under the following conditions: tension: 130 kg; mandrel diameter: 250 mm; bending angle: 90°. After the strain/bend test, the 144-fiber optical fiber cable was disassembled, to verify whether there was breakage of the connection parts 5 in the optical fiber ribbon 1. The verification results are shown in Fig. 5A.

[0049]

With reference to the results of the tearing test and the results of the strain/bend test, it can be understood that, when the minimum value of the tearing force in the tearing test is 2.1 gf or greater, there is "no" breakage of the connection parts 5 after the strain/bend test. When the minimum value of the tearing force in the tearing test is 2.1 gf, the speed ratio V1:V2 between the feeding speed V1 of the

optical fibers 3 and the moving speed V_2 , in the length direction, caused by the rotation of the rotating member 220 is 2.9:1. At this ratio, the value of the minimum thickness d of the resin is $6.8\text{ }\mu\text{m}$, which is about twice the thickness at a speed ratio $V_1:V_2$ of 1.1:1, at which the value of the minimum thickness d of the resin is $3.5\text{ }\mu\text{m}$. Thus, it can be understood that, when the feeding speed V_1 of the optical fibers 3 is at least 2.9 times the moving speed V_2 , in the length direction, of the peripheral edge part of the rotating member 220, the thickness of the thin part 90 (minimum thickness d of the resin) is greater and the strength of the connection parts 5 and the thin parts 90 is further increased, and it is thereby possible to further inhibit breakage of the connection parts 5, compared to cases where $V_1=V_2$.

[0050]

Note that, although it is preferable that the feeding speed V_1 of the optical fibers 3 is at least 2.9 times the moving speed V_2 , in the length direction, of the peripheral edge part of the rotating member 220, Fig. 5A shows that the tearing force in the tearing test is increased even when the speed ratio $V_1:V_2$ is 2.1:1 and thus the strength of the connection parts 5 and the thin parts 90 is increased. Thus, the strength of the connection parts 5 and the thin parts 90 is increased so long as the speed relationship is at least $V_1>V_2$.

[0051]

{Example 2}

In Example 2, a 12-fiber optical fiber ribbon 1 as illustrated in Fig. 4A was prepared by using twelve optical fibers 3 having a diameter of $250\text{ }\mu\text{m}$, as in Example 1, and length difference measurement and the strain/bend test were performed within a range where there was "no" breakage of the connection parts 5 after the strain/bend test in Example 1-i.e., within a range where the feeding speed V_1 of the

optical fibers 3 was at least 2.9 times the moving speed V2, in the length direction, of the peripheral edge part of the rotating member 220. The strain/bend test was performed under the same conditions as in Example 1.

5 [0052]

More specifically, the feeding speed V1 of the twelve optical fibers 3 was varied within a range from 400.0 to 900.0 m/min, and the moving speed V2, in the length direction, of the peripheral edge part of the rotating member 220 was varied
10 within a range from 13.2 to 59.4 m/min. The concrete relationships (speed ratios) between the feeding speed V1 and the moving speed V2 are as shown in Fig. 5B.

[0053]

The length difference is represented by the percentage
15 (%) found by dividing, by the length of the optical fiber ribbon 1 in the length direction, the difference between the length of the optical fiber ribbon 1 in the length direction and the length, in the length direction, of a single optical fiber 3 individually separated from the optical fiber ribbon
20 1. Fig. 5B shows the maximum value, the minimum value, and the average value of the length difference for when the feeding speed V1 of the optical fibers 3 and the moving speed V2, in the length direction, of the peripheral edge part of the rotating member 220 were varied.

25 [0054]

If the length difference is large, slight bending may be applied to the optical fibers 3, which may lead to an increase in transmission loss and/or breaking of the optical fibers 3 when the optical fiber ribbon 1 is used to prepare an optical
30 fiber cable. Thus, it is preferable that the length difference is less than $\pm 0.1\%$.

[0055]

With reference to the results of measuring the length difference shown in Fig. 5B, it can be verified that the

maximum value of the length difference is 0.13% when the speed ratio V1:V2 is 40.0:1, and the maximum value of the length difference is 0.12% when the speed ratio V1:V2 is 45.5:1.
[0056]

5 Thus, taking the length difference into consideration, it is further preferable that the feeding speed V1 of the optical fibers 3 is from 2.9 to 35.1 times the moving speed V2, in the length direction, of the peripheral edge part of the rotating member 220. Note that, in Example 2, at all of
10 the ratios, there was "no" breakage of the connection parts 5 after the strain/bend test.
[0057]

{Example 3}

In Example 3, a 12-fiber optical fiber ribbon 1 as
15 illustrated in Fig. 4A was prepared by using twelve optical fibers 3 having a diameter of 250 μm , as in Example 1, by setting the speed ratios V1:V2 between the feeding speed V1 and the moving speed V2 to four ratios, i.e., 1.1:1, 2.1:1, 2.9:1, and 4.2:1, and the tearing test and the strain/bend
20 test were performed. Different from Example 1, a molten resin having a viscosity of 5.0 Pa·s was used in this Example. Other conditions, such as the size of the rotating members 220, were the same as in Example 1.
[0058]

25 Fig. 6 shows the maximum value, the minimum value, and the average value of the tearing force in the tearing test, and the results of the presence/absence of breakage of the connection parts 5 after the strain/bend test. With reference to the results of the tearing test and the results
30 of the strain/bend test, it can be understood that, when the minimum value of the tearing force in the tearing test is 2.0 gf or greater, there is "no" breakage of the connection parts 5 after the strain/bend test. When the minimum value of the tearing force in the tearing test is 2.0 gf, the speed ratio

V1:V2 is 2.9:1. Thus, as in Example 1, it can be understood that, when the feeding speed V1 of the optical fibers 3 is at least 2.9 times the moving speed V2, in the length direction, of the peripheral edge part of the rotating member 220, the strength of the connection parts 5 and the thin parts 90 can be increased. From the above, it can be understood that, regardless of the viscosity of the molten resin used, the strength of the connection parts 5 and the thin parts 90 can be increased according to the speed ratio between the feeding speed V1 and the moving speed V2.

[0059]

{Example 4}

In Example 4, rotating members 220 having different diameters from the rotating members 220 used in Examples 1 to 3 were used to prepare a 12-fiber optical fiber ribbon 1 as illustrated in Fig. 4A, and the tearing test and the strain/bend test were performed. In this Example, the thickness of the rotating members 220 was set to a constant value of 80 μm , whereas the rotating members were prepared in two diameters, 5 mm and 25 mm. Other conditions, such as the viscosity of the molten resin, were the same in these two cases.

[0060]

Fig. 7A shows the minimum thickness d of the resin, the maximum value, the minimum value, and the average value of the tearing force, and the results of the presence/absence of breakage of the connection parts 5 after the strain/bend test in the case where the diameter of the rotating member 220 was 5 mm. With reference to the results of the tearing test and the results of the strain/bend test, it can be understood that, when the minimum value of the tearing force in the tearing test is 4.4 gf or greater, there is "no" breakage of the connection parts 5 after the strain/bend test.

[0061]

As in Example 1, also in this case, it can be understood that, by delaying the moving speed V2 with respect to the feeding speed V1, the value of the minimum thickness d of the resin becomes greater (thicker). When the minimum value of the tearing force in the tearing test is 4.4 gf, the minimum thickness d of the resin is 7.3 μm . At this value, the speed ratio V1:V2 is 2.9:1. Thus, as in Examples 1 and 3, it can be understood that, when the feeding speed V1 of the optical fibers 3 is at least 2.9 times the moving speed V2, in the length direction, of the peripheral edge part of the rotating member 220, the strength of the connection parts 5 and the thin parts 90 can be increased.

[0062]

Fig. 7B shows the minimum thickness d of the resin, the maximum value, the minimum value, and the average value of the tearing force, and the results of the presence/absence of breakage of the connection parts 5 after the strain/bend test in the case where the diameter of the rotating member 220 was 25 mm. With reference to the results of the tearing test and the results of the strain/bend test, it can be understood that, when the minimum value of the tearing force in the tearing test is 2.3 gf or greater, there is "no" breakage of the connection parts 5 after the strain/bend test.

[0063]

As in the case where the diameter of the rotating member 220 is 5 mm, also in this case, it can be understood that, by delaying the moving speed V2 with respect to the feeding speed V1, the value of the minimum thickness d of the resin becomes greater (thicker). When the minimum value of the tearing force in the tearing test is 2.3 gf, the minimum thickness d of the resin is 6.5 μm . At this value, the speed ratio V1:V2 is 2.9:1. Thus, as in the case where the diameter of the rotating member 220 is 5 mm, it can be understood that, when the feeding speed V1 of the optical fibers 3 is at least

2.9 times the moving speed V_2 , in the length direction, of the peripheral edge part of the rotating member 220, the strength of the connection parts 5 and the thin parts 90 can be increased.

5 [0064]

As described above, in both cases where the diameter of the rotating member 220 is 5 mm and 25 mm, the evaluation results are "good" in cases where the feeding speed V_1 of the optical fibers 3 is at least 2.9 times the moving speed V_2 ,
10 in the length direction, of the peripheral edge part of the rotating member 220. Thus, it can be understood that, regardless of the diameter of the rotating members 220, the strength of the connection parts 5 and the thin parts 90 can be increased according to the speed ratio between the feeding
15 speed V_1 and the moving speed V_2 .

[0065]

{Example 5}

In Example 5, rotating members 220 having different thicknesses from the rotating members 220 used in Examples
20 1 to 3 were used to prepare a 12-fiber optical fiber ribbon 1 as illustrated in Fig. 4A, and the tearing test and the strain/bend test were performed. In this Example, the diameter of the rotating members 220 was set to a constant value of 15 mm, whereas the rotating members were prepared
25 in three thicknesses, 20 μm , 50 μm , and 110 μm . As in Example 4, other conditions, such as the viscosity of the molten resin, were the same in these three cases.

[0066]

Fig. 8A shows the minimum thickness d of the resin, the
30 maximum value, the minimum value, and the average value of the tearing force, and the results of the presence/absence of breakage of the connection parts 5 after the strain/bend test in the case where the thickness of the rotating member 220 was 20 μm . With reference to the results of the tearing

test and the results of the strain/bend test, it can be understood that, when the minimum value of the tearing force in the tearing test is 2.7 gf or greater, there is "no" breakage of the connection parts 5 after the strain/bend test.

5 [0067]

As in Examples 1 and 4, also in this case, it can be understood that, by delaying the moving speed V2 with respect to the feeding speed V1, the value of the minimum thickness d of the resin becomes greater (thicker). When the minimum
10 value of the tearing force in the tearing test is 2.7 gf, the minimum thickness d of the resin is 7.7 μm . At this value, the speed ratio V1:V2 is 2.9:1. Thus, as in Examples 1 and 3, it can be understood that, when the feeding speed V1 of the optical fibers 3 is at least 2.9 times the moving speed
15 V2, in the length direction, of the peripheral edge part of the rotating member 220, the strength of the connection parts 5 and the thin parts 90 can be increased.

[0068]

Fig. 8B shows the minimum thickness d of the resin, the
20 maximum value, the minimum value, and the average value of the tearing force, and the results of the presence/absence of breakage of the connection parts 5 after the strain/bend test in the case where the thickness of the rotating member 220 was 50 μm . With reference to the results of the tearing
25 test and the results of the strain/bend test, it can be understood that, when the minimum value of the tearing force in the tearing test is 2.6 gf or greater, there is "no" breakage of the connection parts 5 after the strain/bend test.

[0069]

30 As in the case where the thickness of the rotating member 220 is 20 μm , also in this case, it can be understood that, by delaying the moving speed V2 with respect to the feeding speed V1, the value of the minimum thickness d of the resin becomes greater (thicker). When the minimum value of the

tearing force in the tearing test is 2.6 gf, the minimum thickness d of the resin is 6.5 μm . At this value, the speed ratio $V1:V2$ is 2.9:1. Thus, as in the case where the thickness of the rotating member 220 is 20 μm , it can be understood that, when the feeding speed $V1$ of the optical fibers 3 is at least 2.9 times the moving speed $V2$, in the length direction, of the peripheral edge part of the rotating member 220, the strength of the connection parts 5 and the thin parts 90 can be increased.

10 [0070]

Fig. 8C shows the minimum thickness d of the resin, the maximum value, the minimum value, and the average value of the tearing force, and the results of the presence/absence of breakage of the connection parts 5 after the strain/bend test in the case where the thickness of the rotating member 220 was 110 μm . With reference to the results of the tearing test and the results of the strain/bend test, it can be understood that, when the minimum value of the tearing force in the tearing test is 3.5 gf or greater, there is "no" breakage of the connection parts 5 after the strain/bend test.

20 [0071]

As in the cases where the thicknesses of the rotating members 220 are 20 μm and 50 μm , also in this case, it can be understood that, by delaying the moving speed $V2$ with respect to the feeding speed $V1$, the value of the minimum thickness d of the resin becomes greater (thicker). When the minimum value of the tearing force in the tearing test is 3.5 gf, the minimum thickness d of the resin is 7.1 μm . At this value, the speed ratio $V1:V2$ is 2.9:1. Thus, as in the cases where the thicknesses of the rotating members 220 are 20 μm and 50 μm , it can be understood that, when the feeding speed $V1$ of the optical fibers 3 is at least 2.9 times the moving speed $V2$, in the length direction, of the peripheral edge part of the rotating member 220, the strength of the connection

parts 5 and the thin parts 90 can be increased.

[0072]

As described above, in all cases where the thicknesses of the rotating members 220 are 20 μm , 50 μm , and 110 μm , the evaluation results are "good" in cases where the feeding speed V1 of the optical fibers 3 is at least 2.9 times the moving speed V2, in the length direction, of the peripheral edge part of the rotating member 220. Thus, it can be understood that, regardless of the diameter of the rotating members 220, the strength of the connection parts 5 and the thin parts 90 can be increased according to the speed ratio between the feeding speed V1 and the moving speed V2.

[0073]

Others:

The foregoing embodiments are for facilitating the understanding of the present invention, and are not to be construed as limiting the present invention. The present invention may be modified and/or improved without departing from the gist thereof, and it goes without saying that the present invention encompasses equivalents thereof.

Reference Signs List

[0074]

1: Optical fiber ribbon;

25 2: Optical fiber ribbon manufacturing device;

3: Optical fiber;

9: Resin;

220: Rotating member;

220A: Recess.

30

[Claim 1] A method for manufacturing an optical fiber ribbon in which adjacent optical fibers are connected intermittently in a length direction, the method comprising:

5 feeding the optical fibers along the length direction;
and

 applying a resin intermittently in the length direction by rotating, between adjacent ones of the optical fibers, a rotating member having a recess and blocking the resin by a
10 peripheral edge part of the rotating member where the recess is not formed,

 wherein a moving speed, in the length direction, of the peripheral edge part of the rotating member at a position where the peripheral edge part of the rotating member blocks the
15 resin between the optical fibers is slower than a feeding speed of the optical fibers.

[Claim 2] The method for manufacturing an optical fiber ribbon according to claim 1, wherein the feeding speed of the
20 optical fibers is at least 2.9 times the moving speed, in the length direction, of the peripheral edge part caused by rotation of the rotating member at the position where the resin is blocked between the optical fibers.

[Claim 3] The method for manufacturing an optical fiber ribbon according to claim 2, wherein the feeding speed of the
25 optical fibers is at most 35.1 times the moving speed, in the length direction, of the peripheral edge part caused by rotation of the rotating member at the position where the resin
30 is blocked between the optical fibers.

[Claim 4] An optical fiber ribbon manufacturing device that manufactures an optical fiber ribbon according to the method for manufacturing an optical fiber ribbon according
35 to any one of claims 1 to 3.

[図1]

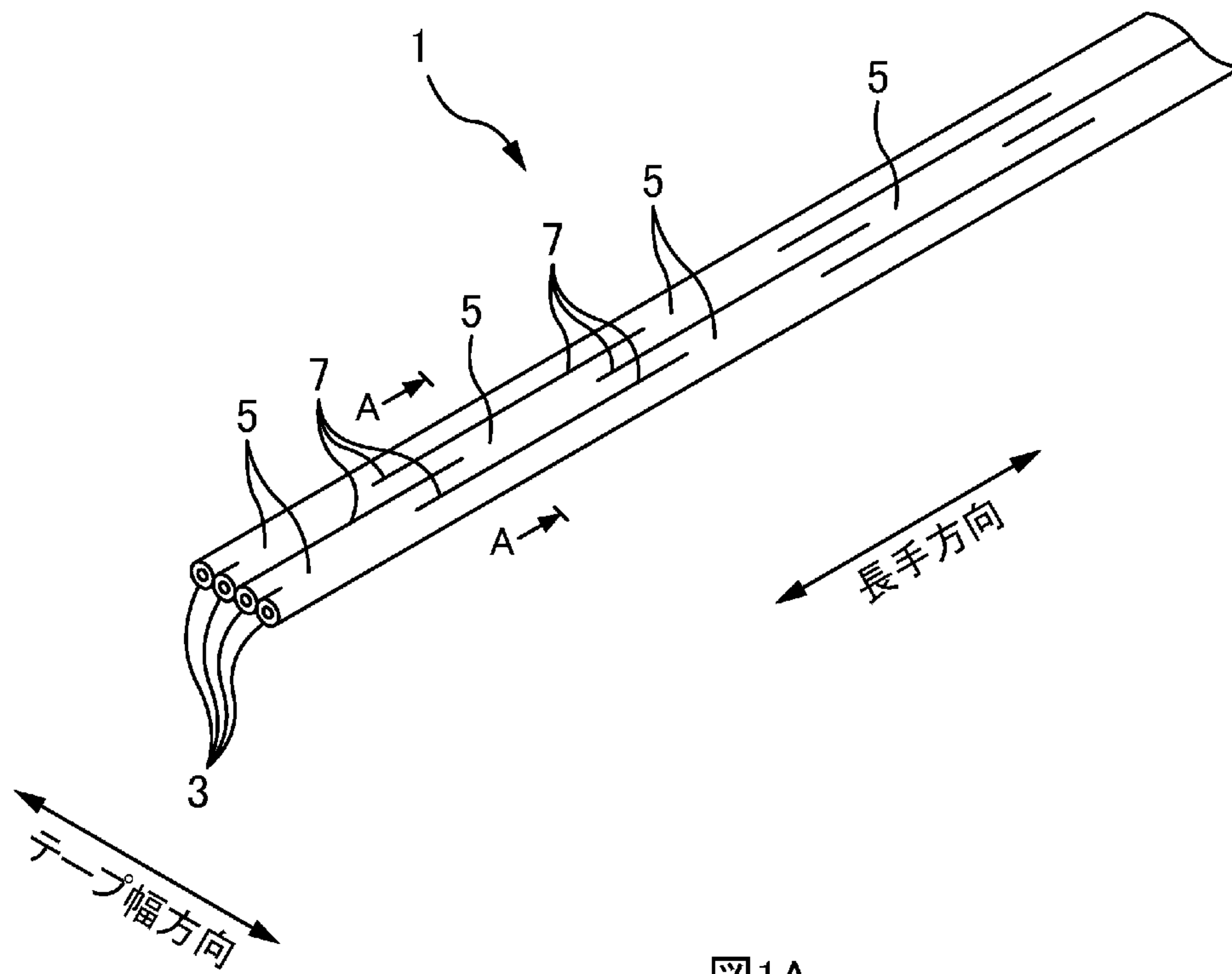


図1A

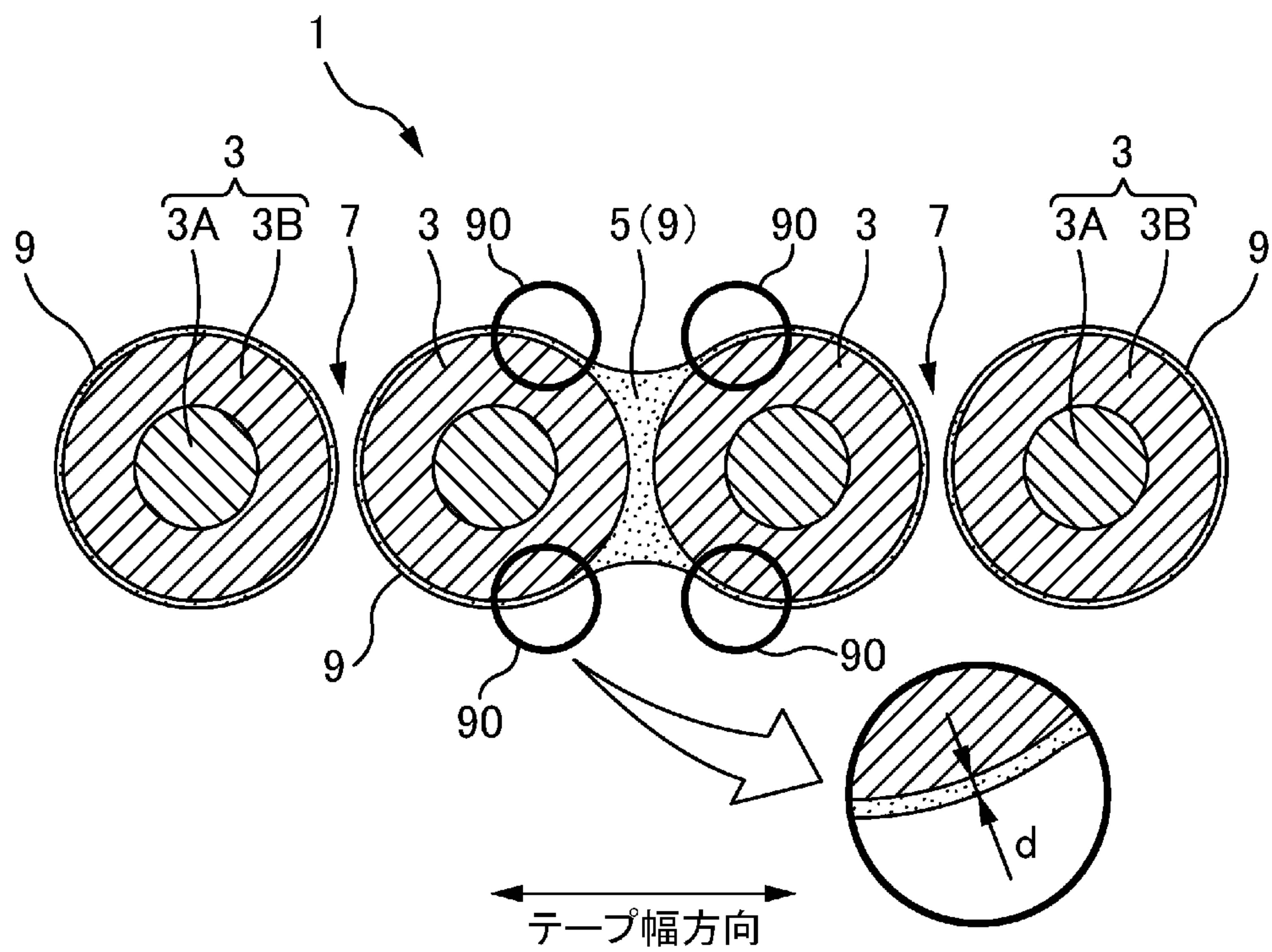


図1B

[図2]

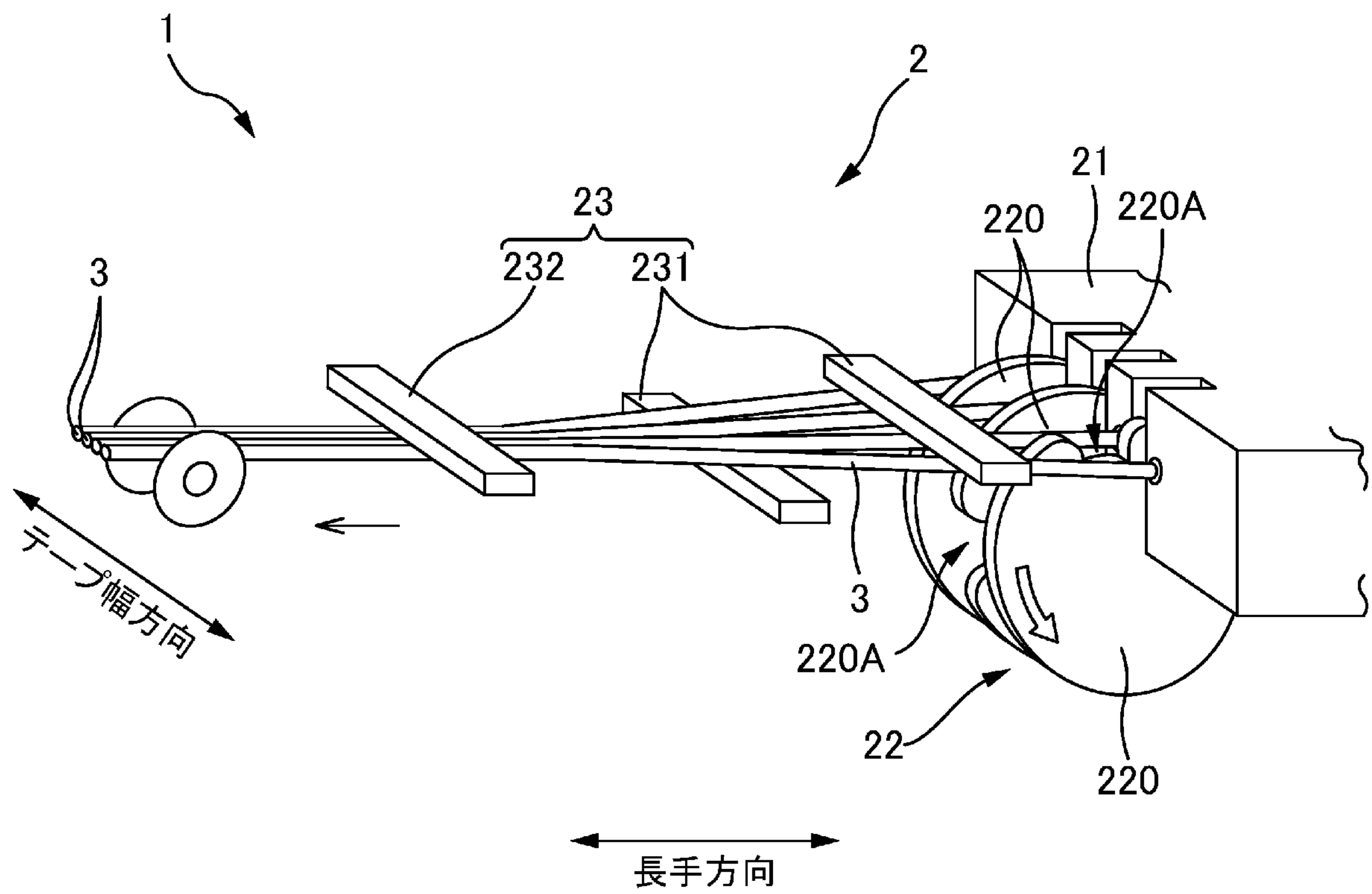


図2A

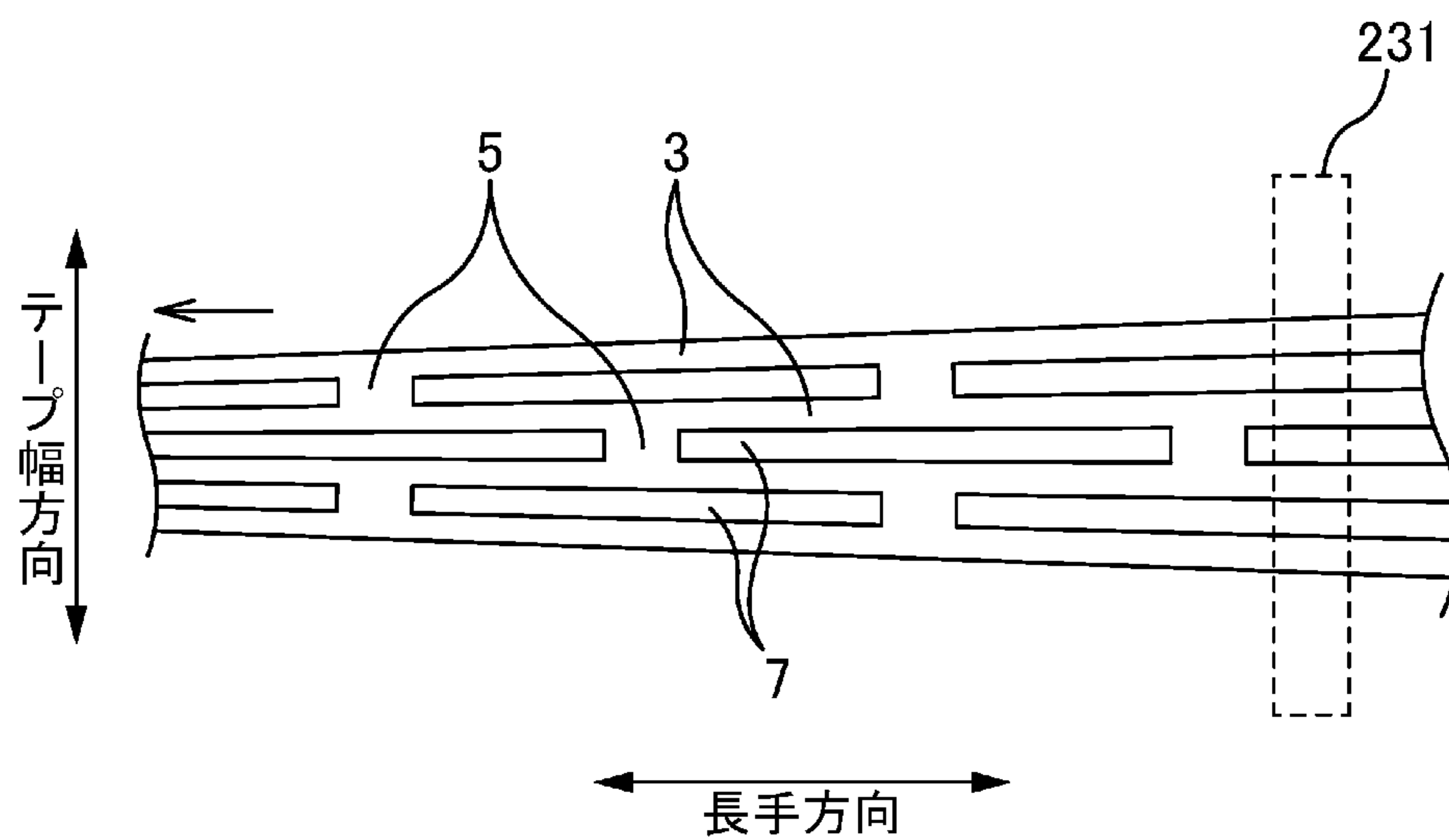
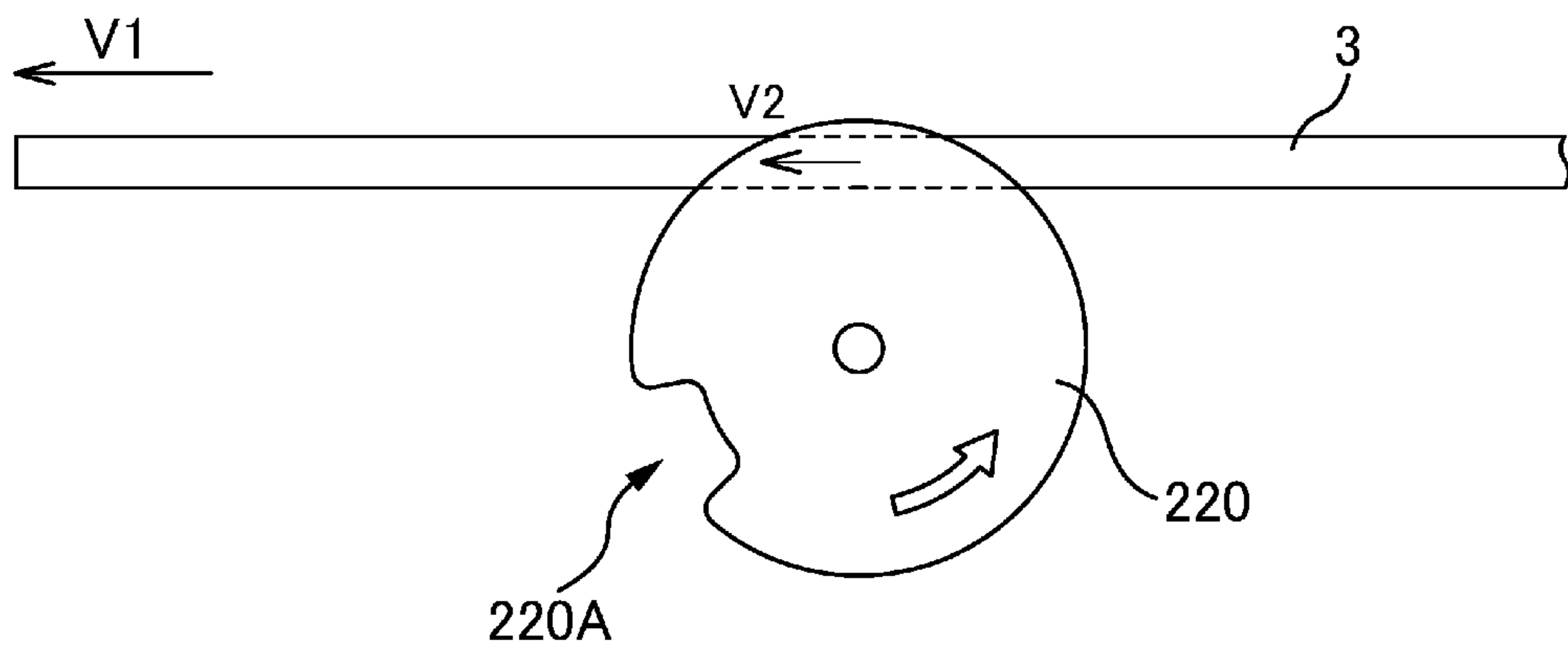


図2B

[図3]



[図4]

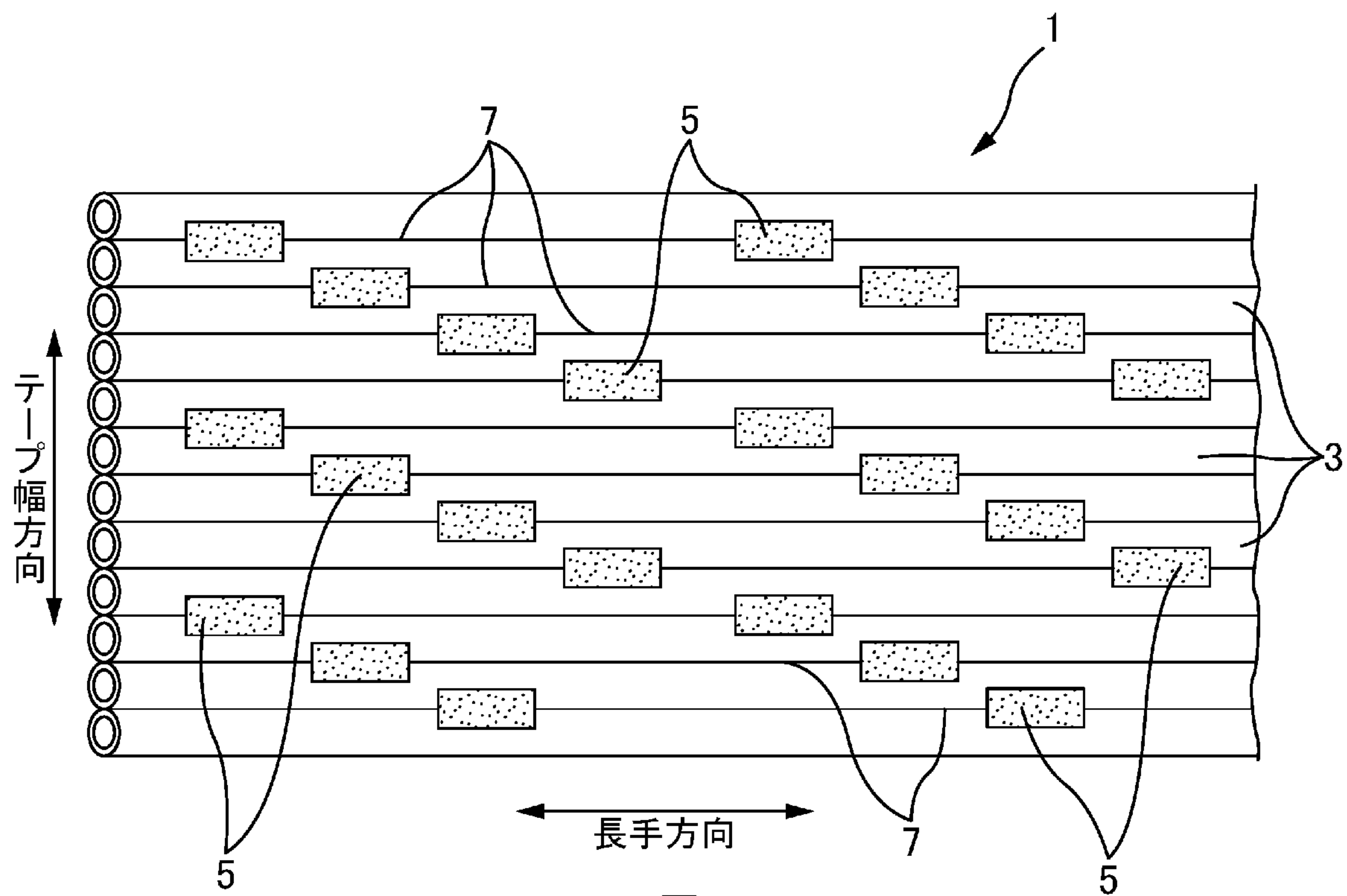


図4A

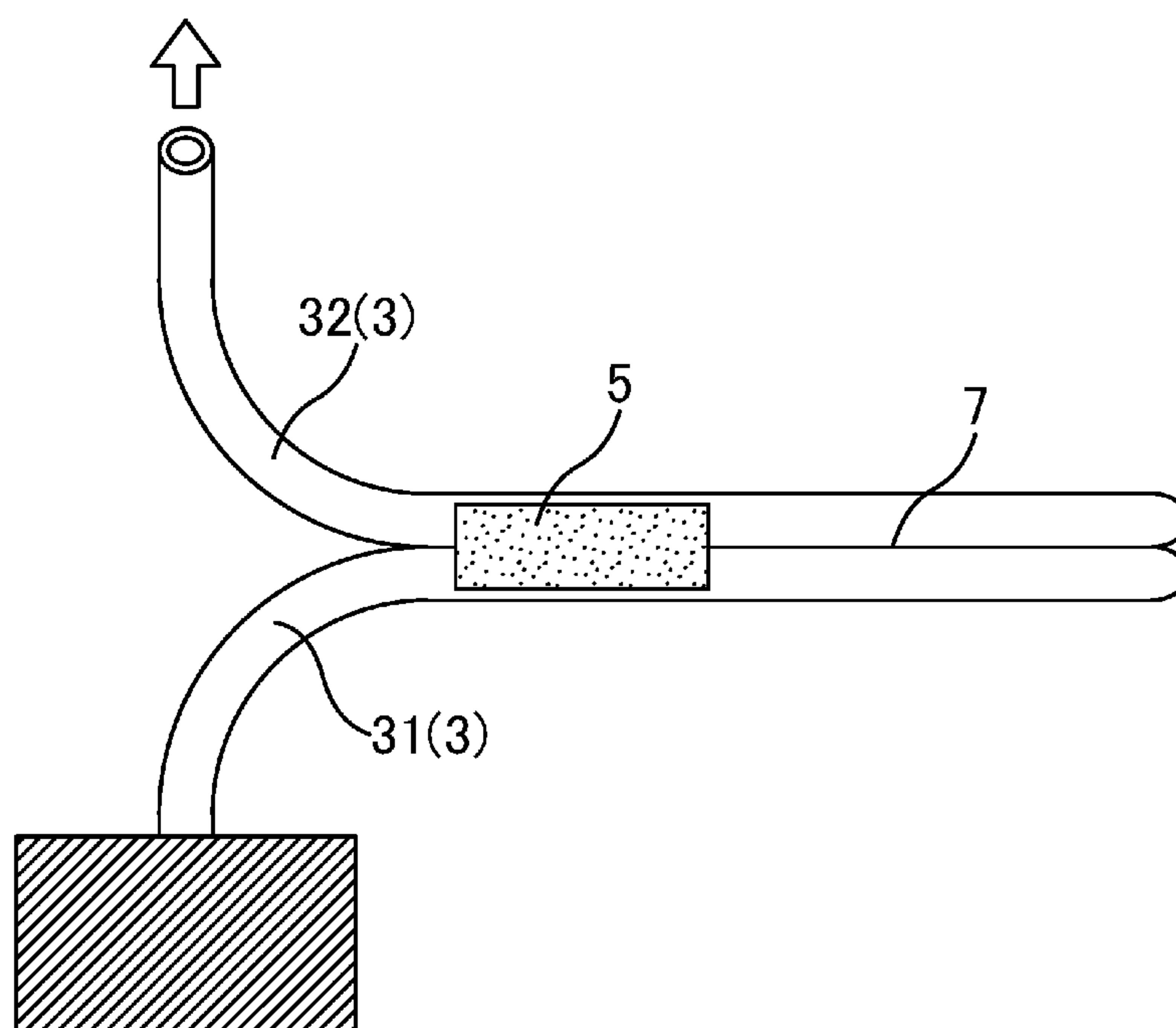


図4B

[図5]

光ファイバ心線 送り出し速度V1 [m/min]	回転体 移動速度V2 [m/min]	速度比 (V1:V2)	樹脂の最小厚さd [μm]	引裂き試験 [gf]			しごき試験 連結部の破損の有無	判定
				最大値	最小値	平均値		
150.0	282.6	0.5:1	4.3	0.4	0.1	0.3	有	×
300.0	282.6	1.1:1	3.5	0.9	0.5	0.7	有	×
400.0	188.4	2.1:1	4.9	1.8	1.3	1.2	有	×
600.0	207.3	2.9:1	6.8	3.9	2.1	3.1	無	○
600.0	141.3	4.2:1	7.6	8.8	4.1	5.4	無	○
900.0	150.9	6.0:1	10.2	8.6	3.0	5.4	無	○
900.0	113.1	8.0:1	8.8	11.8	4.3	7.3	無	○

図5A

光ファイバ心線 送り出し速度V1 [m/min]	回転体 移動速度V2 [m/min]	速度比 (V1:V2)	樹脂の最小厚さd [μm]	線長差 [%]			しごき試験 連結部の破損の有無	判定
				最大値	最小値	平均値		
450.0	45.3	9.9:1	9.5	0.01	-0.02	0.01	無	○
900.0	59.4	15.2:1	10.1	0.01	-0.01	0.00	無	○
400.0	19.2	20.8:1	8.9	0.01	-0.03	0.01	無	○
400.0	15.6	25.6:1	7.6	0.03	-0.02	0.02	無	○
900.0	30.3	29.7:1	11.1	0.04	-0.01	0.02	無	○
600.0	17.1	35.1:1	7.8	0.02	-0.03	0.02	無	○
600.0	15.0	40.0:1	8.2	0.13	-0.01	0.08	無	×
600.0	13.2	45.5:1	9.0	0.12	-0.03	0.09	無	×

図5B

[図6]

速度比 (V1:V2)	引裂き試験 [gf]			しごき試験	判定
	最大値	最小値	平均値	連結部の破損の有無	
1.1:1	1.3	0.7	1.0	有	×
2.1:1	1.5	0.9	1.3	有	×
2.9:1	3.5	2.0	2.8	無	○
4.2:1	6.7	3.7	4.9	無	○

[図7]

直径5mm、厚さ80 μ mの回転体の場合

速度比 (V1:V2)	樹脂の最小厚さ d [μm]	引裂き試験 [gf]			しごき試験	判定
		最大値	最小値	平均値	連結部の破損の有無	
1.1:1	2.5	1.3	0.4	0.8	有	×
2.1:1	3.1	1.8	0.9	1.4	有	×
2.9:1	7.3	5.0	4.4	4.8	無	○
4.2:1	8.1	5.6	3.8	4.2	無	○

図7A

直径25mm、厚さ80 μ mの回転体の場合

速度比 (V1:V2)	樹脂の最小厚さ d [μm]	引裂き試験 [gf]			しごき試験	判定
		最大値	最小値	平均値	連結部の破損の有無	
1.1:1	2.7	0.9	0.3	0.5	有	×
2.1:1	4.2	2.0	0.9	1.5	有	×
2.9:1	6.5	3.1	2.3	2.7	無	○
4.2:1	6.6	5.4	4.5	4.9	無	○

図7B

[図8]

直径15mm、厚さ20 μ mの回転体の場合

速度比 (V1:V2)	樹脂の最小厚さ d [μ m]	引裂き試験 [gf]			しごき試験	判定
		最大値	最小値	平均値	連結部の破損の有無	
1.1:1	1.8	1.2	0.9	1.1	有	×
2.1:1	4.5	1.5	0.9	1.2	有	×
2.9:1	7.7	4.8	2.7	3.3	無	○
4.2:1	6.4	8.4	3.2	4.1	無	○

図8A

直径15mm、厚さ50 μ mの回転体の場合

速度比 (V1:V2)	樹脂の最小厚さ d [μ m]	引裂き試験 [gf]			しごき試験	判定
		最大値	最小値	平均値	連結部の破損の有無	
1.1:1	3.6	1.4	0.5	0.7	有	×
2.1:1	4.1	2.3	1.1	1.6	有	×
2.9:1	6.5	5.7	2.6	3.0	無	○
4.2:1	8.4	7.1	3.1	4.3	無	○

図8B

直径15mm、厚さ110 μ mの回転体の場合

速度比 (V1:V2)	樹脂の最小厚さ d [μ m]	引裂き試験 [gf]			しごき試験	判定
		最大値	最小値	平均値	連結部の破損の有無	
1.1:1	2.4	1.2	0.6	1.0	有	×
2.1:1	3.8	1.9	0.5	1.2	有	×
2.9:1	7.1	6.4	3.5	4.7	無	○
4.2:1	7.8	8.1	4.3	5.5	無	○

図8C

