



HU000029732T2

(19) **HU****MAGYARORSZÁG**
Szellemi Tulajdon Nemzeti Hivatala(11) Lajstromszám: **E 029 732**(13) **T2****EURÓPAI SZABADALOM**
SZÖVEGÉNEK FORDÍTÁSA(21) Magyar ügyszám: **E 13 174916**(51) Int. Cl.: **B26B 19/28** (2006.01)(22) A bejelentés napja: **2013. 07. 03.**

(96) Az európai bejelentés bejelentési száma:

EP 20130174916

(97) Az európai bejelentés közzétételi adatai:

EP 2689901 A1 **2014. 01. 29.**

(97) Az európai szabadalom megadásának meghirdetési adatai:

EP 2689901 B1 **2016. 04. 06.**

(30) Elsőbbségi adatok:

201213555514 **2012. 07. 23.** **US**

(73) Jogosult(ak):

Andis Company, Sturtevant, WI 53177 (US)

(72) Feltaláló(k):

Gilbert, Steven J, Menomonee Falls, Wisconsin 53051 (US)

(74) Képviselő:

Sworks Nemzetközi Szabadalmi Ügyvivői Iroda Kft., Budapest

(54)

Meghajtótág hajvágó számára

Az európai szabadalom ellen, megadásának az Európai Szabadalmi Közlönyben való meghirdetésétől számított kilenc hónapon belül, felszólalást lehet benyújtani az Európai Szabadalmi Hivatalnál. (Európai Szabadalmi Egyezmény 99. cikk(1))

A fordítást a szabadalmas az 1995. évi XXXIII. törvény 84/H. §-a szerint nyújtotta be. A fordítás tartalmi helyességét a Szellemi Tulajdon Nemzeti Hivatala nem vizsgálta.



(11) **EP 2 689 901 B1**

(12) **EUROPEAN PATENT SPECIFICATION**

(45) Date of publication and mention
of the grant of the patent:
06.04.2016 Bulletin 2016/14

(51) Int Cl.:
B26B 19/28 (2006.01)

(21) Application number: **13174916.0**

(22) Date of filing: **03.07.2013**

(54) **Drive member for hair trimmer**

Antriebsselement für Haarschneidegerät

Élément d'entraînement pour tondeuse à cheveux

(84) Designated Contracting States:
**AL AT BE BG CH CY CZ DE DK EE ES FI FR GB
GR HR HU IE IS IT LI LT LU LV MC MK MT NL NO
PL PT RO RS SE SI SK SM TR**

(30) Priority: **23.07.2012 US 201213555514**

(43) Date of publication of application:
29.01.2014 Bulletin 2014/05

(73) Proprietor: **Andis Company
Sturtevant, WI 53177 (US)**

(72) Inventor: **Gilbert, Steven J
Menomonee Falls, Wisconsin 53051 (US)**

(74) Representative: **Roberts, Peter David
Marks & Clerk LLP
1 New York Street
Manchester, M1 4HD (GB)**

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EP 2 689 901 B1

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Description

BACKGROUND

[0001] The present invention relates to a drive member for a hair trimmer and a method for manufacturing the same

[0002] US5325590 discloses a hair trimmer according to the preamble of claim 1.

SUMMARY

[0003] In one embodiment, the invention provides a trimmer comprising: a trimmer body; a rotary drive within the body; a cutting head assembly interconnected with the trimmer body; and a drive operably interconnecting the rotary drive and the cutting head assembly, to transfer rotary movement of the rotary drive into oscillation of a portion of the cutting head assembly with respect to another portion of the cutting head assembly, the drive including an injection molded transmission and an injection molded hinge; wherein the transmission includes a cam follower that is driven by the rotary drive, and a drive lever that engages a portion of the cutting head assembly; wherein the hinge includes a mounting structure for mounting the drive to the trimmer body and a plurality of webs supporting the transmission for oscillatory movement; and wherein one of the transmission and hinge is injection molded over a portion of the other to mechanically bond the transmission and hinge.

[0004] In some embodiments, the hinge and transmission are constructed of materials having the substantially the same melting temperature, allowing the hinge and transmission to be molded at the same mold temperature. In some embodiments, the hinge is made of polypropylene and the transmission is made of glass-filled polypropylene. In some embodiments, the hinge and transmission are molded in the same mold at a temperature of about 54°C (130°F).

[0005] The invention also provides a method of manufacturing a drive for use in a trimmer that includes a rotary drive and a cutting head assembly, the drive transmitting rotary motion from the rotary drive into reciprocation of a portion of the cutting head assembly, the method comprising: injection molding a transmission within an injection molding die; injection molding a hinge within the same injection molding die; and mechanically bonding the transmission and hinge by injection molding one of the transmission and hinge over a portion of the other.

[0006] In some embodiments, the step of injection molding the transmission includes injection molding the transmission at a first mold temperature within the die; and wherein injection molding the hinge includes injection molding the hinge substantially at the first mold temperature. In some embodiments, injection molding the transmission includes injection molding a first material to form the transmission; and injection molding the hinge includes injection molding a second material to form the

hinge, the second material being different from the first material but having a substantially similar melting temperature. In some embodiments, injection molding the transmission includes injection molding glass-filled polypropylene to form the transmission; and injection molding the hinge includes injection molding polypropylene to form the hinge. In some embodiments, both injection molding the transmission and injection molding the hinge include holding the mold temperature at about 54 °C (130 °F).

[0007] Other aspects of the invention will become apparent by consideration of the detailed description and accompanying drawings.

BRIEF DESCRIPTION OF THE DRAWINGS

[0008]

FIG. 1 is a side elevation view of an electric hair trimmer embodying the invention.

FIG. 2 is a top view of a drive for the trimmer.

FIG. 3 is a perspective view of a hinge portion of the drive.

FIG. 4 is another perspective view of the hinge portion.

FIG. 5 is a perspective view of a transmission portion of the drive.

FIG. 6 is another perspective view of the transmission.

DETAILED DESCRIPTION

[0009] Before any embodiments of the invention are explained in detail, it is to be understood that the invention is not limited in its application to the details of construction and the arrangement of components set forth in the following description or illustrated in the following drawings. The invention is capable of other embodiments and of being practiced or of being carried out in various ways.

[0010] The present invention provides a drive member for a hair trimmer. The drive member can replace known drive members, such as that disclosed in U.S. Patent No. 5,325,590.

[0011] Fig. 1 is taken from U.S. Patent No. 5,325,590, and illustrates an electric hair trimmer 10 having an easily hand-held body 14. Preferably, the body 14 is made of a lightweight, rigid plastic and is generally hollow. The trimmer 10 includes a cutting head assembly 18 that is fixed to the body 14 by a fastener. The invention can also be applied to trimmers having a removable cutting head assembly 18. U.S. Pat. No. 5,092,048, which issued on Mar. 3, 1992 to Sukow et al., illustrates one such removable cutting head assembly. The cutting head assembly

18 includes a lower plate 22 and an upper plate or cutter 26 which is supported on the lower plate 22 and which is movable with respect to the lower plate 22. The cutter 26 defines a drive socket which receives a reciprocating or oscillating drive mechanism.

[0012] The trimmer 10 also includes rotary drive means housed by the body 14 for reciprocating the cutter 26. While various constructions could be successfully employed, the illustrated rotary drive includes an electric motor 38 which is housed by the trimmer body 14 and which is operably connected to a suitable source of electric current 42. In Fig. 1, the source of current 42 is schematically represented by a battery. However, the electric motor 38 could also be connected by an electric cord extending from the body 14 to a suitable source of power. A user operable thumb switch 46 for turning the electric motor 38 "on" and "off" extends from the trimmer body 14. The rotary drive also includes a front motor frame 50 and a rear motor frame 54, each of which are fixed respectively to the front and rear ends of the electric motor 38 and which are fixed to the body 14. The front motor frame 50 secures the electric motor 38 to the body 14.

[0013] Fig. 2 illustrates a drive member 110 which interconnects the rotary drive to the cutting head assembly 18. The drive member 110 includes two parts: a hinge 120 and a transmission 130. The hinge 120 mounts to the trimmer body 14. A rear portion of the transmission 130 is engaged by the rotary drive and a front portion of the transmission 130 is interconnected with the cutter 26. The transmission 130 transfers reciprocating movement from the rotary drive to the cutter 26 to create an oscillating, shearing action between the cutter and the lower plate 22. The transmission 130 is supported for such reciprocating movement by the hinge 120.

[0014] Both the hinge 120 and the transmission 130 are injection-molded components. Each of the hinge 120 and transmission 130 are formed with a single injection-molding shot. In the manufacturing process, the transmission 130 is formed with a first injection-molding shot and the hinge 120 is injection molded over the transmission 130 with a second injection-molding shot. As a result, portions of the hinge 120 take their shape as a result of molding around portions of the transmission 130. Both parts 120, 130 include various portions which are illustrated in the drawings and which will be described below. All portions of the hinge 120 are injection molded integrally with the other portions of the hinge 120, and all portions of the transmission 130 are injection molded integrally with the other portions of the transmission 130. The drive member 110 as a whole, as well as the hinge 120 and transmission 130 as separate parts, is symmetrical about a vertical plane that contains an axis of symmetry 135.

[0015] With reference to Figs. 3 and 4, the hinge 120 includes a cross-bar 140, a window frame 160 depending from the cross-bar 140, a window 170 defined within the window frame 160, a left side support 180, and a right side support 190. The cross-bar 140 includes a pair of

vertical slots 195, one at each of the left and right ends. The left and right side supports 180, 190 are mirror images of each other. Each side support 180, 190 includes a z-shaped mounting structure 210, a first base plate 220, a second base plate 230, and four webs 240 extending between the first and second base plates 220, 230.

[0016] The z-shaped mounting structure 210 includes an upper flange 250 and a lower flange 260. The upper flange 250 includes a hole 270 and the lower flange includes a hole 280. When installed on the body of the hair trimmer, a pair of rigid posts extend into the holes 280 in the right and left mounting structures 210 and a pair fasteners extend through the holes 270 and are threaded into a threaded hole in the body of the trimmer, to secure the hinge 120 to the body.

[0017] The four webs 240 are parallel to each other, with space in between. Each end of the webs 240 (i.e., where each web 240 joins to one of the base plates 220, 230) includes a thin neck 290 to facilitate side-to-side pivoting of the cross-bar 140 and base members 230 with respect to the base members 220.

[0018] Referring to Figs. 5 and 6, the transmission 130 includes a front plate 340, a left anchor 350, a right anchor 360, a rear plate 370, a bridge 380, a drive lever 390, and a cam follower 400. The left and right anchors 350, 360 extend rearward of the front plate 340 near the left and right ends, and define forward-facing shoulders 410 that face back to the front plate 340. The left and right anchors 350, 360 may be termed "T-shaped" because their cross-sections are so shaped. The bridge 380 interconnects the front and rear plates 340, 370, and defines a pair of apertures 420. The drive lever 390 extends forward and down from the front plate 340 and engages the cutter 26 of the cutting head assembly 18 of the trimmer 10.

[0019] The cam follower 400 includes a pair of cam walls 430 extending rearward from the rear plate 370. Each cam wall 430 defines a cam follower surface 440. The cam follower surfaces 440 define between them a vertical slot. The cam follower 400 receives a cam that is eccentrically-mounted on an output shaft of the electric motor 38. As the motor shaft rotates, the cam member orbits the axis of rotation of the motor shaft. The orbital movement of the cam is translated into left and right movement of the drive member 110 by the cam bearing on the cam follower surfaces 440. Left and right movement of the drive member 110 is imparted to the cutting head assembly 18 through the drive lever 390, which results in a shearing action in the cutting head assembly 18.

[0020] The drive member 110 is manufactured by first injection molding the transmission 130 within an injection molding die in a first shot. The hinge 120 is then injection molded over the transmission 130 in a second shot within the same injection molding die. As the hinge 120 is injection molded, the cross-bar 140 of the hinge molds around the left anchor 350, right and anchor 360, and

bridge 380 of the transmission 130. The window frame 160 extends through the apertures 420 in the bridge 380, such that the center portion of the bridge 380 extends through the window 170. The vertical slots 195 in the hinge 120 are formed around the anchors 350, 360. The shoulders 410 of the anchors 350, 360 are completely covered with plastic of the cross-bar 140. Overmolding the hinge 120 on the transmission 130 mechanically bonds the two components to obviate the multipiece assembly and manufacturing process of known drives.

[0021] Material selection for the hinge 120 and transmission 130 involves selecting materials that have good flexibility and fatigue resistance for the hinge 120 and relatively high strength and rigidity for the transmission 130. At the same time, the materials should have substantially similar melting points so that they can be molded in the same die at the same mold temperature. In a preferred embodiment, the hinge 120 is made of polypropylene, which is a good material for living hinges, and the transmission 130 is made of glass-filled polypropylene. Polypropylene and glass-filled polypropylene are made from the same resin or a very similar resin, and have a similar melting temperature of about 232°C (450°F). In one example, a mold temperature of a approximately 54°C (130°F) can be used for both polypropylene and glass-filled polypropylene. But glass-filled polypropylene is stiffer than polypropylene and therefore suitable for use as the transmission 130.

[0022] Thus, the invention provides, among other things, a drive member for a trimmer, the drive member including a hinge and a transmission that are created through a two-shot injection molding process. Various features and advantages of the invention are set forth in the following claims.

Claims

1. A trimmer (10) comprising:

a trimmer body (14);
a rotary drive (38, 42, 50, 54) within the body (14);
a cutting head assembly (18) interconnected with the trimmer body (14); and
a drive (110) operably interconnecting the rotary drive (38, 42, 50, 54) and the cutting head assembly (18), to transfer rotary movement of the rotary drive (38, 42, 50, 54) into oscillation of a portion of the cutting head assembly (18) with respect to another portion of the cutting head assembly (18), the drive (110) including an injection molded transmission (130) and an injection molded hinge (120);

wherein the transmission (130) includes a cam follower (400) that is driven by the rotary drive (38, 42, 50, 54), and a drive lever (390) that engages a portion

of the cutting head assembly (18);

wherein the hinge (120) includes a mounting structure (210) for mounting the drive (110) to the trimmer body (14) and a plurality of webs (240) supporting the transmission (130) for oscillatory movement;

characterized in that

one of the transmission (130) and hinge (120) is injection molded over a portion of the other to mechanically bond the transmission (130) and hinge (120).

2. The trimmer of claim 1, wherein the hinge (120) and transmission (130) are constructed of materials having the substantially the same melting temperature, allowing the hinge (120) and transmission (130) to be molded at the same mold temperature.

3. The trimmer of claim 1, wherein the hinge (120) is made of polypropylene and the transmission (130) is made of glass-filled polypropylene.

4. The trimmer of claim 3, wherein the hinge (120) and transmission (130) are molded in the same mold at a temperature of about 54°C (130°F).

5. A method of manufacturing a drive (110) for use in a trimmer (10) that includes a rotary drive (38, 42, 50, 54) and a cutting head assembly (18), the drive (110) transmitting rotary motion from the rotary drive (38, 42, 50, 54) into reciprocation of a portion of the cutting head assembly (18), the method comprising:

injection molding a transmission (130) within an injection molding die;
injection molding a hinge (120) within the same injection molding die; and
mechanically bonding the transmission (130) and hinge (120) by injection molding one of the transmission (130) and hinge (120) over a portion of the other.

6. The method of claim 5, wherein injection molding the transmission (130) includes injection molding the transmission (130) at a first mold temperature within the die; and wherein injection molding the hinge (120) includes injection molding the hinge (120) substantially at the first mold temperature.

7. The method of claim 5, wherein injection molding the transmission (130) includes injection molding a first material to form the transmission (130); and wherein injection molding the hinge (120) includes injection molding a second material to form the hinge (120), the second material being different from the first material but having a substantially similar melting temperature.

8. The method of claim 5, wherein injection molding the transmission (130) includes injection molding glass-

filled polypropylene to form the transmission (130); and wherein injection molding the hinge (120) includes injection molding polypropylene to form the hinge (120).

9. The method of claim 8, wherein both injection molding the transmission (130) and injection molding the hinge (120) including holding the mold temperature at about 54°C (130°F).

Patentansprüche

1. Haarschneidegerät (10), das aufweist:

einen Haarschneidegerätekörper (14);
einen Rotationsantrieb (38, 42, 50, 54) innerhalb des Körpers (14);
eine Schneidkopfbaugruppe (18), die mit dem Haarschneidegerätekörper (14) verbunden ist; und
einen Antrieb (110), der funktionell den Rotationsantrieb (38, 42, 50, 54) und die Schneidkopfbaugruppe (18) miteinander verbindet, um eine Rotationsbewegung des Rotationsantriebes (38, 42, 50, 54) in eine Schwingung eines Abschnittes der Schneidkopfbaugruppe (18) mit Bezugnahme zu einem anderen Abschnitt der Schneidkopfbaugruppe (18) zu übertragen, wobei der Antrieb (110) eine spritzgegossene Transmission (130) und ein spritzgegossenes Scharnier (120) umfasst;

wobei die Transmission (130) einen Nockenstößel (400), der vom Rotationsantrieb (38, 42, 50, 54) angetrieben wird, und einen Antriebshebel (390) umfasst, der mit einem Abschnitt der Schneidkopfbaugruppe (18) in Eingriff kommt,

wobei das Scharnier (120) eine Montagestruktur (210) für das Montieren des Antriebs (110) am Haarschneidegerätekörper (14) und eine Vielzahl von Stegen (240) umfasst, die die Transmission (130) für eine Schwingbewegung tragen,

dadurch gekennzeichnet, dass

eines von Transmission (130) und Scharnier (120) über einen Abschnitt des anderen spritzgegossen wird, um die Transmission (130) und das Scharnier (120) mechanisch zu verbinden.

2. Haarschneidegerät nach Anspruch 1, bei dem das Scharnier (120) und die Transmission (130) aus Materialien mit im Wesentlichen der gleichen Schmelztemperatur konstruiert werden, wodurch gestattet wird, dass das Scharnier (120) und die Transmission (130) mit der gleichen Formtemperatur geformt werden können.

3. Haarschneidegerät nach Anspruch 1, bei dem das

Scharnier (120) aus Polypropylen und die Transmission (130) aus glasfaserverstärktem Polypropylen hergestellt wird.

4. Haarschneidegerät nach Anspruch 3, bei dem das Scharnier (120) und die Transmission (130) in der gleichen Form bei einer Temperatur von etwa 54 °C (130 °F) geformt werden.

5. Verfahren zur Herstellung eines Antriebs (110) für eine Verwendung in einem Haarschneidegerät (10), das einen Rotationsantrieb (38, 42, 50, 54) und eine Schneidkopfbaugruppe (18) umfasst, wobei der Antrieb (110) die Rotationsbewegung vom Rotationsantrieb (38, 42, 50, 54) in eine Hin- und Herbewegung eines Abschnittes der Schneidkopfbaugruppe (18) überträgt, wobei das Verfahren die folgenden Schritte aufweist:

Spritzgießen einer Transmission (130) innerhalb eines Spritzgießwerkzeuges;
Spritzgießen eines Scharniers (120) innerhalb des gleichen Spritzgießwerkzeuges; und
mechanisches Verbinden der Transmission (130) und des Scharniers (120) durch Spritzgießen von einem von Transmission (130) und Scharnier (120) über einen Abschnitt des anderen.

6. Verfahren nach Anspruch 5, bei dem der Schritt des Spritzgießens der Transmission (130) das Spritzgießen der Transmission (130) bei einer ersten Formtemperatur innerhalb des Werkzeuges umfasst; und bei dem der Schritt des Spritzgießens des Scharniers (120) das Spritzgießen des Scharniers (120) im Wesentlichen bei der ersten Formtemperatur umfasst.

7. Verfahren nach Anspruch 5, bei dem der Schritt des Spritzgießens der Transmission (130) das Spritzgießen eines ersten Materials umfasst, um die Transmission (130) herzustellen; und bei dem der Schritt des Spritzgießens des Scharniers (120) das Spritzgießen eines zweiten Materials umfasst, um das Scharnier (120) herzustellen, wobei das zweite Material vom ersten Material abweicht, aber eine im Wesentlichen gleiche Schmelztemperatur aufweist.

8. Verfahren nach Anspruch 5, bei dem der Schritt des Spritzgießens der Transmission (130) das Spritzgießen von glasfaserverstärktem Polypropylen umfasst, um die Transmission (130) herzustellen; und bei dem der Schritt des Spritzgießens des Scharniers (120) das Spritzgießen von Polypropylen umfasst, um das Scharnier (120) herzustellen.

9. Verfahren nach Anspruch 8, bei dem sowohl der Schritt des Spritzgießens der Transmission (130) als

auch der Schritt des Spritzgießens des Scharniers (120) das Halten der Formtemperatur bei etwa 54 °C (130 °F) umfasst.

Revendications

1. Tondeuse (10), comprenant :

un corps de tondeuse (14) ;
un entraînement rotatif (38, 42, 50, 54) à l'intérieur du corps ;
un assemblage de tête de coupe (18) interconnecté avec le corps de la tondeuse (14) ; et
un entraînement (110), assurant en service l'interconnexion de l'entraînement rotatif (38, 42, 50, 54) et de l'assemblage de tête de coupe (18) pour transférer le mouvement rotatif de l'entraînement rotatif (38, 42, 50, 54) en une oscillation d'une partie de l'assemblage de tête de coupe (18) par rapport à une autre partie de l'assemblage de tête de coupe (18), l'entraînement (110) englobant une transmission moulée par injection (130) et une charnière moulée par injection (120) ;

dans laquelle la transmission (130) inclut un galet de came (400) entraîné par l'entraînement rotatif (38, 42, 50, 54), et un levier d'entraînement (390) s'engageant dans une partie de l'assemblage de tête de coupe (18) ;

dans laquelle la charnière (120) inclut une structure de montage (210) pour monter l'entraînement (110) sur le corps de la tondeuse (14) et plusieurs bandes (240) supportant la transmission (130) en vue d'un mouvement oscillatoire ; **caractérisée en ce que** un élément, la transmission (130) ou la charnière (120), est moulé par injection au-dessus d'une partie de l'autre élément pour relier mécaniquement la transmission (130) et la charnière (120).

2. Tondeuse selon la revendication 1, dans laquelle la charnière (120) et la transmission (130) sont construites à partir de matériaux présentant substantiellement la même température de fusion, permettant le moulage de la charnière (120) et de la transmission (130) à la même température de moulage.

3. Tondeuse selon la revendication 1, dans laquelle la charnière (120) est fabriquée à partir de polypropylène, la transmission (130) étant fabriquée à partir de polypropylène armé de verre.

4. Tondeuse selon la revendication 3, dans laquelle la charnière (120) et la transmission (130) sont moulées dans le même moule à une température d'environ 54°C (130°F).

5. Procédé de fabrication d'un entraînement (110) destiné à être utilisé dans une tondeuse (10) englobant un entraînement rotatif (38, 42, 50, 54) et un assemblage de tête de coupe (18), l'entraînement (110) transmettant le mouvement de rotation de l'entraînement rotatif (38, 42, 50, 54) en un mouvement alternatif d'une partie de l'assemblage de tête de coupe (18), le procédé comprenant les étapes ci-dessous :

moulage par injection d'une transmission (130) dans une filière de moulage par injection ;
moulage par injection d'une charnière (120) dans la même filière de moulage par injection ; et
liaison mécanique de la transmission (130) et de la charnière (120) en moulant par injection un élément, la transmission (130) ou la charnière (120) au-dessus d'une partie de l'autre élément.

6. Procédé selon la revendication 5, dans lequel l'étape de moulage par injection de la transmission (130) inclut le moulage par injection de la transmission (130) à une première température de moulage dans la filière ; et dans lequel le moulage par injection de la charnière (120) inclut le moulage par injection de la charnière (120) substantiellement à la première température de moulage.

7. Procédé selon la revendication 5, dans lequel l'étape de moulage par injection de la transmission (130) inclut le moulage par injection d'un premier matériau pour former la transmission (130) ; et dans lequel le moulage par injection de la charnière (120) inclut le moulage par injection d'un deuxième matériau pour former la charnière (120), le deuxième matériau étant différent du premier matériau mais présentant une température de fusion substantiellement similaire.

8. Procédé selon la revendication 5, dans lequel le moulage par injection de la transmission (130) inclut le moulage par injection de polypropylène chargé de verre pour former la transmission (130) ; et dans lequel le moulage par injection de la charnière (120) inclut le moulage par injection de polypropylène pour former la charnière (120).

9. Procédé selon la revendication 8, dans lequel le moulage par injection de la transmission (130) et le moulage par injection de la charnière (120) incluent le maintien de la température de moulage à environ 54°C (130°F).

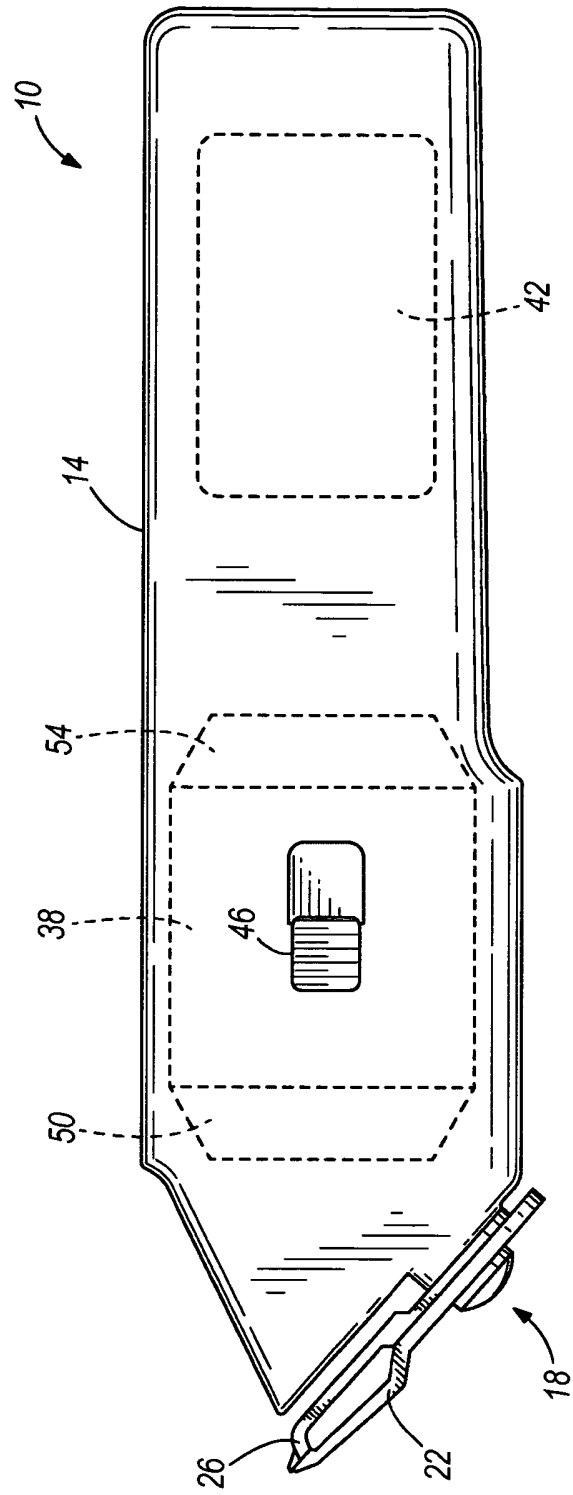


FIG. 1
PRIOR ART

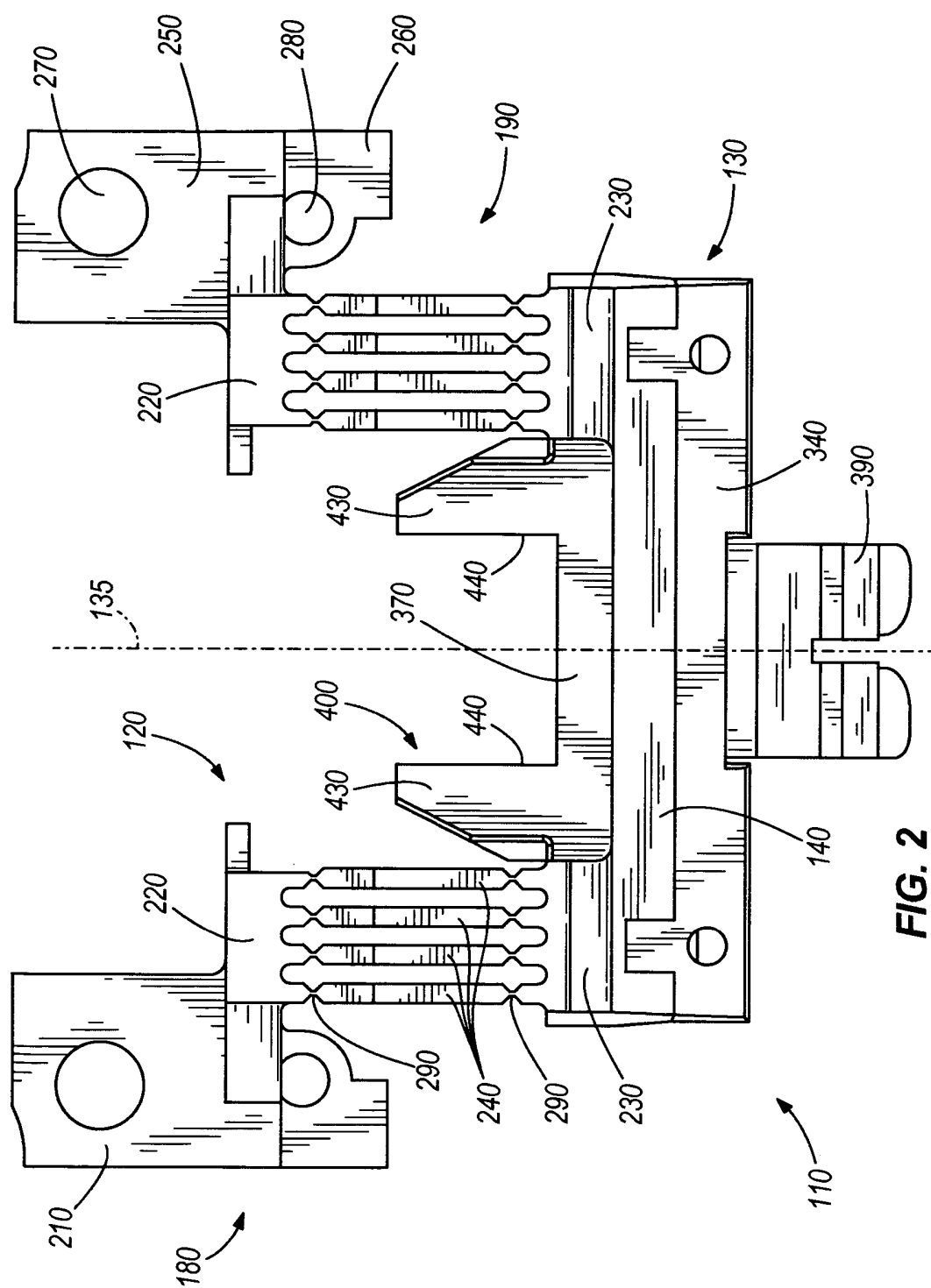
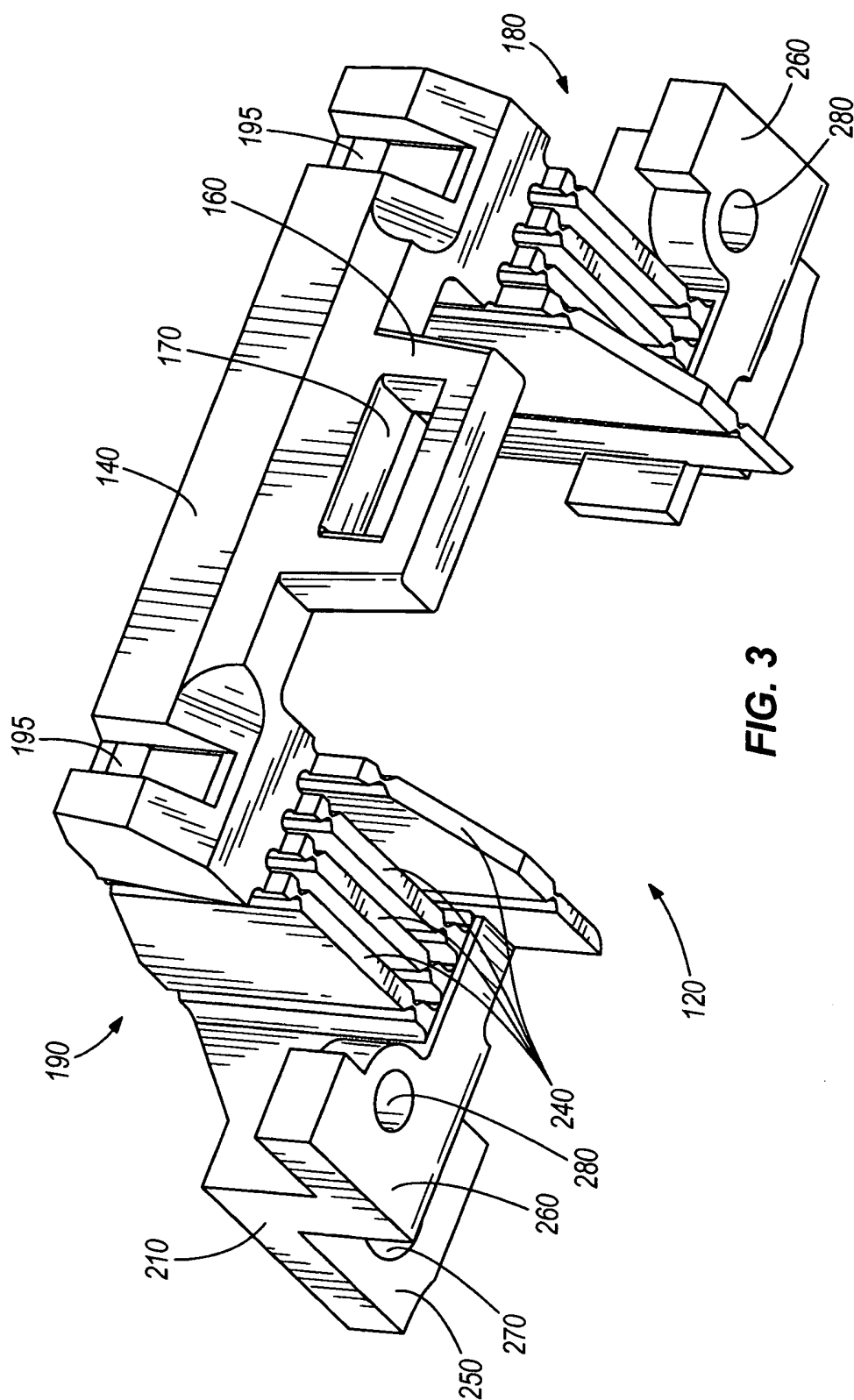
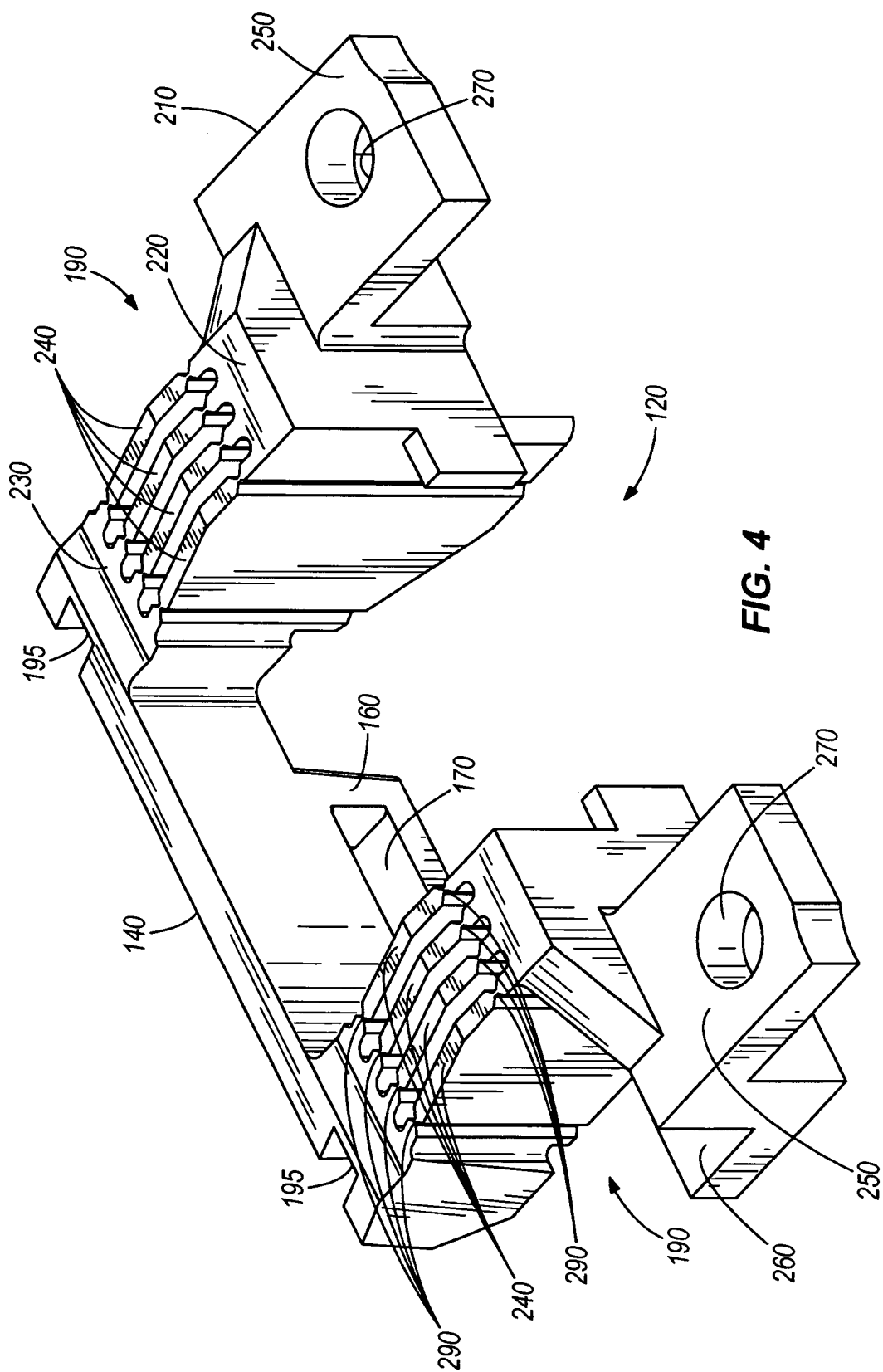
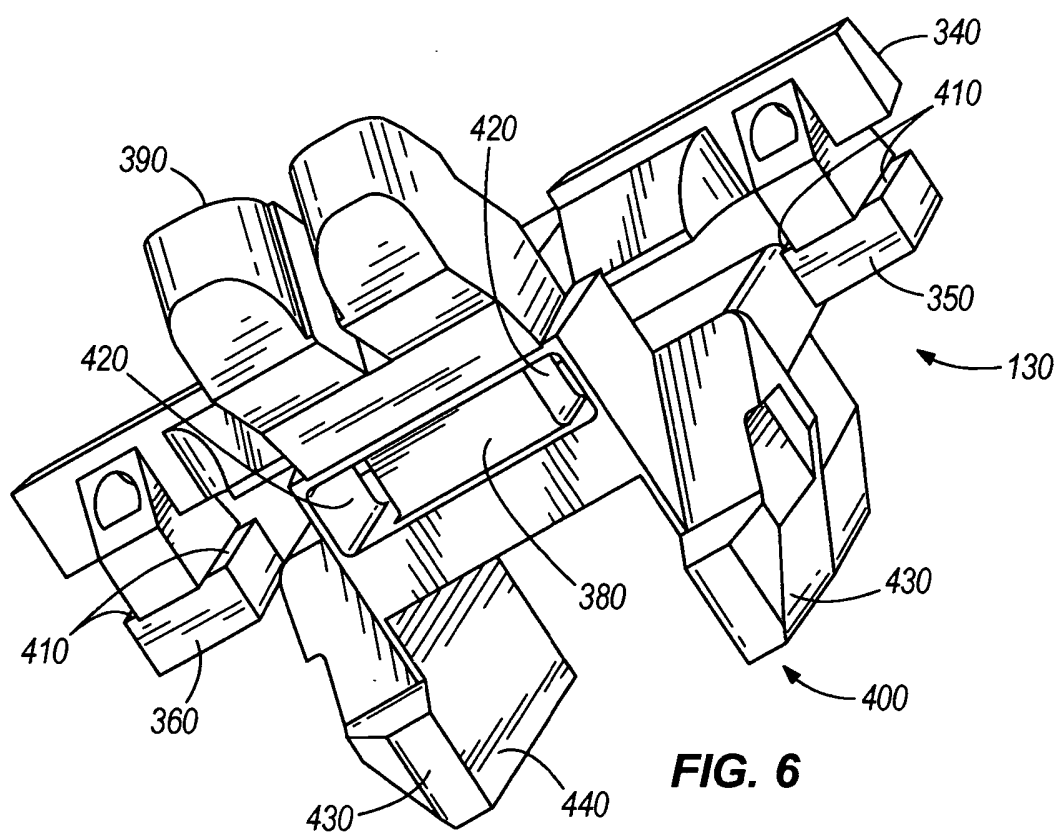
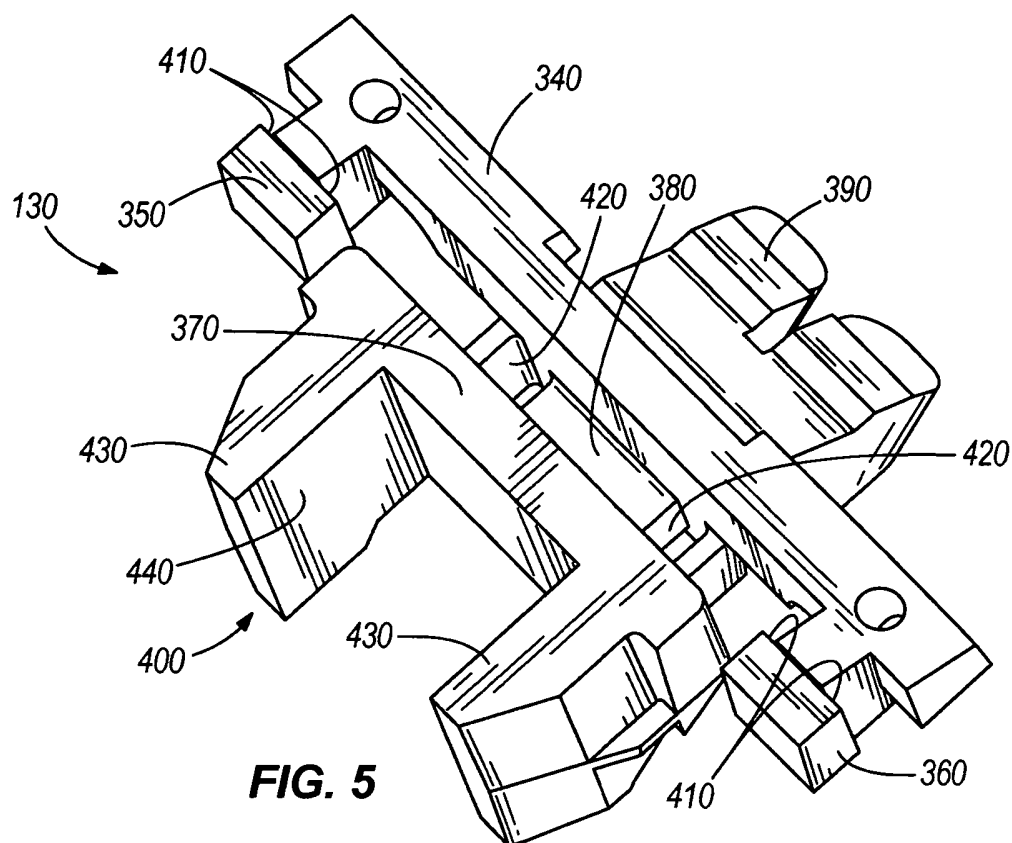


FIG. 2







REFERENCES CITED IN THE DESCRIPTION

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Patent documents cited in the description

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- US 5092048 A, Sukow [0011]

Szabadalmi igénypontok

1. Hajvágó (10), amely tartalmaz:
 - hajvágó testet (14);
 - forgó meghajtást (38, 42, 50, 54) a testen (14) belül;
 - 5 vágófej egységet (18), amely össze van kötve a hajvágó testtel (14); és
 - meghajtást (110, amely funkcionálisan összeköti a forgó meghajtást (38, 42, 50, 54) és a vágófej egységet (18), hogy átvigye a forgó meghajtás (38, 42, 50, 54) forgó mozgását a vágófej egység (18) egy részének rezgésébe a vágófej egység (18) egy másik részéhez vonatkoztatva, a meghajtás (110) tartalmaz fröccsöntött átvitelt (130) és fröccsöntött forgópántot (120);
- 10 ahol az átvitel (130) tartalmaz bűtykös emelőt (400), amely a forgó meghajtás (38, 42, 50, 54) által van meghajtva, és meghajtó emelőt (390), amely a vágófej egység (18) egy részéhez kapcsolódik;
- ahol a forgópánt (120) tartalmaz szerelőszerkezetet (210) a meghajtás (110) a hajvágó testhez (14) szerelésére és több szalagot (240), amelyek megtámasztják az átvitelt (130) rezgő mozgásba; azzal jellemezve, hogy
- 15 az átvitel (130) és forgópánt (120) egyike fröccsöntve van a másik egy része felett, hogy mechanikusan összekötse az átvitelt (130) és forgópántot (120).
2. Az 1. igénypont szerinti hajvágó, ahol a forgópánt (120) és átvitel (130) olyan anyagokból vannak konstruálva, amelyeknek lényegében ugyanaz az olvadási hőmérséklete, lehetővé téve, hogy a forgópánt (120) és átvitel (130) ugyanazon az öntési hőmérsékleten legyen öntve.
- 20 3. Az 1. igénypont szerinti hajvágó, ahol a forgópánt (120) polipropilénből van előállítva és az átvitel (130) üvegszálerősített polipropilénből van előállítva.
4. A 3. igénypont szerinti hajvágó, ahol a forgópánt (120) és átvitel (130) ugyanabban formában van öntve körülbelül 54°C-on (130°F).
5. Eljárás meghajtás (110) előállításán hajvágóban (10) felhasználásra, amely tartalmaz forgó
- 25 meghajtást (38, 42, 50, 54) és vágófej egységet (18), a meghajtás (110) átvizsgáló mozgást a forgó meghajtásról (38, 42, 50, 54) az vágófej egység (18) egy részének ide-oda mozgásába, az eljárás tartalmazza:
 - átvitel (130) fröccsöntését fröccsöntőszerszámban;
 - forgópánt (120) fröccsöntését ugyanabban a fröccsöntőszerszámban; és
 - 30 az átvitel (130) és forgópánt (120) mechanikus összekötését az átvitel (130) és forgópánt (120) egyikének fröccsöntése által a másik egy része felett.
6. Az 5. igénypont szerinti eljárás, ahol az átvitel (130) fröccsöntése tartalmazza az átvitel (130) fröccsöntését első öntési hőmérsékleten a szerszámon belül; és ahol a forgópánt (120) fröccsöntése tartalmazza a forgópánt (120) fröccsöntését lényegében az első öntési hőmérsékleten.
- 35 7. Az 5. igénypont szerinti eljárás, ahol az átvitel (130) fröccsöntése tartalmazza első anyag fröccsöntését, hogy kialakítsuk az átvitelt (130); és ahol a forgópánt (120) fröccsöntése tartalmazza a második anyag fröccsöntését, hogy kialakítsuk a forgópántot (120), a második anyag különböző az első anyagtól, de lényegében ugyanaz az olvadáspontjuk.

8. Az 5. igénypont szerinti eljárás, ahol az átvitel (130) fröccsöntése tartalmazza üvegszálerősített polipropilén fröccsöntését, hogy kialakítsuk az átvitelt (130); és ahol a forgópánt (120) fröccsöntése tartalmazza polipropilén fröccsöntését, hogy kialakítsuk a forgópántot (120).

9. A 8. igénypont szerinti eljárás, ahol mind az átvitel (130) és mind a forgópánt (120) fröccsöntése tartalmazza az öntési hőmérséklet tartását körülbelül 54°C-on (130°F).

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