

Title (en)  
METHOD OF MANUFACTURING A COILED FLEXIBLE TUBE, AND COILED FLEXIBLE TUBE

Publication  
**EP 0071273 B1 19851106 (DE)**

Application  
**EP 82106873 A 19820729**

Priority  
• DE 3130323 A 19810731  
• DE 3202516 A 19820127  
• DE 3204244 A 19820208

Abstract (en)  
[origin: EP0071273A1] 1. Process for manufacturing a strip-wound hose comprising the steps of : placing at least on foil strip (1) in a helical form with turns thereof placed one after the other, said at least one strip being supplied from a supply of strip to a piece (8) of strip-wound hose, produced at an earlier time and turning about the longitudinal axis thereof, an joining said strip to said piece of hose for increasing length of same, the strip material of adjacent turns being made to mutually overlap along the margins and the adjacent turns along these margins being joined together upon supplying a connection band (10) so as to give a mechanical connection between one such turn and the next turn thereto, said supplied connection band, upon being folded, being so placed that at the position of such overlap it engages said margin zones for fixing the overlapping margin zone in relation to the other of said overlapping margin zones, characterized by the following consecutive steps of : a) folding the connection band (10) about one of the lengthways edges of said strip (1) supplied for joining to said produced piece of hose in such a way that a fold leg (14) of the connection band on an upper side and a fold leg (13) on a lower side of the strip is moved along with the strip for forming a three-layer structure made up of the one layer of the strip material between two layers of the connection band, b) placing the margin zone that is to be overlapped of the strip on a free margin zone of the end turn of the piece (8) of hose produced earlier in such a way that one of the two materials selected from : said strip and said end turn, is placed on one (14) of the fold legs of the connection band (10) that is seated on the other of said materials, over part (15) of the breadth of this fold leg, which placing is carried out at the beginning of, or during bending to become round, of the strip (1), and of or during the overlapping placement of the strip material of the end turn upon forming of the next turn, whereafter part of the length (16) of this fold leg (14), that thus is partly covered over, is kept uncovered and on such covered part (15) of the connection band (10) there is a four-layer structure, that is made up of the connection band, strip material of the one turn, connection band and strip material of the next turn, c) the uncovered part (16) of the fold leg (14) is folded down about the lengthways edge of the placed strip material, such folding taking place so that said uncovered part is placed on said strip material with the production of a five-layer structure made up of the connection band, strip material of one turn, connection band, strip material of the next turn and connection band, d) this five-layer structure so produced is acted upon by a pressing force in a direction normal to the plane of the strip material and the material of the connection band for the purpose of producing a strong connection structure of the materials.

IPC 1-7  
**B21C 37/12; F16L 11/16**

IPC 8 full level  
**B21C 37/12** (2006.01)

CPC (source: EP)  
**B21C 37/121** (2013.01); **B21C 37/124** (2013.01)

Cited by  
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**EP 0071273 A1 19830209; EP 0071273 B1 19851106**

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