

Title (en)  
Manufacture of telecommunications cable cores.

Title (de)  
Herstellung von Nachrichtenkabelseelen.

Title (fr)  
Fabrication d'âmes de câble de télécommunications.

Publication  
**EP 0147071 A2 19850703 (EN)**

Application  
**EP 84308216 A 19841127**

Priority  
CA 444289 A 19831223

Abstract (en)  
A core unit (23) and method and apparatus for making it in which conductor pairs or units (38) have a single direction of twist and angles of twist lay change along lengths of the conductor pairs. In a preferred and practical construction, the angles of twist lay of all pairs change along their lengths on a continuous basis. This angle change is cyclical and with the cycles of the angles of the pairs being out-of-phase with one another. This achieves average twist lays of the units which are substantially equal to one another from conductor pair-to pair. The structure is achieved in a tandem operation of twisting conductors (30) into pairs and then forming them into the core unit, preferably by stranding.

IPC 1-7  
**H01B 13/02**

IPC 8 full level  
**D07B 3/00** (2006.01); **H01B 13/02** (2006.01); **H01B 13/04** (2006.01)

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