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(54) Benevnelse **DEVICE FOR LAYING PASTE PATTERNS IN A TUBE**

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# Device for laying paste patterns in a tube

## Field of the invention

The technical field of the invention is mainly that of tubes for cylindrical propellant charges having a central channel, equipping the munitions.

## Prior art

The propellant charges fitted to shells and missiles are ignited by means of a squib combined with an igniter tube. The igniter tube is formed of a combustible tube containing an ignition charge based on rapid combustion ignition powder. The igniter tube is placed in the channel of the propellant charge.

Patent application FR-A-2 593 905 describes an ignition charge placed in a combustible tube consisting of a pile of tablets of agglomerated ignition powder. These assemblies for an igniter tube require both the manufacture of agglomerated powder tablets, as well as their placing in the combustible tube.

However, the operation of filling the combustible tube with the ignition charge is a delicate operation, in terms of both the handling technique and the pyrotechnic risk (the ignition powder is classified in risk division 1.1 in the sense of the UN GHS classification ((UN) Globally Harmonised System for classification and labelling of chemical products). This operation requires special tooling in order to be automated. Moreover, when the ignition charge is introduced into the tube in admixture with a collodion in order to obtain tablets (*in situ*), the evaporation time for the solvent of the collodion is long because of the confinement of the collodion loaded in the tube.

Furthermore, it is sometimes necessary to dismantle the igniter tube of a propellant charge, for example when scrapping or neutralising ammunition. This dismantling of the igniter tube involves an extraction of the ignition charge arranged in the combustible tube. This extraction by direct contact with the agglomerated powder generates a pyrotechnic danger.

Patent application FR-A-2 725 781 proposes a method making it possible to better distribute the powder charge in the channel of the munition and facilitates the dismantling of the ignition material compared with agglomerated powder ignition material. In order to do this, the agglomerated powder tablets are replaced by an ignition material comprising an ignition composition in powdered form (typically gunpowder) deposited on a flexible support sheet, which is then advantageously rolled up on itself in order to be inserted in a combustible tube to form an igniter tube. In order that the powder (which is just placed

on the flexible support) does not fall to the bottom of the igniter tube, the powdered composition must be covered with another flexible sheet (called a screen sheet), at least one of the screen and support sheets being coated with adhesive. However, the implementation of this method is complex because of the handling of the explosive ignition powder classified in risk division 1.1, the control of the regularity of the quantities of powder deposited in piles on the flexible sheet and the geometries of the piles, and the step of covering the piles of powder deposited on the flexible sheet by the sticky screen sheet. Moreover, the configuration possibilities for pyrotechnic objects are limited and controlled uniquely by the weight and the spatial distribution of the piles of powdered powder.

It would therefore be useful to have available a device enabling the deposition of paste patterns with varied geometries in a combustible tube, as known for example in US 3 453 163 A. The present invention proposes to respond to this need.

**Summary of the invention**

The present invention relates to a device according to claim 1 for depositing paste patterns, in particular ignition charge, on the surface of the channel of a tube, in particular a combustible tube. The invention also relates to a method according to claim 8 using the above-mentioned device.

**Brief description of the figures**

Figure 1 schematically represents the reference frame for movement of the device of the invention in a combustible tube.

Figure 2 schematically represents the assemblies A and B, the frame C, and a control module D.

Figure 3 shows the installation of assemblies A and B on the frame C.

Figure 4 shows movement of the combustible tube along the axis X.

Figure 5 shows a cartridge used in the device of the invention.

Figure 6 shows the direction of rotation of the combustible tube and the orientation of the nozzle in order to obtain a circular or helical deposit.

Figure 7 illustrates a circular deposit of paste in a combustible tube.

Figure 8 illustrates a helical deposit of paste in a combustible tube.

Figure 9 represents assembly A of the device of the invention.

Figure 10 shows the elements of assembly A ensuring the movements in X and Y.

Figure 11 represents an alternative of assembly B of the device of the invention.

Figure 12 represents an alternative of assembly B of the device of the invention.

Figure 13a represents a state of the device of the invention during its use.

Figure 13b represents a state of the device of the invention during its use.

Figure 14 represents a state of the device of the invention during its use.

Figure 15 represents a state of the device of the invention during its use.

Figure 16 represents a state of the device of the invention during its use.

Figure 17 represents a state of the device of the invention during its use.

Figure 18 illustrates a helical deposit of paste in a combustible tube.

Figure 19 illustrates a helical deposit of paste in a combustible tube.

**Description of the invention**

The present invention relates, according to a first aspect, to a device for depositing paste patterns, in particular ignition charge, on the inner or outer surface, preferably the inner surface, of a channel of a tube, in particular a combustible tube. The description which follows takes, as its reference frame, the axis Y horizontally positioned along the central axis of the tube, the axis X along a horizontal direction orthogonal to the axis Y, the rotation Z around the axis Y (tube rotation), and the rotation E around the axis Y (rotation of the syringe pushing screw), as shown in figure 1.

The device comprises a frame C supporting two mechanical assemblies A and B which cooperate:

- a first assembly A, for holding, positioning and moving the tube;
- a second assembly B for extrusion.

As illustrated in figure 2, the first assembly A comprises two superimposed tables allowing movement along the X and Y axes, and incorporates on the upper table a system for holding and rotating the tube along an axis of rotation Z. The second assembly B comprises a plate supporting a linear pushing system and a cylindrical cartridge. The cartridge contains the ignition charge paste to be deposited. The cartridge is prolonged at one of its ends by a bent tubular extension provided with an extrusion nozzle and, at its other end, contains a piston sliding with controlled movement.

These two assemblies A and B are mounted on a same frame C so that the longitudinal axis Yc of the cartridge and the axis of revolution Yt of the tube are coplanar in the plane (X, Y), as shown in figure 3.

The assembly A has a mobile shaft driven by a stepper motor enabling the tube to be moved along the axis X and aligning the axis Yt of the tube with the longitudinal axis Yc of the cartridge, as shown in figure 4.

For the deposition phase, assembly A ensures the moving of the tube, on the one hand for rotation Z about its central axis Y and, on the other hand, for translation along the axis Y. The two rotation and translation movements are driven separately by controlled actuators. These actuators are, for example, stepper motors, controlled by software interfaces of the type known for 3D printers. The rotation and translation movements of the tube can be continuous or discontinuous in stages, at constant or variable speed.

The assembly B supports a cylindrical cartridge containing the ignition charge paste mounted on a fixed table, as shown in figure 5. The cartridge is oriented along the axis Y and is provided at one end, towards the tube, with a curved tubular extension terminating in an extrusion nozzle. Therefore, the cartridge and the nozzle cannot move along the axis Y but the horizontal movement travel along the axis Y ensured by assembly A is sufficient so that the nozzle penetrates into the channel of the tube over its entire length. A piston, actuated in the body of the cartridge by a jack or a worm screw, is capable of moving in translation in the body of the cartridge and along the longitudinal axis Yc. The movement in translation of the jack or of the screw is generated by a stepping motor controlled by a software interface, for example of the type used for 3D printers. For the depositing phase, the flow rate of paste via the nozzle is regulated by the movement of the piston. The paste extruded by the nozzle is deposited on the surface of the channel of the tube in order to form the desired pattern or patterns.

The angular orientation of the nozzle in the plane (Y, Z) is decisive for the quality of the deposit in the tube. This angular orientation is a function, in particular, of the viscosity of the paste, the speed of rotation of the tube and the adhesion of the paste on the tube. Advantageously, the nozzle is orientated at about 225° for a rotation of the tube in the anticlockwise direction in order to obtain a circular or helical deposit (the tube then also moving in translation), as shown in figure 6.

The coordination of the movements of the tube (in rotation about the axis Y and in translation along the axis Y) and of the piston of the cartridge along the axis Y, makes it possible to control, at each instant, the position of the deposition in the channel of the tube and the quantity of paste deposited. This coordination is ensured, for example, by a computer program for controlling motors taking into account as input data, in particular, the size characteristics of the deposit (weight deposited, patterns, etc.) of the ignition charge and those of the tube (diameter, length, etc.).

In one embodiment, the cartridge is temperature conditioned so as to maintain the viscosity of the paste at a value ensuring its extrusion and flowability.

This device makes it possible to deposit paste patterns of varied geometries in the tube, for example linear patterns along the axis of the tube, circular, helical and triangular (chevrons) patterns. A plurality of patterns can be deposited successively in the channel of the tube, for example a plurality of helical patterns that are angularly offset or intertwining of patterns. The quantity of paste deposited within a given pattern can also vary according to the position in the channel by varying the speed of advancement of the piston of the syringe and/or the speed of rotation/translation of the tube. It is also possible to obtain patterns of pastes in different compositions, either by introducing into the cartridge at least two stages of different compositions, or by repeating the depositing operation with cartridges containing different compositions.

The tube is made, for example, of plastic, metal or fibrous material. Advantageously, the tube is made of combustible fibrous material of the type used for tubes for propellant charges. By way of indication, the combustible tube, such as those marketed by the company Eurenco, consists of 60 wt% to 80 wt% cellulose ester, 17 wt% to 37 wt% cellulose, 3 wt% to 7 wt% resin and 0 wt% to 2 wt% stabilising additive (the sum of these various constituents being equal to 100%). Its weight is about 15 g to 25 g. The combustible tube has a height of from about 120 mm to 140 mm, for an inner diameter of from 25 mm to 30 mm and a thickness of from 1.5 to 2.5 mm.

Advantageously, the combustible tube has the composition given in table 1 and the dimensions given below.

Table 1

| Composition | wt% |
|---|---|
| Nitrocellulose powder cotton | 69 |
| Cellulose | 25 |
| Resin | 5 |
| Stabilising additive | 1 |

The weight of such a combustible tube is 18 g +/- 3 g, its height is 126 mm, for an internal diameter of 28 mm and a thickness of 1.8 mm.

In one embodiment, the surface of the tube can be prepared, prior to the depositing of the paste, by sanding or by depositing a primer in order to promote the adhesion of the paste during the depositing.

In one embodiment, the tube installed on the device of the invention can have a length that is a multiple of that of the unit tube forming the channel of the munition, it is then, after depositing, cut into sections of equal length to that of the unit tube.

The cartridge containing the paste is, for example:

- a simple syringe equipped with its piston, the tip of which has been cut in order to receive the tubular extension, or
- a plastic cartridge equipped with a piston of the type used for extruding masonry pastes or silicone joints, or
- a cylindrical body equipped with a piston receiving a cylindrical flexible pouch of the type of those marketed by the company Titanobel or by the company Würth France.

In one embodiment, the cartridge is automatically filled with paste from a paste tank. A tubular connection between the tank and the cartridge makes it possible to fill the cartridge when the piston is moved back, leaving the volume of the cartridge free. This avoids replacement of the cartridge after use of its paste contents, in order to carry out a new depositing.

The deposited paste can keep its pasty aspect or solidify (for example by evaporation of a solvent or solvents, or cross-linking of a polymer). The patterns obtained after depositing are thus either pasty or solid depending on the desired end product. It is possible that some of the patterns keep their pasty aspect while some others are solidified according to the compositions of deposited pastes (by incorporation at least two different compositions in the cartridge, or by carrying out successively at least two deposits with different compositions).

In one embodiment suitable for depositing an ignition charge in the combustible tube, the paste consists of a collodion loaded with an ignition powder, which solidifies by evaporation of the one or more solvents after deposition to produce solid patterns.

The collodion is of the type nitrocellulose base + solvent(s). In one embodiment, the nitrocellulose base of the collodion consists of a cellulose ester (for about 70 wt% to about 90 wt%) and generally contains, in addition, conventionally, at least one plasticiser (about 1 wt% to about 20 wt%, preferably about 10 wt%) and at least one stabiliser of the cellulose ester (about 0.5 wt% to about 5 wt%). It also generally contains at least one additive (>0 wt% to about 1 wt%), for example selected from anti-adhesion agents, anti-flash agents and antioxidants. It can contain a residual quantity of solvent(s), in particular anti-phlegmatising solvent(s) or (and) solvent(s) for dissolving the cellulose ester used during its manufacture.

Advantageously, the cellulose ester used as a majority component is selected from cellulose nitrate, cellulose acetate and nitrocellulose, the latter being preferred. The weight content of nitrogen of the nitrocellulose is ideally 10.5% to 13.5%, an example being grade E nitrocellulose with a weight content of nitrogen of 11.8% to 12.3%, advantageously equal to 12%.

The plasticiser used to prepare the collodion can be, in particular, a ketone (such as camphor), a vinyl ether (such as LUTONAL® A50 marketed by the company BASF), a polyurethane (such as NEP-PLAST 2001 marketed by the company Hagedorn-NC), an adipate (such as dioctyl adipate) or a citrate (such as triethyl 2-acetylcitrate).

The stabiliser used to prepare the collodion can be, in particular, a compound the chemical formula of which comprises aromatic rings (ideally two aromatic rings), capable of fixing the nitrogen oxides from the decomposition of nitric esters (presently nitrocellulose). Examples of stabiliser may include 2-nitrodiphenylamine (2NDPA), 1,3-diethyl-1,3-diphenyl urea (centralite I), 1,3-dimethyl-1,3-diphenyl urea (centralite II), and 1-methyl-3-ethyl-1,3-diphenyl urea (centralite III).

The optional additive used for preparing the collodion can be selected, in particular, from anti-adhesion agents, such as silicone-type anti-adhesion agents, anti-flash agents, antioxidants, dyes, surfactants, anti-agglomeration agents and hydrophobic agents.

The solvent can be a double solvent of the acetone/butyl acetate type (BA) at 50 wt%/50 wt%.

The collodion is advantageously formulated to lead to a dry extract (after evaporation of the solvent) of 10 wt% to 40 wt%.

By way of indication, table 2 below presents a formulation of the collodion with 14 wt% dry extract.

Table 2

| | Collodion | | |
|---|---|---|---|
| | | Composition (wt%) | |
| Nitrocellulose base | Nitrocellulose | 84 | 14 |
| | Plasticiser | 10 | |
| | Stabiliser | 3.5 | |
| | Others (additive(s), water, solvent...) | 2.5 | |
| | Total | 100 | |
| | BA | | 43 |
| | Acetone | | 43 |
| | Total | | 100 |

In one embodiment, the collodion loaded with ignition powder(s) comprises about 50 wt% to about 70 wt% powder(s), and the rest to 100% (in other words about 30 wt% to about 50 wt%) collodion. Conventionally, the one or more previously constituted ignition powders, are added to the collodion.

Conventionally, the one or more previously constituted ignition powders, are added to the collodion. The powder used is preferably gunpowder (GP) having a composition by weight:

- potassium nitrate (saltpetre): ~ 75%
- charcoal: ~ 15%
- sulfur: ~ 10%.

The collodion loaded with ignition powder is advantageously obtained by addition of the previously constituted ignition powder, in the solvent. It is then given the name "Benite B". It differs from those of the prior art, designated "benite", obtained by separate additions to the collodion of constituents of the ignition powder and without plasticiser. By way of indication, table 3 below gives an example of the composition of the collodion of table 2, loaded with ignition powder GP7 (which is a fine particle size powder).

Table 3

| Raw materials | Weight (g) | Composition (wt%) |
|---|---|---|
| GP7 | 10.36 | 56 |
| Collodion | 8.14 | 44 |
| Total | 18.5 | 100 |

The collodion loaded with ignition powder is classified in risk division 1.4 within the meaning of the UN GHS. The danger zones to take into account for handling the loaded collodion are therefore reduced, which facilitates the operations of depositing the collodion on the tube.

After drying (evaporation of the solvent) of the loaded collodion, the dry product (i.e. the ignition charge) comprises about 88 wt% to about 92 wt% ignition powder(s), about 7 wt% to about 10 wt% cellulose ester, the rest to 100% being provided by at least one compound selected from a plasticiser, an additive and a residual solvent. By way of indication, the dry product obtained after drying (evaporation of the solvent) of the collodion of table 3 contains the weight ratios indicated in table 4 below.

Table 4

| Dry Benite B composition | Weight (g) | wt% |
|---|---|---|
| PN7 | 10.36 | 90.08 |
| Nitrocellulose | 0.96 | 8.35 |
| Plasticiser | 0.11 | 0.96 |
| Stabiliser | 0.04 | 0.35 |
| Residues (water, solvent, etc.) | 0.03 | 0.26 |
| Total | 11.50 | 100.00 |

The viscosity of the paste is adjusted so as to allow its loading by pouring into the cartridge, its extrusion via the nozzle, and its non-flowing depositing on the tube.

Any geometry and depositing of patterns on the inner surface (channel) of the tube by means of the device of the invention can be envisaged.

In the case of an ignition charge, the shapes more particularly selected are spaced point patterns, or spaced circular patterns along the length of the channel, or linear patterns along the length of the channel, or one or more helical patterns along the length of the channel. The deposits are not necessarily all identical in size and/or composition and are not necessarily all arranged in a regular manner.

The number of deposits, their geometry and their arrangements constituting the ignition charge in the channel of the tube are adjustment parameters of the ignition charge. Figures 7 and 8 show shapes of ignition charge deposited in the channel of a tube.

As previously indicated, the device according to the invention therefore comprises two assemblies A and B, mounted on a same frame C, which cooperate, assembly A which is suitable for holding and controlling the movements of the tube, and assembly B which is fixed and supports a cylindrical cartridge containing the paste to be deposited. The motors (see below) of assemblies A and B are controlled by a control module D.

Assembly A comprises the elements described below, represented in figure 9.

A system **28** enables the positioning and rotating of the tube **1.** This system 28 comprises rollers **2a**, **2b** and **3**, disposed in a triangle and between which the tube **1** is positioned. Rubber rings **4** are disposed on the rollers **2a** and **2b** in order to ensure a rotational driving contact with the tube **1**. The rollers **2a** and **2b** comprise, at their ends, a circular shoulder **5** allowing the tube **1** to be held in position along the axis Y. They also each comprise, at their end opposite to assembly B, a toothed wheel **6a**, **6b**. The system **28** comprises a toothed wheel **7** coupled with a shaft rotated via a stepping motor **8**

controlled by a software of the same type as those equipping 3D printers. The toothed wheel **7** cooperates with the toothed wheels **6a**, **6b** in order to rotate the tube **1**.

The three rollers **2a**, **2b** and **3** are assembled and thus fixed using brackets on the table **9a**. The roller **3** in the upper position is provided with means allowing it to be disengaged in order to position the tube **1** on the rollers **2a** and **2b**, then to fold it into contact above the tube **1**. In one embodiment, the roller **3** is held by an articulated arm **10** connected to the table **9a**.

As shown in figure 10, table **9a** is mounted on a second table **9b**, the connections between these two tables and the frame **C** are produced by means of rings, for example linear ball bearings (sliding on rails), for guidance, and toothed pulleys and belts for movement, this allowing a movement of the table **9a** along the axis X relative to the table **9b** (movement generated by the motor **11**) and a movement of the table **9b** along the axis Y relative to the frame **C** (movement generated by the motor **12**). The assembly is controlled by a software of the same type as those equipping 3D printers. This degree of freedom makes it possible to laterally disengage the table **9a** along the axis X in order to facilitate the positioning and removal of the tube **1** within the three rollers **2a, 2b and 3**. It also allows a precise positioning of table **9a** in order to make axis Yt of the tube **1** coincide with axis Yc of the cartridge **19** (see below).

The assembly B, disposed facing assembly A, comprises the elements described below, represented in figure 11.

A fixed table **13** supports two rings **14a** and **14b**, such as ball sockets, sliding on guide rails, co-linear with the axis Y, enabling the sliding of a carriage **15.** This carriage **15** is moved by a worm screw **16** actuated by a stepping motor **17**. The carriage **15** makes it possible to move the piston **18** of the cartridge **19** containing the paste by means of a connecting rod **20**.

The table **13** is disposed on the frame **C**. When the cartridge is a syringe, the rod **20** and the piston **18** (also called a stopper in the terminology of syringes) form a single piece. The plunger of the piston **18** of the syringe is housed in a central chamber **21**, equipped with a clasp, of the carriage **15**. The clasp ensures the connection in the central chamber **21** between the plunger of the piston **18** and the carriage **15**. A cradle **22** that is fixed on the table **13** holds the body of the syringe. The central chamber **21** of the carriage **15** and the cradle **22** are aligned and disposed so that the axis Yc of the syringe is co-linear with the Y-axis. A tubular extension **23** terminated by a nozzle **24** is disposed at the end of the syringe in place of the original tip of the syringe.

As shown in figure 12, when the cartridge **19** is a cylindrical body equipped with a piston, the rod **20** is centrally fixed to the piston **18**. At its other end, the rod **20** is held by a clasp in a central chamber **21** of the carriage **15**. The cartridge **19** is equipped at one of its ends with a curved tubular extension **23**, terminated by a nozzle **24**. Two legs **25a** and **25b** are fixed facing each other on the table **13**. Leg **25a** comprises a bore with a counter bore and the other **25b** comprises a half-bore with a shoulder so as to house the two ends of the cartridge (in the manner of a gun for a masonry cartridge). The legs **25a** and **25b** fixed on the table **13** and the central chamber **21** of the carriage **15** are aligned and disposed in such a way that the axis Yc of the cartridge is co-linear with the Y-axis.

According to another aspect, the invention relates to a method for depositing paste patterns on the (inner or outer, preferably inner) surface of the channel of a tube. In what follows, a method of implementation of the device of the invention is described, for depositing a helical pattern of ignition charge on the inner surface of a combustible tube, by using, as the cartridge containing the ignition charge paste, a cartridge with a cylindrical body and equipped with a piston.

At the start of the implementation, the articulated arm **10** supporting the roller **3** is unfolded and the position of the table **9a** is offset with respect to the axis Yc of the cartridge so as to facilitate the installation of the tube **1**. The tube **1** is placed on the rollers **2a** and **2b** as shown in figure 13a. Then, the roller **3** is brought into contact with the upper part of the tube **1** as shown in figure 13b.

The carriage **15** is then moved back towards the motor **17** so as to leave free space for positioning the cartridge **19**. The cartridge **19** containing the paste and equipped with its piston **18** connected to the rod **20** is positioned on the legs **25a** and **25b**. Then, the carriage **15** is advanced in order to secure the end of the rod **20** in the chamber **21** equipped with a clasp. The status of the device at this stage of implementation is shown in figure 14.

The priming of the cartridge **19** allows the filling with paste of the tubular extension **23** and the nozzle **24** by moving the piston **18** until the paste **26** starts to be extruded by the nozzle **24**, as shown in figure 15.

The table **9a** is then moved along the axis X by actuating the motor **11** so as to align the axes Yt of the tube **1** and Yc of the cartridge **19**. The device is then in the state shown in figure 16.

The table **9b** is then moved along the Y-axis by means of the motor **12** so as to make the nozzle **24** for extruding the paste penetrate to the initial point of deposition in the channel of the tube **1**, as shown in figure 17.

The tube 1 is then rotated by means of the motor **8**, and the deposition phase is then engaged by simultaneously actuating the motor **12** causing the movement of the tube **1** along the axis Y and of the motor **17** causing the advancement of the piston **18** of the cartridge **19**. The conjunction of the actions generated by each of the three motors **8**, **12** and **17** leads to a helical depositing of paste **27** on the inner surface of the tube, as shown in figures 8, 18 and 19. After the deposit of the pattern, the tables **9a and 9b** are returned to their initial position and the tube is withdrawn from the device.

By way of indication, the settings listed in table 5 can be used for the implementation of the device as described above.

Table 5

| | |
|---|---|
| Dimensions of the tube | Øint 28.5 mm / Lg Ht: 126 mm |
| Paste density | 1.2 g/cm$^3$ |
| Cartridge dimensions | Øint: 20.2 mm / useful Lg: 78 mm |
| Nozzle diameter | Ø 6 mm |
| Nozzle inclination | 235° (or 8 o'clock) |
| Speed [Mrot_tube] | 2 rpm |
| Speed [My_tube] | 14 mm/min |
| Speed [My_piston] | 7 mm/min |
| Linear density of deposited paste | 16.5 g/mL |
| Length of the pattern | 1000 mm |

The device of the invention is useful for depositing paste patterns inside a tube and, more particularly, for obtaining ignition tubes for propellant charges. It can also be used for any application requiring the deposit of patterns in a tube, for example in the industrial, pharmaceutical or food fields.

## PATENTKRAV

**1.** En anordning for å avsette pastamønstre, spesielt av tennladning, på overflaten av kanalen til et rør (1), spesielt et brennbart rør, innretningen innbefatter en ramme som understøtter en første mekanisk sammenstilling A for å holde, posisjonere og flytte røret, og en andre mekanisk sammenstilling B for ekstrudering av pasta for å avsette pastamønstrene, hvor sammenstillingene A og B samarbeider med hverandre,
**karakterisert ved** at sammenstilling A:
- innbefatter et første bord (9a) montert på et andre bord (9b), disse to bordene muliggjør bevegelse langs en horisontal akse Y beliggende langs den sentrale aksen til røret og langs en akse X beliggende i horisontal retning vinkelrett på aksen Y, og
- innbefatter på det første bordet (9a), et system (28) for å holde og rotere røret langs en rotasjonsakse Z.

**2.** Anordningen i henhold til krav 1, hvor det første bordet (9a) innbefatter:
- et rør (1) plassert mellom tre ruller (2a, 2b, 3) festet på det første bordet (9a), en første og en andre rulle (2a, 2b) som hver innbefatter, i den ene enden, en sirkulær skulder (5) å tillate at røret (1) holdes i posisjon langs aksen Y, og ved den andre enden et tannhjul (6a, 6b);
- en motor (8) som muliggjør at den første og andre rullen (2a, 2b) kan roteres via en aksel koblet til et tannhjul (7) som samvirker med tannhjulene (6a, 6b).

**3.** Anordningen i henhold til krav 2, hvor en tredje rulle (3) er forsynt med midler som gjør at den kan frigjøres for å posisjonere røret (1) på den første og andre rullen (2a, 2b), for så å brette den til kontakt over røret (1).

**4.** Anordningen i henhold til ett av kravene 1 til 3, hvor det andre bordet (9b) er festet på rammen (C), det første bordet (9a) er montert på det andre bordet (9b) for å tillate en bevegelse av første bordet (9a) langs aksen X i forhold til det andre bordet (9b), og en bevegelse av det andre bordet (9b) langs aksen Y i

forhold til rammen (C).

**5.** Anordningen i henhold til ett av kravene 1 til 4, hvor sammenstillingen B innbefatter:

- et fast bord (13) som understøtter to ringer (14a) og (14b) som glir på styreskinner, ko-lineært med Y-aksen;
- en vogn (15) beveget av en snekkeskrue (16) aktivert av en motor (17);
- en patron (19) innbefattende et stempel (18) forsynt med en forbindelsesstang (20), en rørformet forlengelse (23) og en dyse (24).

**6.** Anordningen i henhold til krav 5, hvor patronen er en sprøyte, og hvor:

- stangen (20) og stempelet (18) danner et enkelt stykke;
- stempelet til sprøytens stempel (18) er plassert i et sentralt kammer (21), utstyrt med en lås, i vognen (15);
- sprøytens legeme holdes av en vugge (22);
- det sentrale kammeret (21) og holderen (22) er innrettet og plassert slik at aksen til sprøyten Yc er ko-lineær med aksen Y.

**7.** Anordningen i henhold til krav 5, hvor patronen er et sylindrisk legeme tilveiebragt med et stempel, og hvor:

- stangen (20) er sentralt festet til stempelet (18);
- ved sin andre ende holdes stangen (20) av en lås i et sentralt kammer (21) på vognen (15);
- et første og et andre ben (25a, 25b) er festet vendt mot hverandre på det faste bordet (13), det første benet (25a) innbefatter en boring med en motboring og det andre ben (25b) innbefatter en halvboring med en skulder for å huse de to endene av patronen;
- bena (25a) og (25b) og det sentrale kammeret (21) er innrettet og plassert på en slik måte at aksen til patronen Yc er ko-lineær med aksen Y.

**8.** En fremgangsmåte for å avsette pastamønstre, spesielt tennladning, på overflaten av kanalen til et rør (1), spesielt et brennbart rør, ved implementering av anordningen i henhold til ett av kravene 1 til 7.

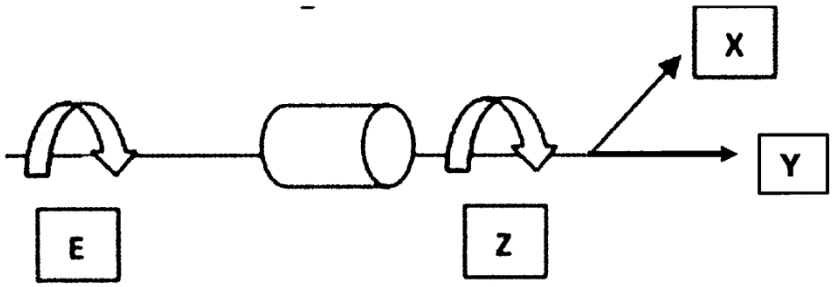


**Fig.1**

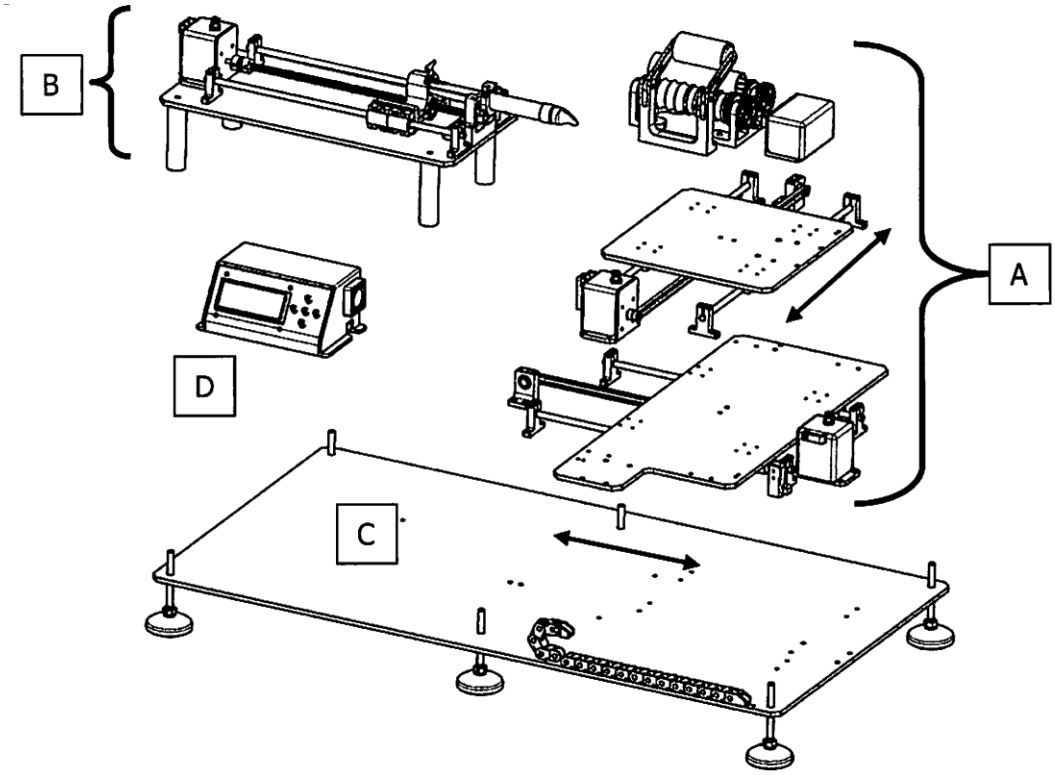


**Fig.2**

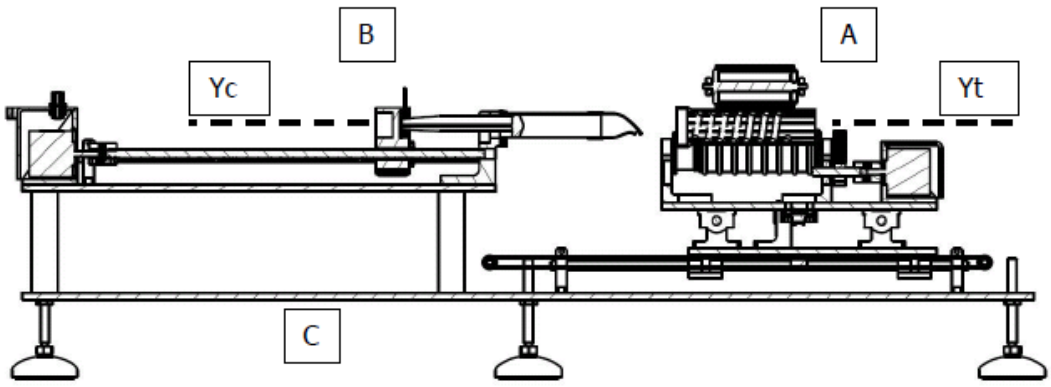


**Fig.3**

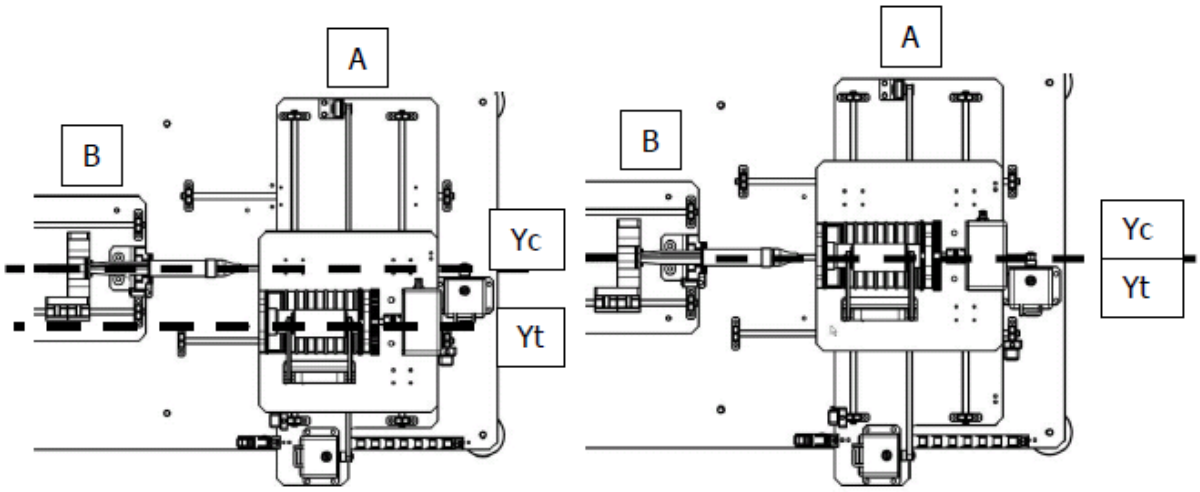


Fig.4

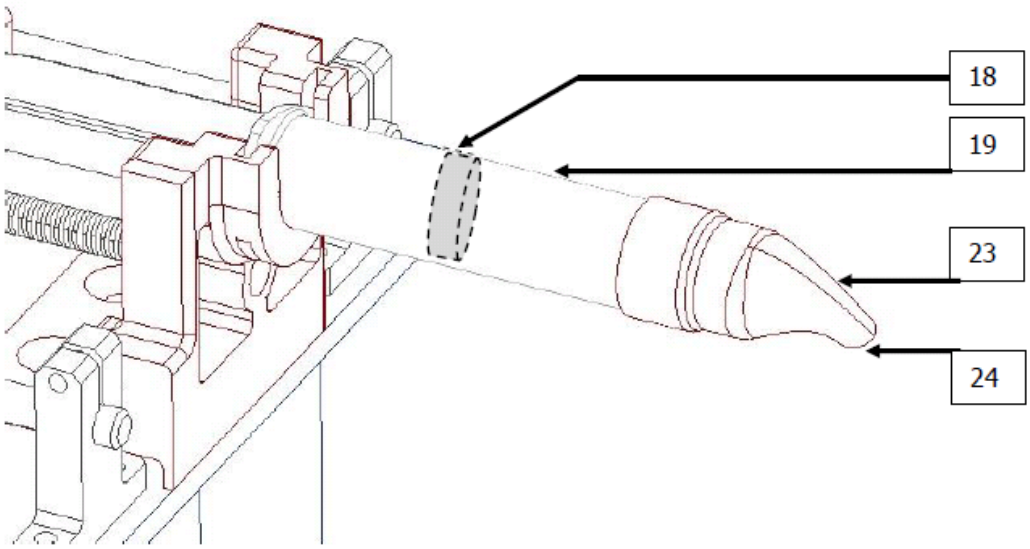


Fig.5

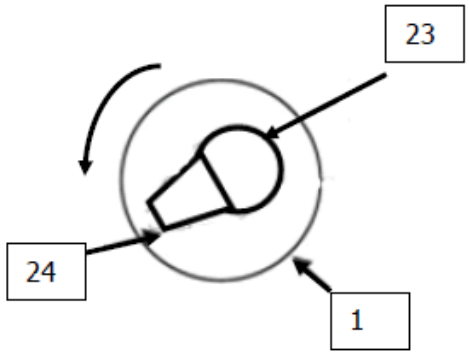


Fig.6

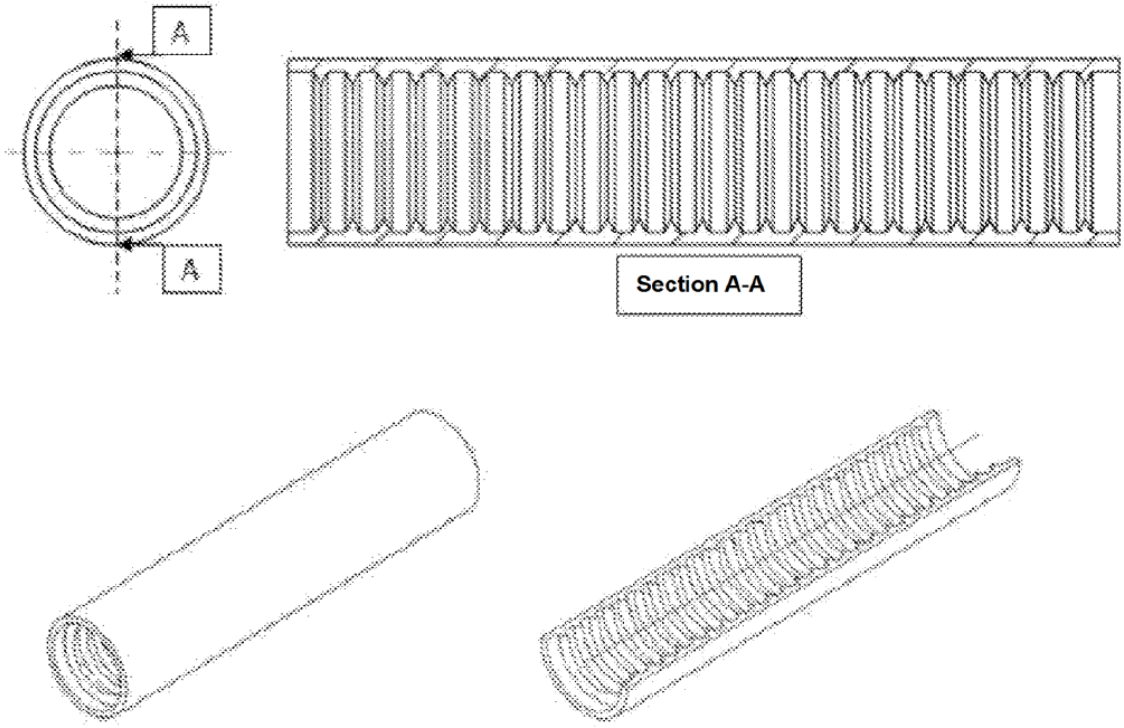
A
A
Section A-A

Fig.7

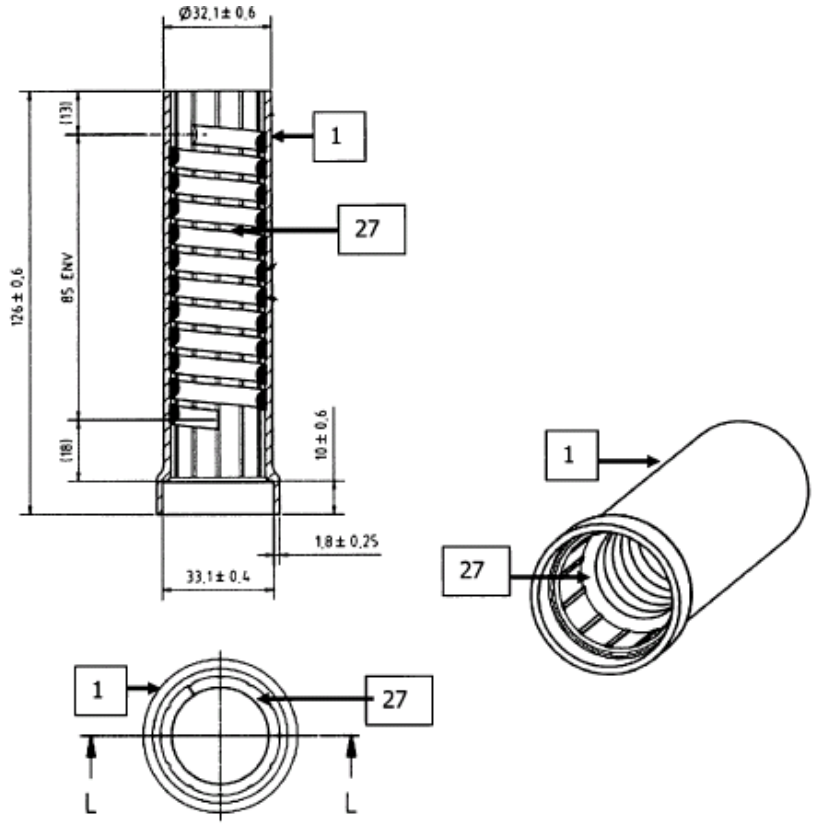
Ø32,1± 0,6
(13)
(18)
126± 0,6
85 ENV
10± 0,6
1,8± 0,25
33,1± 0,4
1
27
1
27
1
27
L
L

Fig.8

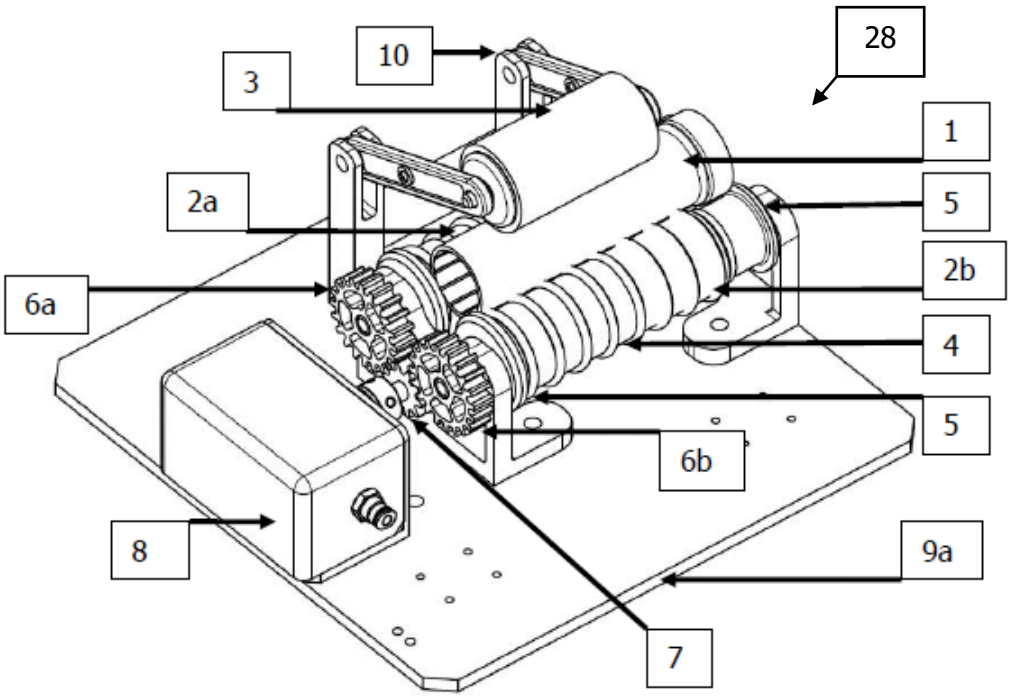


Fig.9

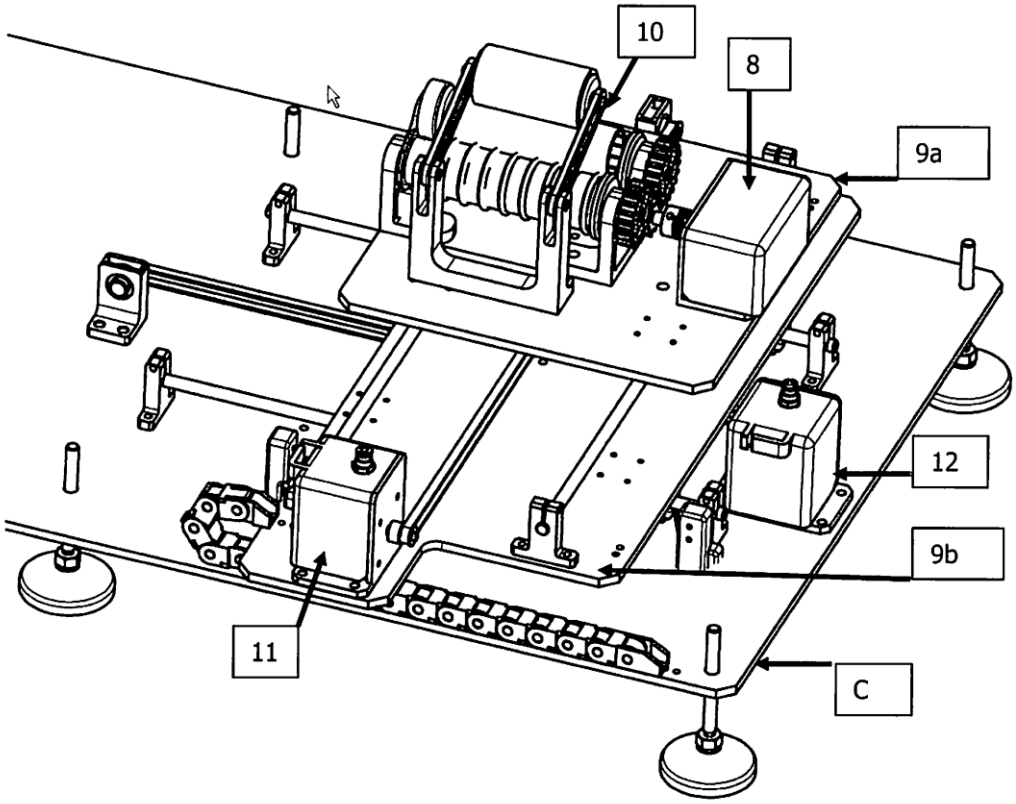


Fig.10

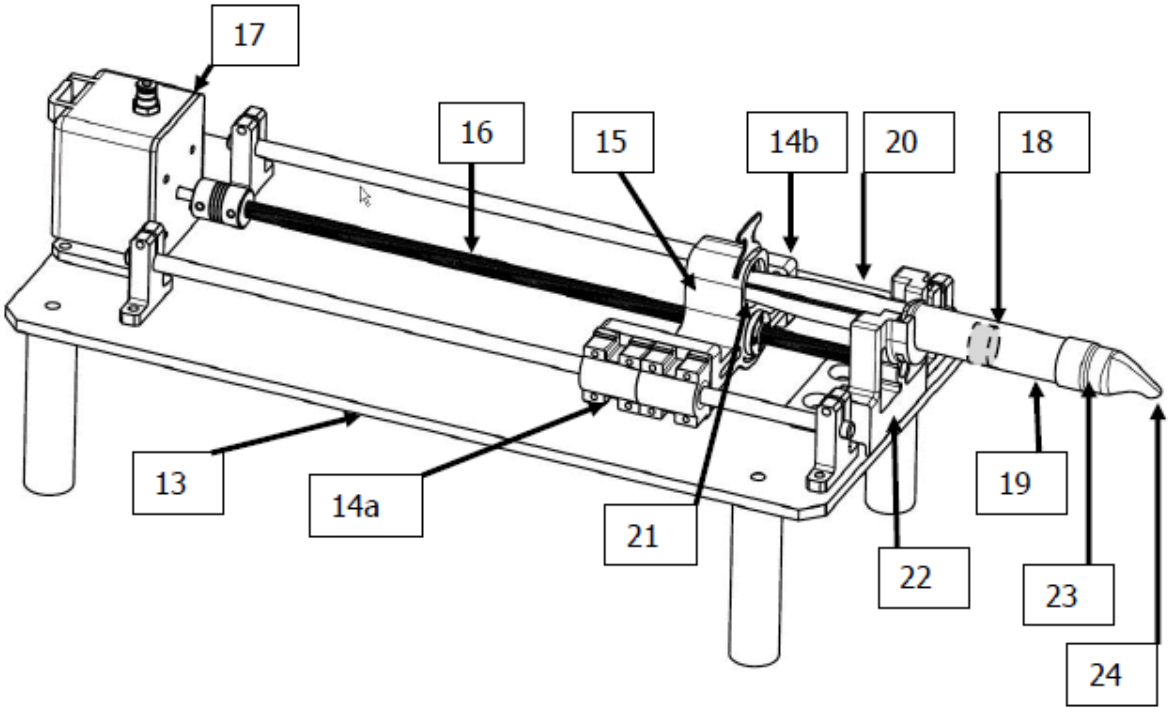


Fig.11

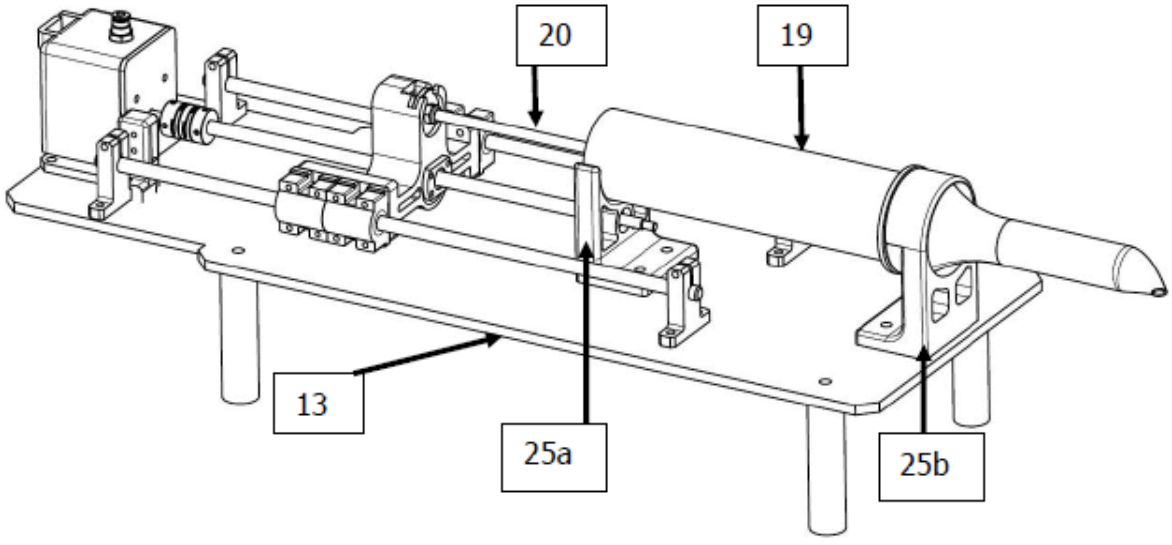


Fig.12

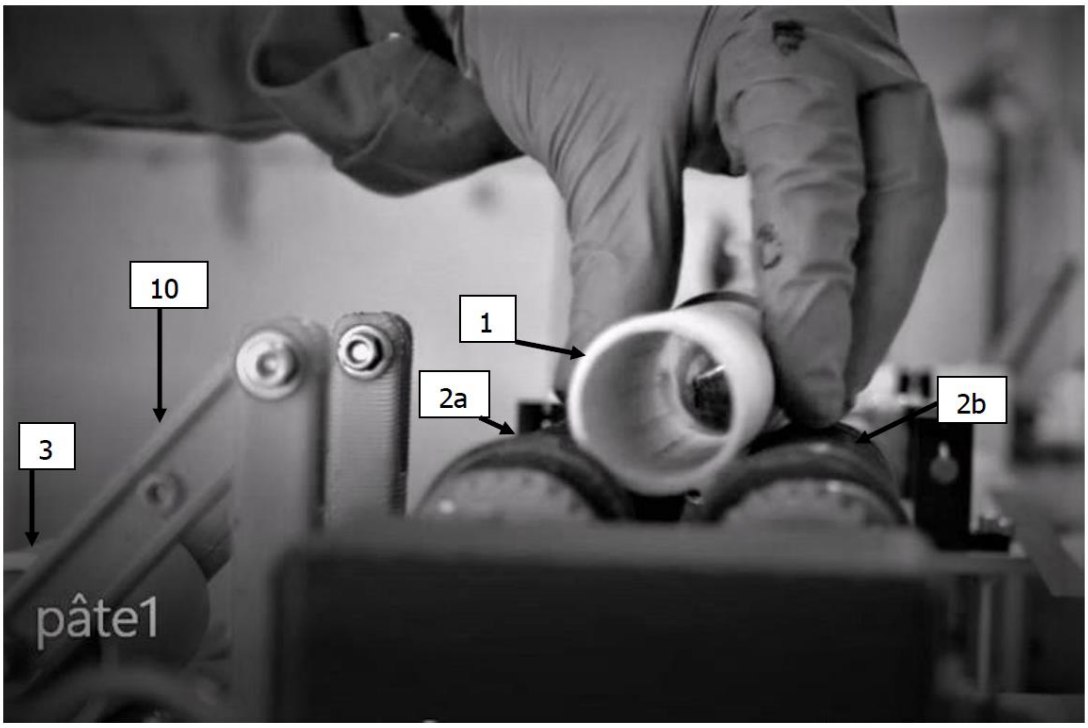


Fig.13a

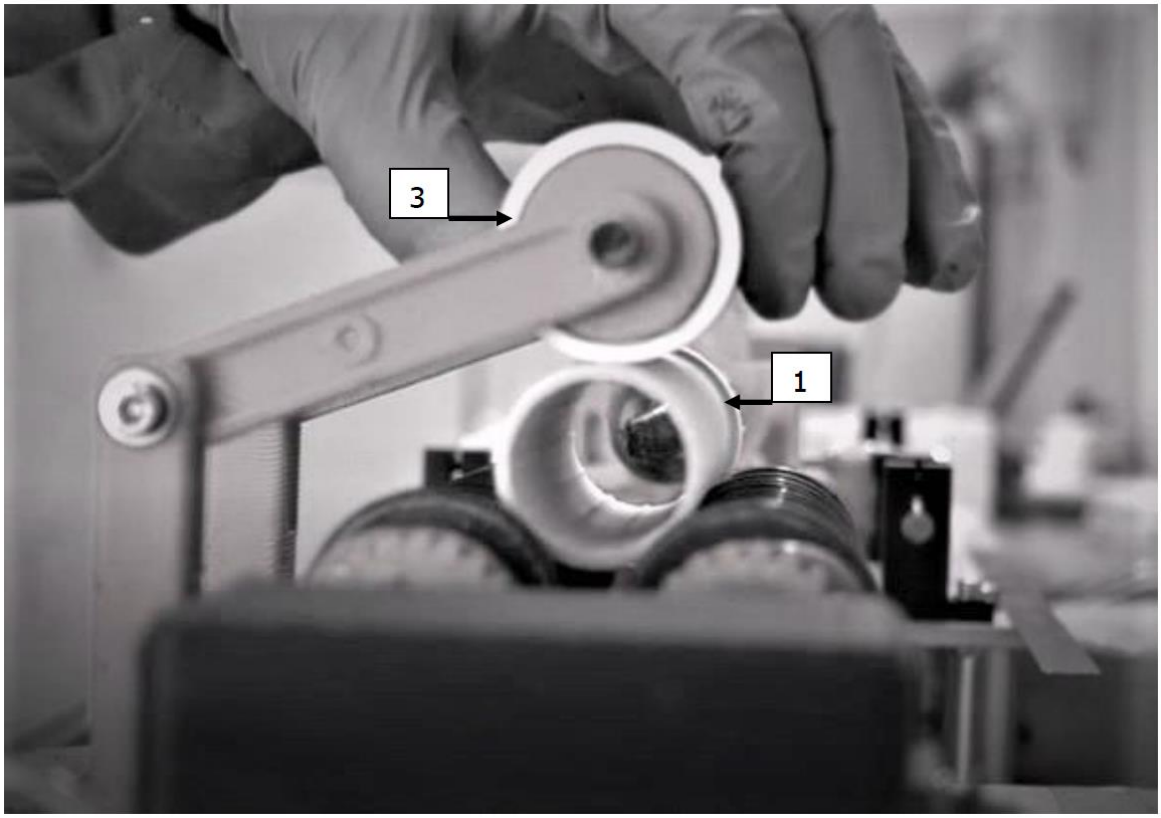


Fig.13b

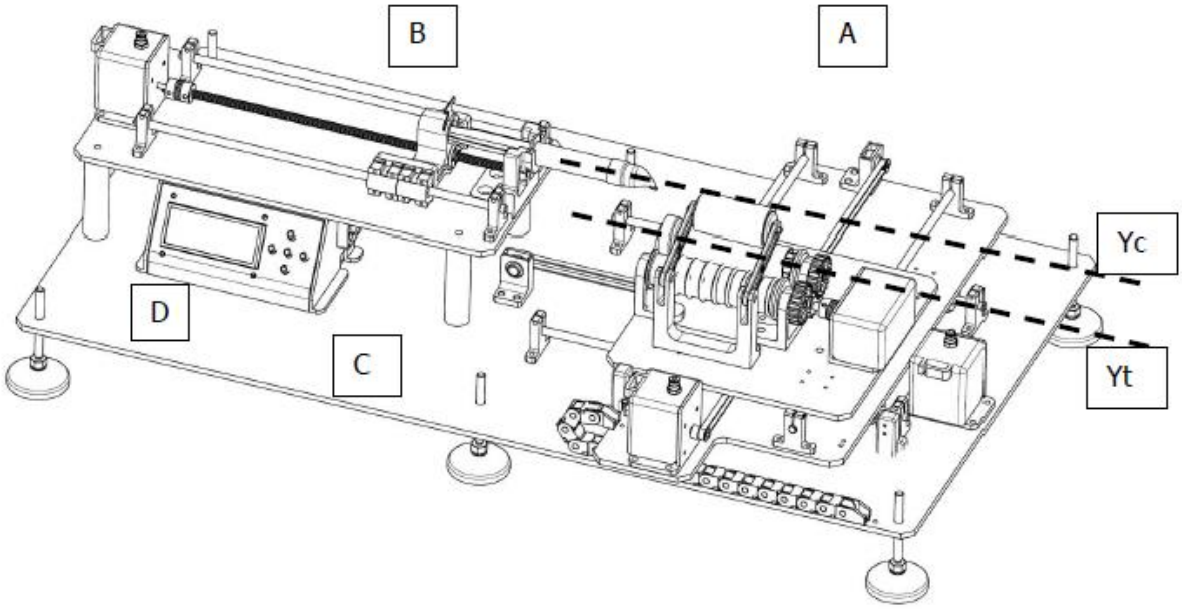


**Fig.14**

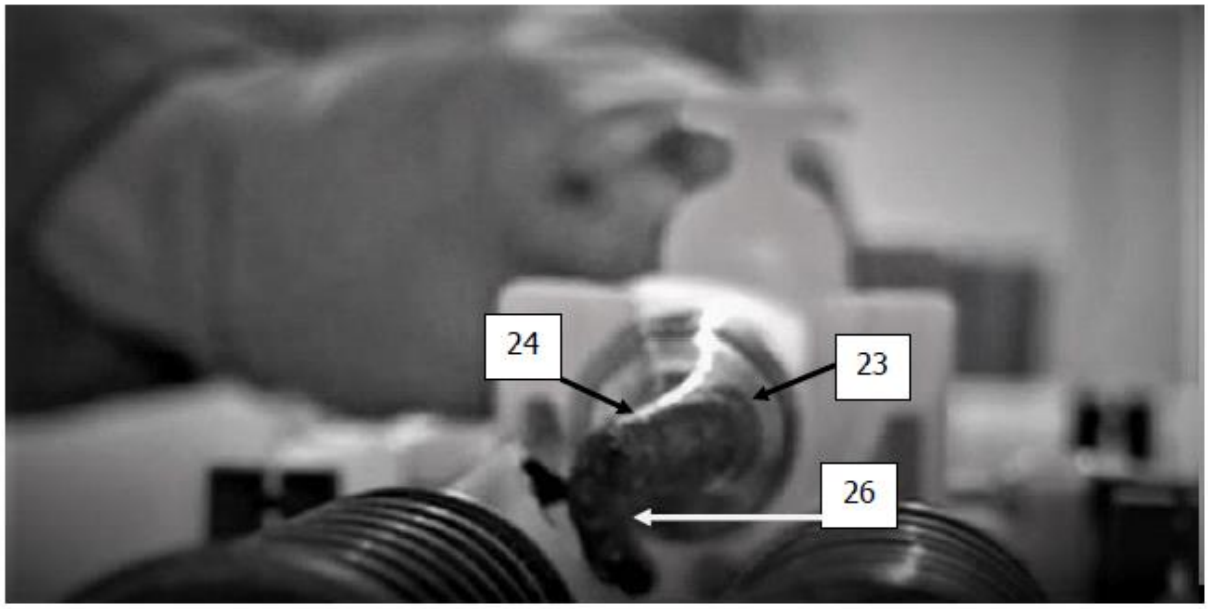


**Fig.15**

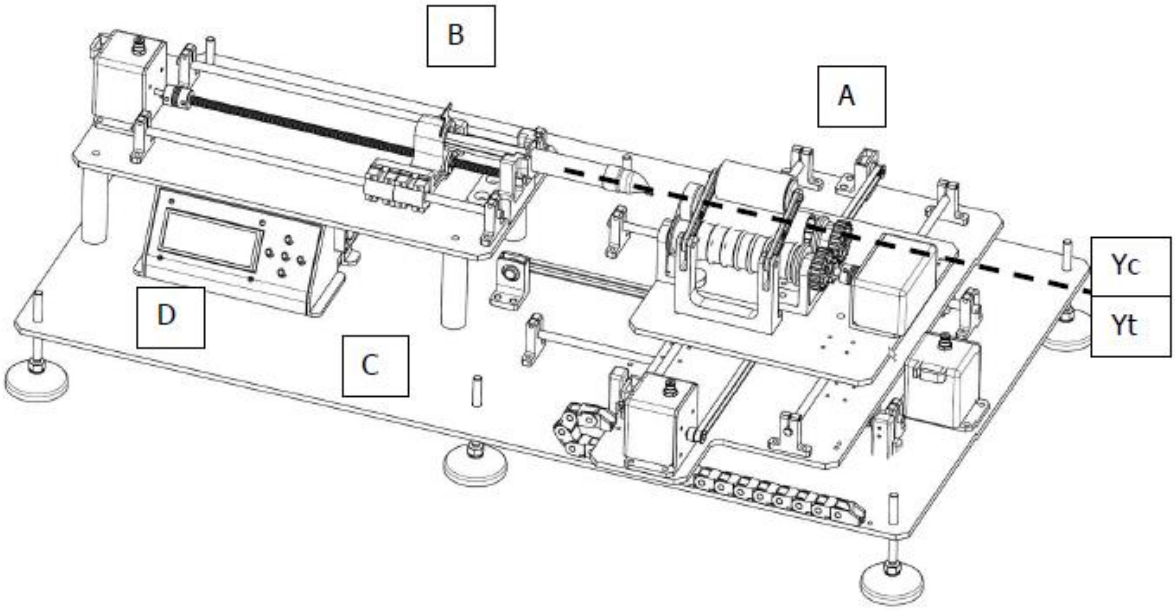


Fig.16

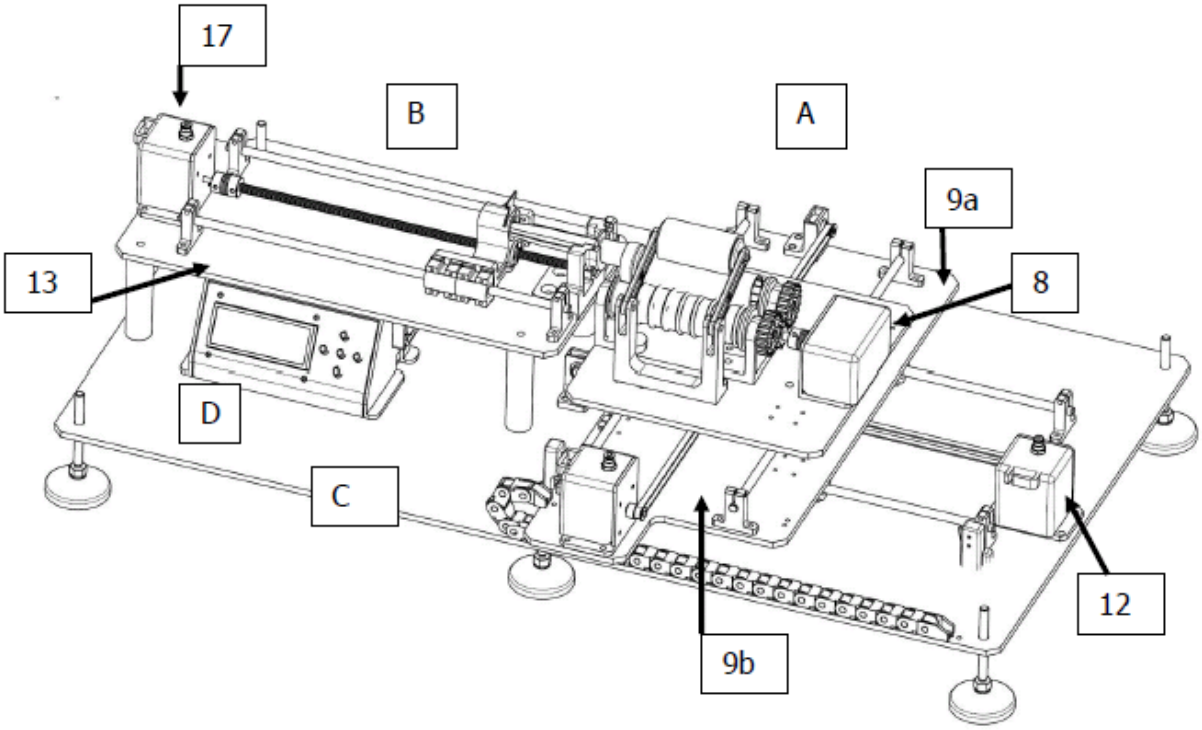


Fig.17

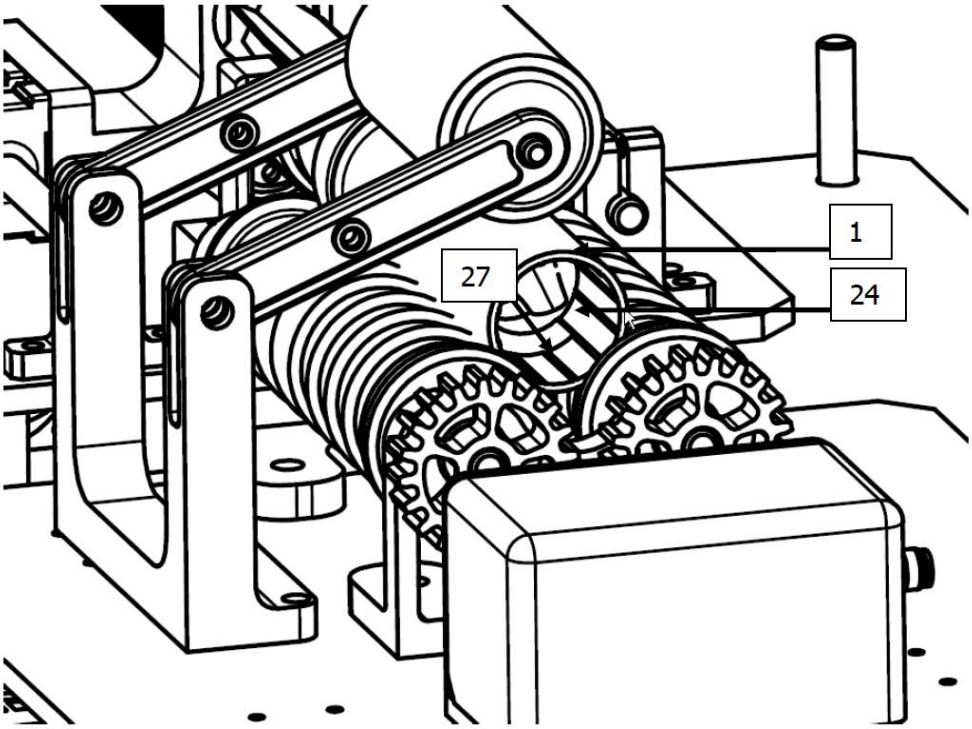


Fig.18

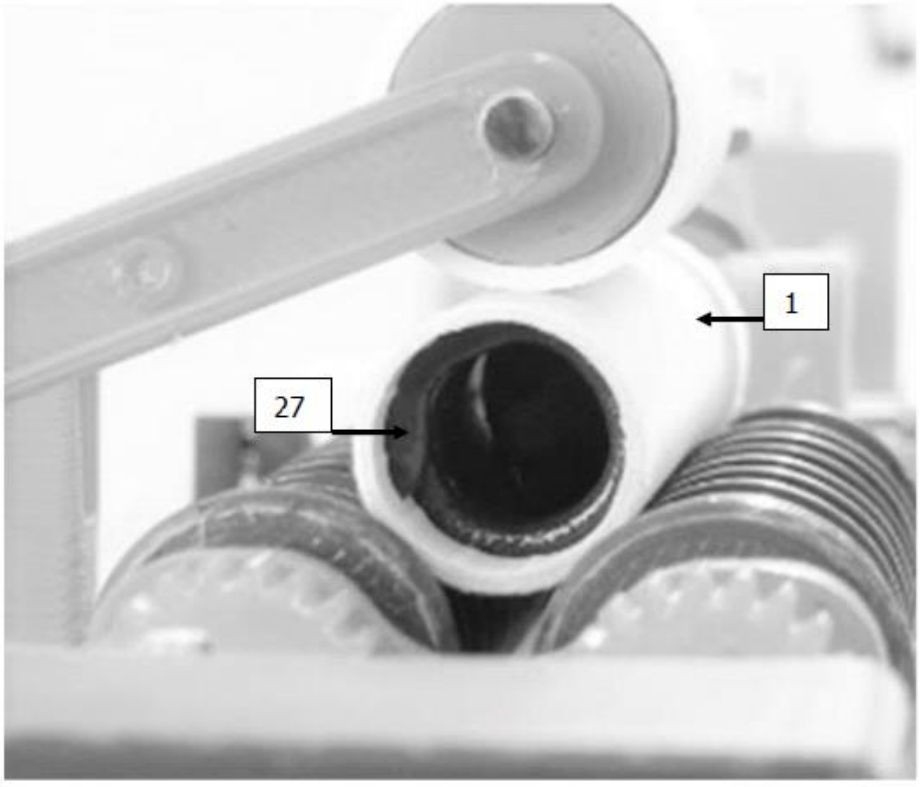


Fig.19