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(54) **SPORT BALL WITH ENERGY ABSORBING
FOAM AT VARYING LOCATIONS**

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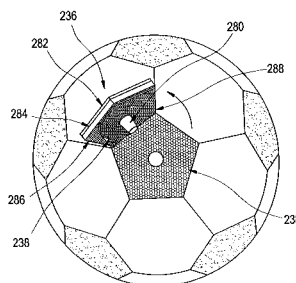
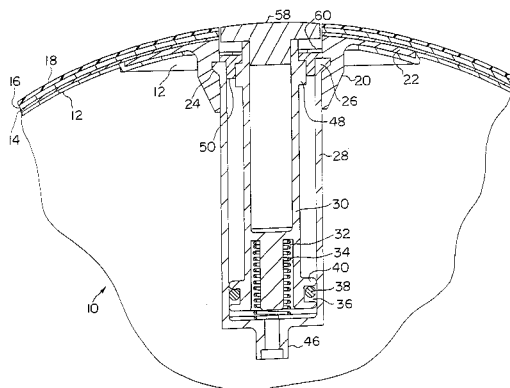
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(57) **ABSTRACT**

An inflatable sport ball, such as a soccer ball, a volleyball,
a basketball, a football or a playground ball, is provided with
a self-contained inflation mechanism for inflating or more
likely adding pressure to the ball. The mechanism is a pump
which is inside the ball and which is operable to pump
ambient air into the ball. Energy absorbing foam panels are
used at varying locations to maximize rebound performance
by minimizing the rebound height differential. The foam
panels may be of different types and/or thicknesses.



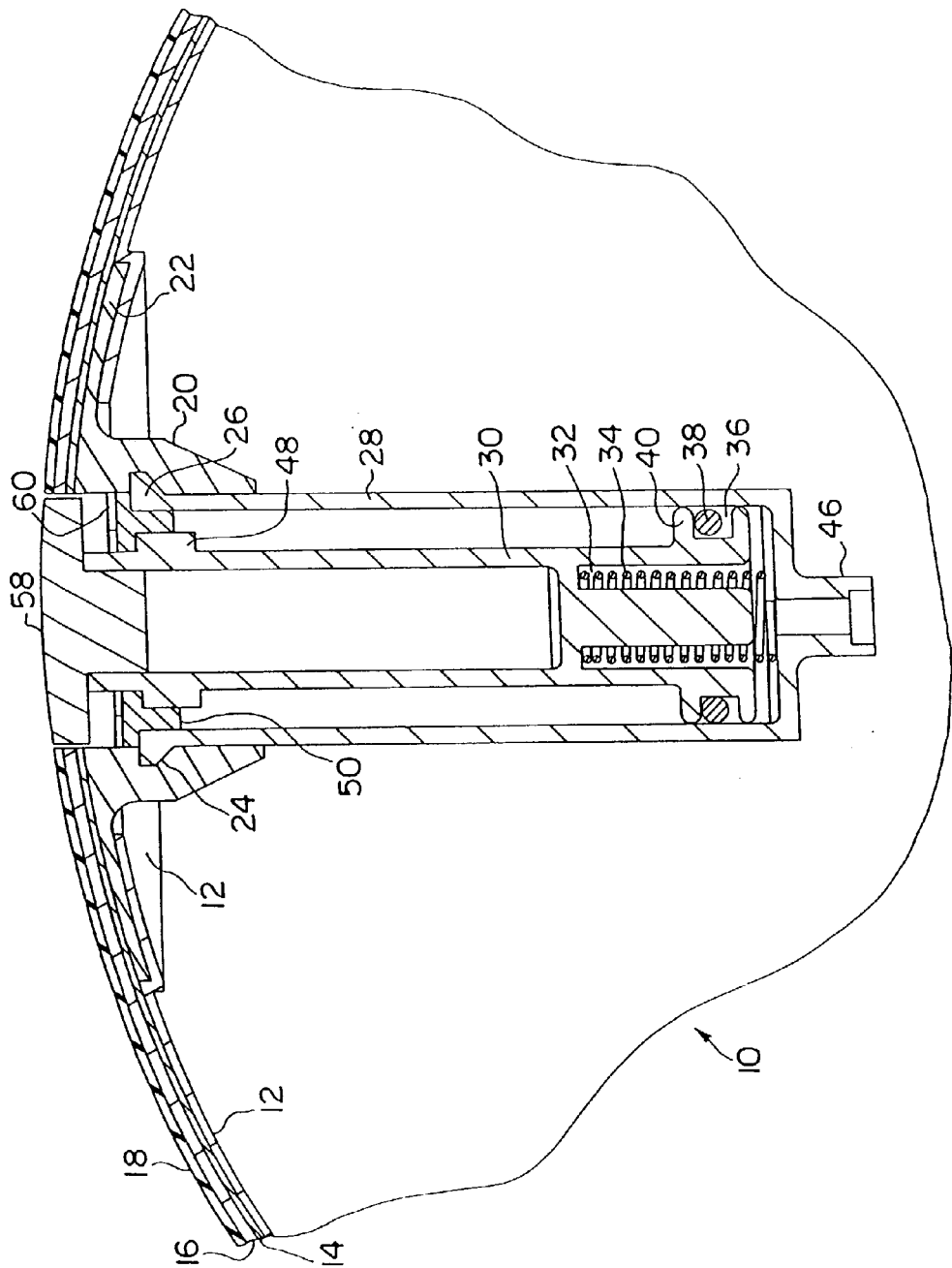


FIG. 1

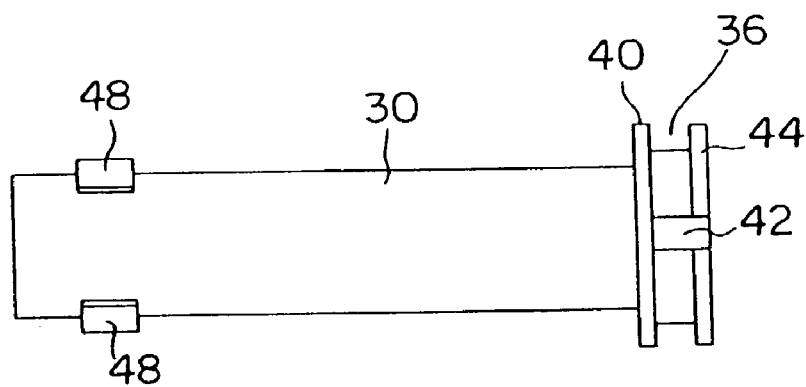


FIG. 2

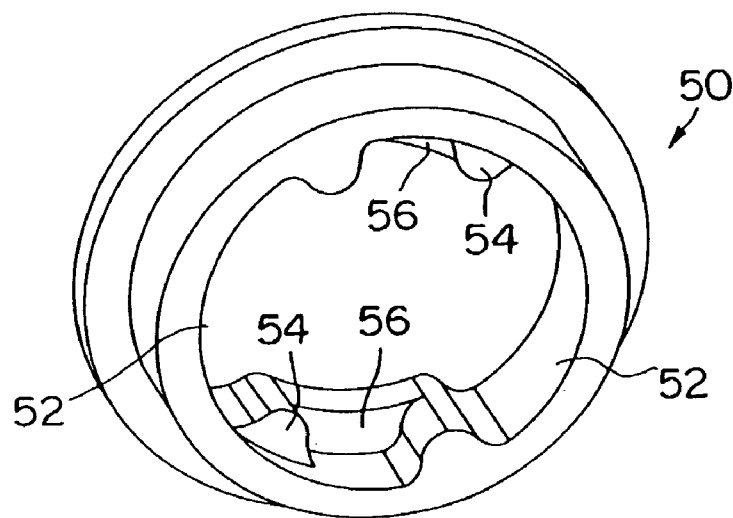


FIG. 3

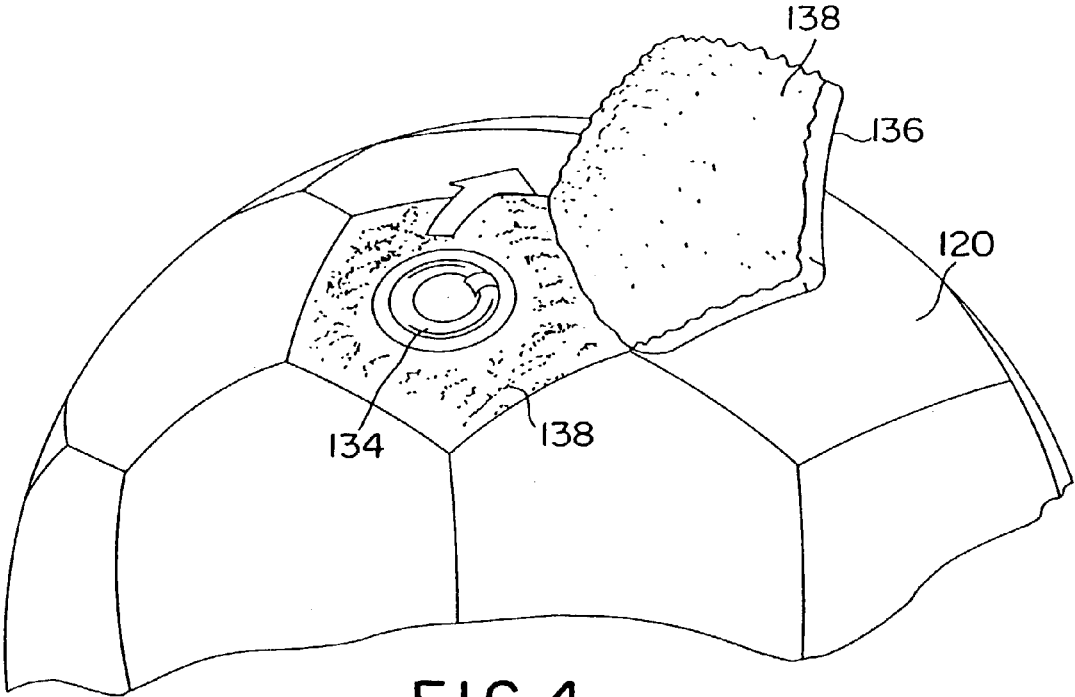
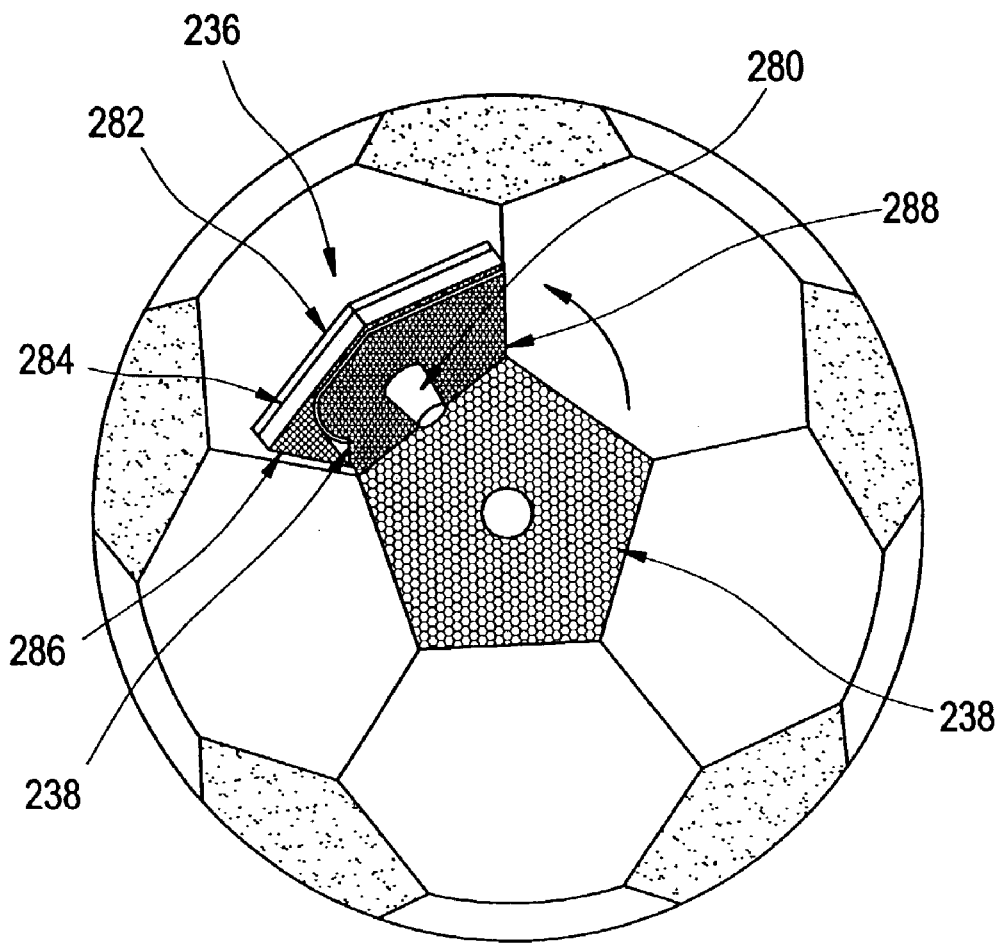


FIG. 4

FIG. 5



SPORT BALL WITH ENERGY ABSORBING FOAM AT VARYING LOCATIONS

CROSS REFERENCE TO RELATED APPLICATIONS

[0001] This application is a continuation-in-part of U.S. patent application Ser. No. 10/210,436, filed Aug. 1, 2002, which is continuation-in-part of U.S. patent application Ser. No. 10/183,337, filed Jun. 25, 2002, which is a continuation of U.S. patent application Ser. No. 09/594,980, filed Jun. 15, 2000, now U.S. Pat. No. 6,409,618, which is a continuation-in-part of U.S. patent application Ser. No. 09/478,225, filed Jan. 6, 2000, now U.S. Pat. No. 6,287,225, which claims the benefit of U.S. Provisional Application No. 60/159,311, filed Oct. 14, 1999. application Ser. No. 10/210,436 also claims the benefit of U.S. Provisional Application No. 60/309,665, filed Aug. 2, 2001. This application is also a continuation-in-part of U.S. patent application Ser. No. 09/766,165, filed Jan. 19, 2001, which is a continuation-in-part of U.S. patent application Ser. No. 09/594,980, filed Jun. 15, 2000, now U.S. Pat. No. 6,409,618, which is a continuation-in-part of U.S. patent application Ser. No. 09/478,225, filed Jan. 6, 2000, now U.S. Pat. No. 6,287,225. This application also claims the benefit of U.S. Provisional Application No. 60/342,421, filed Dec. 21, 2001.

BACKGROUND OF THE INVENTION

[0002] Conventional inflatable sport balls, such as soccer balls, basketballs, footballs, volleyballs and playground balls, may contain a foam layer or layers under the cover layer(s), but the foam layer, if present, is traditionally a layer of foam material that is of uniform thickness and composition. There is no way to control or improve the ball's performance, such as rebound, with the uniform foam layer.

[0003] Additionally, conventional inflatable sport balls, such as basketballs, footballs, soccer balls, volleyballs and playground balls, are traditionally inflated through an inflation valve using a separate inflation needle that is inserted into and through a self-sealing inflation valve. A separate pump, such as a traditional bicycle pump, is connected to the inflation needle and the ball is inflated using the pump. The inflation needle is then withdrawn from the inflation valve which self-seals to maintain the pressure. This system works fine until the sport ball needs inflation or a pressure increase and a needle and/or pump are not readily available. A sport ball having maximum performance that also has a self-contained inflation mechanism to add air to the sport ball is needed in the art. For some sport balls, a cover, such as a panel or other portion, over the self-contained inflation mechanism is also desirable. What is needed in the art is a sport ball where the performance characteristics can be altered as desired.

SUMMARY OF THE INVENTION

[0004] The present invention relates to sport balls having integral pumps and containing a layer of energy absorbing foam material in at least one location, and a cover, and which also contain mechanisms for inflating or adding pressure to the balls. Preferably, the sport ball contains at least two types of foam and/or different thicknesses of foam wherein one type or area of foam absorbs more energy than at least one other type or area of foam on the ball. The energy absorbing

foam material maximizes performance, such as rebound, of the sport balls. The object is to be able to inflate or add pressure to a sport ball without the need for separate inflation equipment such as a separate inflation needle and pump.

[0005] Specifically, the invention relates to a sport ball that has a layer of energy absorbing foam in at least one location, and also has a self-contained pump device (or multiple pump devices) that is operable from outside the ball and which pumps ambient air into the ball to achieve the desired pressure. More specifically, the pump device preferably provides a chamber within the ball with means for admitting ambient air into the chamber and provides means for forcing that air from the chamber through a one-way valve means into the interior volume of the ball. In one preferred embodiment, the pump device most specifically comprises a piston and cylinder arrangement with the piston operable from outside the ball.

[0006] The present invention also relates to sport balls with integral self-contained inflation mechanisms and energy absorbing foam material in at least one location, and a cover on the ball, wherein the inflation mechanism is covered by a portion of the cover. The portion of the cover that covers the inflation mechanism may be hinged or may have other means of closing, such as hook and loop closure (for example, VELCRO™). The portion of the cover that covers the inflation mechanism may also have a foam layer that may be the same or different as any other foam layer on the ball.

[0007] Other objects of the invention will become apparent from the specification, drawings and claims.

BRIEF DESCRIPTION OF THE DRAWINGS

[0008] FIG. 1 shows a cross section of a portion of a sport ball with a foam layer and a self-contained pump operable from outside the ball for adding air pressure to the ball.

[0009] FIG. 2 is a side view of the piston shown in FIG. 1.

[0010] FIG. 3 is an isometric view of the cap for the pump of FIG. 1 showing the configuration for locking and unlocking the pump piston.

[0011] FIG. 4 shows one embodiment of a sport ball of the invention having a cover over the self-contained inflation mechanism.

[0012] FIG. 5 shows another embodiment of a sport ball of the invention having a cover over a different self-contained inflation mechanism.

DESCRIPTION OF THE PREFERRED EMBODIMENTS

[0013] Referring first to FIGS. 1 to 3 of the drawings, a portion of a sport ball 10 is illustrated incorporating the energy absorbing foam and one embodiment of a self-contained inflation mechanism of the invention. The ball that is illustrated is a typical soccer ball construction comprising a carcass having a rubber bladder 12 for air retention, a lining or winding layer 14 wrapped around the bladder, a foam layer 16, and an outer layer 18. The outer layer is preferably, but not necessarily, stitched. The outer layer preferably has a foam layer backing 16 or it may be a separate foam layer 16. For a laminated ball, there may be

an additional outer layer of leather, synthetic or composite leather panels. The panels may be applied by any process known in the art, such as by applying adhesive and setting by cold molding. The windings, if present, are preferably randomly oriented and two or three layers thick, and they form a layer which cannot be extended to any significant degree and which restricts the ball from expanding to any significant extent above its regulation size when inflated above its normal playing pressure. This layer for volleyballs and soccer balls is sometimes referred to as a lining layer instead of a winding layer, and it may be composed of cotton or polyester cloth that is impregnated with a flexible binder resin such as vinyl or latex rubber. A foam layer 16 is incorporated under the cover layer as previously described. This foam layer 16 is added to the sport ball of the invention control or to change the performance characteristics of the ball. For sport balls with panels, such as a soccer ball or volleyball, the foam layer 16 is incorporated under the panel, and the foam type and/or thickness may vary with each panel, or certain panels, as desired. Alternatively, some panels may have one type of foam while other panels may have another type and/or thickness of foam, depending on the desired properties of the ball, such as rebound height and rebound differential.

[0014] Materials suitable for use as the bladder include, but are not limited to, butyl, latex, urethane, and other rubber materials generally known in the art. Examples of materials suitable for the winding layer include, but are not limited to, nylon, polyester and the like. Examples of materials suitable for use as the outer layer, or cover, include, but are not limited to, polyurethanes, including thermoplastic polyurethanes; polyvinylchloride (PVC); leather; synthetic leather; and composite leather. Materials suitable for use as the foam layer include, but are not limited to, NEOPRENE™, SBR, TPE, EVA, or any foam material known in the art that is capable of high or low energy absorption. Examples of commercially available high or low energy absorbing foams include the CONFOR™ open-celled polyurethane foams available from Aearo EAR Specialty Composites, Inc., and NEOPRENE™ (polychloroprene) foams available from Dupont Dow Elastomers. Typical properties of CONFOR™ foams are shown in Table 1 below.

TABLE 1

uz,5/28 TYPICAL PROPERTIES OF CONFOR™ FOAMS					
Property	CF-47 Green	CF-45 Blue	C-42 Pink	CF-40 Yellow	CFNT Yellow
Density Nominal kg/m ³ (lb/ft ³)	93 (5.8)	96 (6.0)	91 (5.7)	93 (5.8)	80.1 (5.0)
Ball Rebound (%)	2.8	2.4	1.0	0.9	4.0
Therm. Cond.-K Value	.485	.485	.485	.485	.485
W/m*K (BTU in/hr ft ² F)	(0.28)	(0.28)	(0.28)	(0.28)	(0.28)
Compression Set (%) 22 hr at 70° C.,					
Compressed 25%	0.3	0.4	0.9	0.6	1.8
Compressed 50%	0.6	0.6	1.0	2.4	6.0
Indentation Force Def. 25% Deflection: 22° C. at 50% Relative Humidity	43	34	26	15	8
Tensile Strength kPa (psi) 51 cm/mm at 22° C.	174 (25.2)	154 (22.3)	125 (18.1)	101 (14.6)	41 (6.0)
Tear Strength kN/m (lbf/in)	0.96 (5.5)	0.81 (4.6)	0.60 (3.4)	0.28 (1.6)	0.26 (1.5)
51 cm/mm at 22° C.					

TABLE 1-continued

uz,5/28 TYPICAL PROPERTIES OF CONFOR™ FOAMS					
Property	CF-47 Green	CF-45 Blue	C-42 Pink	CF-40 Yellow	CFNT Yellow
Elongation (%) 51 cm/mm at 22° C.	98	108	109	135	149

Note: All test methods are ASTM D3574 except Therm. Cond. (ASTM C177)

[0015] Aearo EAR Specialty Composites, Inc. (EAR) performs a Ball Rebound % test (Resilience test) according to ASTM D3574. The Resilience test consists of dropping a steel ball from a specified height onto the foam and recording the rebound height of the ball. The value is recorded as a percentage of the original drop height. The following table provides Ball Rebound data and densities of some of these foams:

TABLE 2

REBOUND HEIGHT % and DENSITY OF FOAMS		
Type of Foam	Ball Rebound %- ASTM D3574	Density kg/m ³ (lb/ft ³) (ASTM D3574)
CF-47 Green	2.8	93 (5.8)
CF-45 Blue	2.4	96 (6.0)
CF-42 Pink	1.0	91 (5.7)
CF-40 Yellow	0.9	93 (5.8)
CFNT Yellow	4.0	80.1 (5.0)
NEOPRENE™	Not Available	*165 kg/m ³
TPE	Not Available	*135 kg/m ³

[0016] Note: A lower Ball Rebound % indicates a foam with higher energy absorbing capabilities. (The Ball Rebound % of NEOPRENE™ and TPE are not available.)
*The inventors determined these densities.

[0017] This invention proposes using at least one energy absorbing foam, and preferably two or more types and/or thicknesses of energy absorbing foams at specified locations in the ball to control the rebound height and rebound differential by increasing or decreasing the rebound height of the ball. The purpose or goal is to achieve a certain rebound height differential (the maximum rebound height minus the minimum rebound height), and preferably, to minimize the rebound height differential.

[0018] During testing of sport balls incorporating self-contained inflation mechanisms and foam layers, the inventors found that the ball exhibited an increased rebound height at the valve location. It was determined that using a foam with higher energy absorbing capabilities than the standard foam used in the foam layer (such as NEO-PRENE™ foams, which are polychloroprene foams available from DuPont Dow Elastomers) at the valve location would reduce the overall return flight of the ball, thus reducing the rebound height differential. If a greater rebound height is desired, utilizing a lower energy absorbing foam at the desired location, such as at the pump where the rebound height is generally lower, would allow the soccer ball to retain a larger amount of energy, which would increase the rebound at that location. The rebound height, and therefore rebound differential, can be controlled and optimized or minimized by selectively using different types and/or thicknesses of energy absorbing foams.

[0019] In one preferred embodiment, incorporated into the carcass of the ball of the invention during the formation is the rubber pump boot or housing **20** with a central opening and with a flange **22** which is bonded to the bladder using a rubber adhesive. The flange is located between the rubber bladder **12** and the lining layer or layer of windings **14**. The boot **20** and flange **22** may be constructed of any suitable material, such as butyl rubber, natural rubber, urethane rubber, or any suitable elastomer or rubber material known in the art, or combinations thereof. It is advantageous if the boot **20** and flange **22** are constructed of the same material(s) because the adhesion between them is improved if the materials are the same. Preferably, the boot **20** and flange **22** are constructed of natural rubber, butyl rubber, or a combination of both.

[0020] During manufacture of the sport balls, a molding plug may be inserted into the boot opening during the molding and winding process to maintain the proper shape central opening and to allow the bladder to be inflated during the manufacturing process. The molding plug is preferably aluminum, composite or rubber, most preferably aluminum. The central opening through the boot **20** is configured with a groove **24** to hold the flange **26** on the upper end of the pump cylinder **28**. The cylinder can optionally be bonded to the boot using any suitable flexible adhesive, such as, but not limited to, epoxy, urethane, cyanoacrylate, or any other flexible adhesive known in the art. The pump cylinder shown in **FIGS. 1 and 2** is a right cylinder, but other cylinders, such as a cylinder having a non-circular cross-section, may be used.

[0021] In the embodiment shown, located in the pump cylinder **28** is the pump piston **30** that is illustrated in both **FIGS. 1 and 2**. The piston includes a circular groove **32** at the bottom end which contains the spring **34** that forces the piston up in the cylinder **28**. Also at the bottom end of the piston **30** is an O-ring groove **36** containing the O-ring **38**. As seen in **FIG. 1**, this O-ring groove **36** is dimensioned such that the O-ring **38** can move up and down in the groove **36**. The O-ring is forced into the position shown in **FIG. 1** when the piston **30** is pushed down. In this position, the O-ring seals between the cylinder wall and the upper flange **40** of the groove **36**. As shown in **FIG. 2**, there are recesses or slots **42** in the groove **36** extending from just below the upper flange **40** down through the lower flange **44**. Only one of these slots **42** is shown in **FIG. 2** but there are preferably two or more. When the piston **30** is forced up by the spring **34**, the O-ring **38** moves to the bottom of the groove **36** which opens up a by-pass around the O-ring through the recesses **42** so that the air can enter the cylinder **28** below the piston **30**. Then, when the piston is pushed down, the O-ring moves back up to the top of the groove and seals to force the air out through the cylinder exit nozzle **46**.

[0022] At the upper end of the piston are the two flanges **48** which cooperate with the cylinder cap **50** to hold the piston down in the cylinder and to release the piston for pumping. The cylinder cap **50** is fixed into the top of the cylinder **28** and the piston **30** extends through the center of the cylinder cap. The cap is adhered to the cylinder. **FIG. 3** shows an isometric view of the bottom of the cylinder cap **50** and illustrates the open areas **52** on opposite sides of the central opening through which the two flanges **48** on the piston can pass in the unlocked position. In the locked position, the piston is pushed down and rotated such that the

two flanges **48** pass under the projections **54** and are rotated into the locking recesses **56**. Attached to the upper end of the piston **30** is a button or cap **58** which is designed to essentially completely fill the hole in the carcass and to be flush with the surface of the ball or slightly below the surface, depending on the type of sport ball. This button may be of any desired material such as cast urethane or rubber, such as SANTOPRENE™ rubber, natural rubber, butyl rubber and the like. Preferably, the button is formed from SANTOPRENE™ rubber, available from Advanced Elastomer Systems, Akron Ohio. In one preferred embodiment, the button or cap **58** is co-injected with the piston **30** as one part. Alternatively, the button or cap **58** may be co-injected with a connecting piece, and the button or cap **58** and connecting piece may then be attached to the upper end of the piston **30** using an adhesive suitable for bonding the two pieces together. Co-injecting the button **58** and the piston **30** as one part, or alternatively, the button **58** and the connecting piece (not shown) as one part that is mounted to the piston, provides a more durable part that is less likely to break or come apart during routine use of the ball. The button or cap material and the piston material need to be selected such that the two materials will adhere when co-injected. Testing of various combinations has shown that co-injecting or extruding a soft rubber button, such as a button comprising SANTOPRENE™, and a harder piston, such as polycarbonate or polypropylene and the like, provides a durable bond without the need for adhesives.

[0023] The upper surface of the button or cap **58** may be constructed to match the feel of the rest of the ball, if desired. The surface of the button or cap may be textured to increase grip if desired, such as for a basketball. For other balls, such as a soccer ball, the surface may be smooth. For basketballs, it is preferable if the button and pad are flush with the surface, or essentially flush with the surface. For other balls, such as footballs, soccer balls and volleyballs, the button and pad may be slightly recessed.

[0024] In a preferred embodiment, fibers or other reinforcing materials may be incorporated into the rubber compound or thermoplastic material used for the button **58** during mixing. Examples of fiber materials suitable for use include, but are not limited to, polyester, polyamide, polypropylene, KEVLAR™, cellulosic, glass and combinations thereof. Incorporation of fibers or other reinforcing materials into the button or cap improves the durability of the button and improves the union of the button or cap and the piston rod, thus preventing the button or cap **58** from shearing off during use. Although the pump would still function without the button, it becomes very difficult to use.

[0025] The piston and the connecting piece may be formed of any suitable material, such as, but not limited to, polycarbonate, polypropylene (preferably high impact polypropylene), nylon, ABS, polyphenylene oxide, and the like.

[0026] Any desired one-way valve can be used on the exit nozzle **46**. For example, a duckbill valve is a common type of one-way valve. Other types of one-way valves may also be used, as long as the valve functions to keep air inside the ball as desired. The one-way valve preferably functions in the conventional manner where inlet air pressure forces the valve open to admit air while the air pressure inside of the ball squeezes the valve closed to prevent the leakage of air.

[0027] A pump assembly of the type described and illustrated in **FIGS. 1 to 3** is made from materials known in the

art. Examples of preferable materials include plastics such as polystyrene, polyethylene, nylon, and polycarbonate, and combinations thereof. Although the assembly is small and light weight, perhaps only about 5 to about 25 grams, it is desirable that a weight be added to the ball structure to counterbalance the weight of the pump mechanism. In a lighter weight or smaller ball, such as a soccer ball, the pump assembly may weigh less and/or be smaller (shorter) than a corresponding pump assembly for a heavier ball, such as a basketball. If a counter weight is used, the ball may have a pump mechanism on one side of the ball and a standard needle valve on the opposite side of the ball where the material forming the needle valve is weighted. Additional material can be added to the needle valve housing or the region surrounding the valve. Alternatively, a dense metal powder such as tungsten could be added to the rubber compound. Other counterweight options may also be used as desired.

[0028] Examples of other pump arrangements that may be used with the invention are shown in co-pending application Ser. No. 09/560,768, filed Apr. 28, 2000, and U.S. Pat. Nos. 6,422,960 and 6,450,906, incorporated herein by reference.

[0029] Since the pressure in a sport ball can be too high through overinflation or a temperature increase, it is advisable to have a way to bleed pressure from the ball when the conventional inflating needle is not available. One example of such an arrangement may include a bleeding aperture through the carcass of the ball, such as that shown in U.S. Pat. Nos. 6,287,225 and 6,409,618, incorporated herein by reference. Alternatively, the pump may have a mechanism that allows the pressure to be relieved, either through action of the pump, or through the use of a relief mechanism built into the pump, such as a mechanism to open the one-way valve if desired to allow air to flow out of the interior of the ball.

[0030] Some sport balls have covers over the self-contained inflation mechanism, and the covers remain closed while the ball is being used. For other balls, there may be no cover over the pump. **FIG. 4** illustrates one embodiment of a sport ball having a cover over the self-contained inflation mechanism. As shown, a flap or panel **136** covers the ball opening. This flap or panel **136** may be held in place by VELCRO™ tape or fabric **138** to prevent it from opening during use. Once the flap has been opened, the pump would be usable. In this embodiment, a flip up pull ring **134** is attached to the upper end of the piston rod. To operate the pump, the pull ring is flipped up, and using a pumping action, air is added to the ball.

[0031] Other variations of the pump and cover may be used as well. For example, **FIG. 5** shows a pump having a button or cap, as shown in **FIG. 1**, except that a foam plug **280** fits on top of the button or cap (which is recessed or below the surface of the ball) to improve the feel of the ball in the area of the pump. One panel **236** is stitched to the adjacent panel on one side **288**. The panel or cover has a cover material **282**, such as leather or polyurethane, a foam layer **284**, a fabric layer under the foam layer **286**, and a hook and loop (VELCRO™ layer) **238** adhered to the fabric layer. A hook and loop layer **238** is also located on the ball. Other variations of the cover may also be used, such as, for example, rotating locks. Preferably, the flap or panel, if desired, is held in place with a hook and loop closure system, such as VELCRO™.

[0032] Sport balls used in competition often must meet certain specifications. For example, the National Basketball Association (NBA) has certain guidelines or specifications that a regulation basketball must meet, such as size, pressure, rebound height differential, and the like. A regulation soccer ball is currently tested against Federated International Football Association (FIFA) specifications in order to qualify as a "FIFA Approved" or "FIFA Inspected" ball. An equivalent certification process is the International Match-ball Standard. Some of the tests used by FIFA to determine if a soccer ball is suitable for play include circumference, weight, air retention, rebound, water absorption, durability and balance.

[0033] The test methodology for rebound of soccer balls requires that the ball be inflated to 0.8 bar, which is equivalent to 11.6 PSI. The ball is then dropped from 2 meters (78.7 inches) onto a steel plate. The rebound is then recorded by comparing the height of the bottom of the soccer ball (a light can be positioned so the shadow can be recorded) to a fixed scale against the wall. FIFA drops the ball 10 times on the center of different panels. The FIFA Approved level of certification requires that the ball rebounds no less than 120 cm (47.24") and no higher than 165 cm. (64.96"). FIFA allows a differential of 10 cm. (3.94") between the highest and lowest rebound. Early prototypes of the pump soccer ball had a wide rebound distribution. The maximum rebound height minus the minimum rebound height was typically 6 inches or greater, but under a more rigorous testing regimen. Spalding's test consists of 3 to 5 drops at the following locations: the pump, valve, and 90 degrees away from the pump. In addition, the method involves testing from the pump location to a distance five inches away from the pump, in two directions (denoted right and left) in one half to one-inch increments. The inventors found that this test methodology provides a worst case scenario for the rebound differential and allows for a superior product to be created.

EXAMPLES

[0034] As previously mentioned, early pump soccer ball prototypes had wide variations in maximum minus minimum rebound heights (the rebound differential). The greatest rebound height was observed at the valve location. This increased rebound height at the valve raised the maximum minus minimum rebound height considerably. Samples were made with the CONFOR™ foams at the valve location. The data shown in Tables 3 and 4 below shows that the maximum minus minimum rebound heights of a ball with 100% NEOPRENE™ foam at all locations had a higher rebound differential than a ball having two types of energy absorbing foam: 6 mm. of CONFOR™ foam at the valve of the ball and NEOPRENE™ at all other locations. The rebound differential improved from 6" to 4" with the use of the CONFOR™ foam at the valve. The CONFOR™ foam is an example of a high energy absorbing foam, and this type of foam absorbs more energy than other types of foam, such as the NEOPRENE™ foam. The decrease in the ball's energy leads to a lower overall return rebound. It has been determined that the use of 6 mm of TPE foam can also decrease the rebound height of the ball by absorbing more energy than other foams, such as NEOPRENE™ foam.

[0035] By contrast, the pump location on a soccer ball exhibited lower rebound heights than other locations on the same ball. A lower energy absorbing foam at the pump

location would allow the soccer ball to retain a larger amount of energy, which would increase the rebound at the pump.

[0036] The use of multiple types and/or thicknesses of foams is a considerable improvement over the ball with only a single type of foam. By placing foams having varying energy absorption capabilities at different locations around the ball, the maximum minus minimum rebound differential can be controlled and optimized or minimized.

[0037] A soccer ball inflated to 11.6 psi that had 100% NEOPRENE™ was tested by dropping the ball from a height of 2 meters (78.74 inches) and measuring the rebound height at various locations. The ball was a standard soccer ball (size 5) with a pump installed. A counter weight was installed opposite the pump. The weight of the finished ball, as tested, was 430.3 grams (including the tape to mark the test spots). Rebound data is shown in Table 3 below.

TABLE 3									
SOCCER BALL WITH 100% NEOPRENE™ FOAM PANELS									
Location on ball	Ht. (in.)	Ht. (in.)	Ht. (in.)	Ht. (in.)	Ht. (in.)	Ht. (in.)	Ht. (in.)	Ht. (in.)	Ht. (in.)
Valve	55	56	56	56	56	56	56	56	56
Pump	52	52	52						
90 Left (7")	52	52							
90 Right (7")	52	52							
1" Right of Pump	50	50	50						
1.5" Right	50	50							
2" Right	52	52							
2.5" Right	54	54	54	54	54				
3" Right	54	54	54	54	54				
4" Right	53	54	54						
5" Right	52	54	54						
1" Left of Pump	51	52							
1.5" Left	50	50							
2" Left	54	52	54	54					
2.5" Left	54	53	52	54	54				
3" Left	54	54	54	54	54				
4" Left	54	54	54						
5" Left	54	54	54						

[0038] Table 3 shows that the rebound height of a ball having only one type and thickness of foam, 6 mm of NEOPRENE™ at all locations, varied from 50 inches to 56 inches (a rebound differential of 6 inches).

[0039] The second ball, which had 6 mm of CONFOR™ foam at the valve location and 6 mm NEOPRENE™ foam at all other locations was tested in the same manner as the above ball. Rebound height was again measured according to the same procedure. Results are shown in Table 4 below.

TABLE 4					
SOCCER BALL WITH CONFOR™ FOAM AT VALVE					
Location on ball	Ht. (in.)	Ht. (in.)	Ht. (in.)	Ht. (in.)	Ht. (in.)
Valve	50	50	50	50	52
Pump	50	51			
90 Left (7")	52	52			
90 Right (7")	50	52			
1" Right of Pump	50	52			
1.5" Right	52	50			
2" Right	50	50			
2.5" Right	52	52	50	52	51
3" Right	54	54	54	54	
4" Right	54	54	53	54	
5" Right	53	52	53		
1" Left of Pump	52	52			
1.5" Left	51	52			
2" Left	50	50			
2.5" Left	54	52	54	54	
3" Left	54	53	52	54	54
4" Left	54	54	54	54	
5" Left	54	54	54	54	

[0040] Table 4 shows that the rebound height varied from 50 inches to 54 inches, for a rebound differential of 4 inches. Adding 6 mm of the high energy absorbing foam, CONFOR™, at the valve location reduced the rebound height at this location, thereby lowering the rebound differential. Additional foam types or different thicknesses of foam may be used at other locations to control the rebound differential, as desired.

[0041] Additional soccer balls with pumps and having varying foam types and thicknesses were also constructed. Two actual production soccer balls were compared. The first ball had 5 mm of 100% NEOPRENE™ foam at the pump panel, 6 mm of 100% TPE foam at the valve panel, and the remainder of the panels comprised 2 mm of TPE foam and 4 mm of SBR foam. The second soccer ball had the same construction except for the foam layout. The second ball had 5 mm of 100% NEOPRENE™ at the pump panel, and 6 mm of 100% TPE at the rest of the panels. All other parts, such as the cover material, boot material, pump, etc. were the same in both balls. The second ball is a lower cost version of the first ball and has the same rebound differential and good rebound properties, although the rebound range was 4 inches lower than the first ball (rebound of 42 to 50 inches vs. 46 to 54 inches for the first ball). The addition of the SBR foam to the first ball, where a combination of SBR and TPE foam was used, improved and increased the rebound height significantly. Results of the rebound test are shown in Table 5 below.

TABLE 5							
SOCCER BALLS WITH VARYING FOAM PANELS							
Location on ball	Ball 1 Ht. (in.)	Ball 1 Ht. (in.)	Ball 1 Ht. (in.)	Ball 1 Ht. (in.)	Ball 2 Ht. (in.)	Ball 2 Ht. (in.)	Ball 2 Ht. (in.)
Valve	52	53			48	49	
Pump	50	51			46	47	
90 Left (7")	52	53			48	48	
90 Right (7")	52	52			48	48	

TABLE 5-continued

SOCCER BALLS WITH VARYING FOAM PANELS								
Location on ball	Ball 1 Ht. (in.)	Ball 1 Ht. (in.)	Ball 1 Ht. (in.)	Ball 1 Ht. (in.)	Ball 2 Ht. (in.)	Ball 2 Ht. (in.)	Ball 2 Ht. (in.)	Ball 2 Ht. (in.)
1" Right of Pump	46	46			42	42	42	
1.5" Right	48	48			43	44		
2" Right	52	51			48	49		
2.5" Right	54	53	54	54	50	50	50	
3" Right	53	53	54	54	49	49	48	
4" Right	53	54			48	48		
5" Right	52	53			47	48		
1" Left of Pump	46	46			42	42		
1.5" Left	46	48			45	46		
2" Left	52	52			49	50		
2.5" Left	53	54	54	54	50	48	48	50
3" Left	52	52	54		48	48	48	
4" Left	52	53			48	48		
5" Left	52	53			48	48		

Note: Balls are dropped from 2 meters (78.74 inches), inflated to 11.6 psi.

[0042] Two different volleyballs having pumps were also constructed and tested. The first ball had 5 mm of 100% TPE foam at all panel locations. The second ball had 5 mm of 100% NEOPRENE™ foam at the pump panel and the two panels surrounding the pump, and the valve and remaining panels had 4.5 mm of 100% TPE foam. All other parts, such as the cover material, boot material, pump, etc. were the same in both balls. The first ball, which has the same foam at all panels, is a lower cost version of the second ball. The first ball, which had a layer of foam comprising only one type and one thickness, had a larger rebound differential than the second ball (14 inches). By varying the foam and using two types and thicknesses of foam in the second volleyball, the rebound differential decreased by 5 inches (to 9 inches). Results of the rebound test are shown in Table 6 below.

TABLE 6

VOLLEYBALLS WITH VARYING FOAM PANELS					
Location on ball	Ball 1 Ht. (in.)	Ball 1 Ht. (in.)	Ball 2 Ht. (in.)	Ball 2 Ht. (in.)	Ball 2 Ht. (in.)
Valve	57	59	64	65	
Pump	53	55	60	61	
1" Right of Pump	49	50	60	58	
1.5" Right	51	51	58	57	
2" Right	56	58	59	60	
2.5" Right	60	60	62	62	64
3" Right	62	61	62	62	62
5" Right	61	61	64	64	64
1" Left of Pump	49	48	56	56	
1.5" Left	52	51	56	56	
2" Left	55	57	56	58	
2.5" Left	61	61	60	64	64
3" Left	59	60	62	64	64
5" Left	57	58	62	63	
Random Drops	60	60			

Note: Balls are dropped from 100 inches onto a wooden platform, inflated to 5 psi.

[0043] As Table 6 indicates, the second volleyball, which had 5 mm of NEOPRENE™ foam at the pump and the two surrounding panels, and 4.5 mm of TPE foam at the valve,

had a higher overall rebound range than the first ball, but the differential was significantly reduced (from 14 inches to 9 inches). This example used the NEOPRENE™ foam as a low energy absorbing foam, as compared to the TPE foam. Since less energy was absorbed at the pump and surrounding panels by the NEOPRENE™ foam than by the TPE foam, the ball retained more energy and the rebound height was greater and also improved dramatically (56 to 65 inches vs. 48 to 62 inches). The first ball, which used only one type and thickness of the energy absorbing foam, had a lower rebound height.

[0044] The foregoing description is, at present, considered to be the preferred embodiments of the present invention. However, it is contemplated that various changes and modifications apparent to those skilled in the art may be made without departing from the present invention. Therefore, the foregoing description is intended to cover all such changes and modifications encompassed within the spirit and scope of the present invention, including all equivalent aspects.

1. An inflatable sport ball comprising an integral pump inside the ball, wherein the sport ball comprises a layer of energy absorbing foam in at least one location on the ball, and wherein the sport ball further comprises a cover.
2. An inflatable sport ball as recited in claim 1 wherein said layer of foam covers essentially the entire ball.
3. An inflatable sport ball as recited in claim 1 wherein said ball includes at least two different types or thicknesses of energy absorbing foam at different locations of the ball.
4. An inflatable sport ball as recited in claim 3 wherein at least one type of foam absorbs more energy than at least one other type of foam.
5. An inflatable sport ball as recited in claim 3 wherein said sport ball comprising at least two types or thicknesses of energy absorbing foam has a lower rebound differential than a sport ball having all other components the same except the foam types or thicknesses.
6. An inflatable sport ball as recited in claim 1 wherein said cover comprises a portion that covers said pump.
7. An inflatable sport ball as recited in claim 1 wherein said pump includes means for pumping ambient air into said ball and means for preventing said pumped air from escaping out of said ball.
8. An inflatable sport ball as recited in claim 1 wherein said sport ball is a volleyball or soccer ball.
9. An inflatable sport ball comprising an internal pump, further comprising a layer of energy absorbing foam in at least one location on the ball, said pump including a cylinder having an air outlet into said ball, a one-way valve attached to said air outlet permitting air flow from said cylinder into said ball and preventing air flow from said ball back into said cylinder, means for drawing ambient air from outside said ball into said cylinder and to force said drawn ambient air from said cylinder through said one-way valve into said ball and further including means for operating said pump from outside said carcass, and wherein the sport ball further comprises a cover.
10. An inflatable sport ball as recited in claim 9 wherein said means for actuating said pump comprise a piston having a piston rod attached to said piston and extending through an opening in said carcass and movable between an extended position and an inserted position, and further including means for locking said piston rod in said inserted position.

11. An inflatable sport ball as recited in claim 9 wherein said layer of foam covers essentially the entire ball.

12. An inflatable sport ball as recited in claim 9 wherein said ball includes at least two different types or thicknesses of foam at different locations of the ball.

13. An inflatable sport ball as recited in claim 12 wherein at least one type of foam absorbs more energy than at least one other type of foam.

14. An inflatable sport ball as recited in claim 12 wherein said sport ball comprising at least two types or thicknesses of energy absorbing foam has a lower rebound differential than a sport ball having all other components the same except the foam types or thicknesses.

15. An inflatable sport ball as recited in claim 9 and further including means attached inside said ball to counterbalance the weight of said internal pump.

16. An inflatable sport ball as recited in claim 9 and further including means for bleeding air pressure from said ball.

17. An inflatable sport ball as recited in claim 9 wherein said sport ball is a volleyball or soccer ball.

18. An inflatable sport ball comprising an integral pump inside the ball and a cover, wherein the sport ball comprises a layer of energy absorbing foam comprising at least two different types or thicknesses of foam, and one type or thickness of foam absorbs more energy than at least one other type or thickness of foam, wherein the sport ball has a lower rebound differential than a sport ball having all other components the same except the foam types or thicknesses.

19. An inflatable sport ball as recited in claim 18 wherein said sport ball is a volleyball or soccer ball.

20. An inflatable sport ball as recited in claim 18 wherein said cover comprises a panel that covers said pump.

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