

Title (en)
Method and device for stacking blanks.

Title (de)
Verfahren und Vorrichtung zum Stapeln von Platten.

Title (fr)
Procédé et dispositif d'empilage de plaques.

Publication
EP 0006771 A1 19800109 (FR)

Application
EP 79400274 A 19790427

Priority
FR 7818810 A 19780623

Abstract (en)
1. Method of using an apparatus for receiving and stacking sheets with a view to their removal at the outlet of a production or processing machine which operates continuously, such a machine processing sheets which are capable of undergoing a change of format at least once, the said apparatus being of the type using, between the outlet (3) of the machine which is delivering and the station (14) at which the stack is formed, a system with at least two endless conveyors, a first conveyor (1) receiving at its upstream end the sheets issuing from the machine which is delivering, and discharging them at its downstream end onto a second conveyor (2) which itself discharges them to the station where the stack is formed, the said apparatus also being equipped with means allowing a stack to be transferred, these means allowing a stop device (13) to be interposed at the outlet of the second conveyor (2) when a stack is completed, the speed of this latter conveyor to be reduced or brought to zero, the completed stack to be removed, and lastly the stop device (13) to be retracted and the normal speed of the second conveyor (2) to be re-established when the stacking station (14) is ready to receive a new stack, characterised in that it consists in tracking, from its arrival on the said receiving and stacking apparatus (1), the path of the last sheet (19) of a first format and in initiating a stack transfer when the said sheet has left the second conveyor (2), and in that, additionally, the operating speed of the first conveyor (1) is increased when the said last sheet (19) of a first format has been received and this speed then reduced to a lower value than its normal value when the said last sheet has left this first conveyor.

Abstract (fr)
Procédé d'utilisation des récepteurs automatiques en long équipant les onduleuses à fonctionnement continu, tel que par exemple le récepteur selon le brevet français no. 76-21 112. Selon l'invention, on suit, dès son arrivée sur le récepteur, le trajet de la dernière plaque d'un premier format et on déclenche un changement de pile lorsque cette dernière plaque a quitté le dernier transporteur (2) du récepteur. Par ailleurs, on arrête toute rétraction du dispositif télescopique situé à l'aval du premier transporteur (1) dudit récepteur. L'invention trouve son application pour la fabrication de plaques de carton ondulé.

IPC 1-7
B65H 43/00; **B65H 29/66**; **B65H 31/32**; **B65H 33/12**

IPC 8 full level
B65H 29/66 (2006.01); **B65H 31/32** (2006.01); **B65H 33/12** (2006.01); **B65H 43/00** (2006.01)

CPC (source: EP)
B65H 29/66 (2013.01); **B65H 31/32** (2013.01); **B65H 33/12** (2013.01); **B65H 43/00** (2013.01); **B65H 2701/1762** (2013.01)

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Designated contracting state (EPC)
DE GB IT

DOCDB simple family (publication)
EP 0006771 A1 19800109; **EP 0006771 B1 19811014**; DE 2960976 D1 19811224; FR 2435429 A1 19800404; FR 2435429 B1 19811106

DOCDB simple family (application)
EP 79400274 A 19790427; DE 2960976 T 19790427; FR 7818810 A 19780623