

Title (en)

Counter and splitter device for bars in layers, particularly for final packing of rolling mill products.

Title (de)

Vorrichtung zum Zählen und Trennen von Stangen in Schichten, insbesondere zum Verpacken von Walzwerkprodukten.

Title (fr)

Dispositif de comptage et séparation de barres en couches, en particulier pour l'emballage de produits laminés.

Publication

EP 0474997 A1 19920318 (EN)

Application

EP 91110809 A 19910629

Priority

IT 8346590 A 19900906

Abstract (en)

Splitter device (1) for bars in layers, particularly for final packing of rolling mills with layers line up device, of the type that includes on one supporting and conveying plane layers of bars advancing crosswards (2): bars line up devices (32), suitable to flatten the layer of bars, aligning them and arranging them parallel on the same plane; photoelectric cell devices (8) to detect and count the number of advancing bars, devices supplied on one side with means for the emission of orthogonal infrared rays through the bars being counted (8a), and on the other side with means for the detecting of such rays; bars splitters devices getting through the layer of overlapped bars to separate them; characterized by the fact that such means for detecting and counting advancing bars include: pulse devices (32i) corresponding to the space of cross advancing of the bars to be counted and separated, together with photocell counter devices (8, 8a, 8b), connected to a data processing device (MP), such data processing device (MP) being: connected to issue instructions to the bars advancing system and to the splitter devices for advancement and stop and/or speed variation; programmed to elaborate data received by such pulse devices (32i) and such photoelectric cell devices (8, 8a, 8b) to count a pre-set number of bars, and after the advancement stop command, to issue a signal to the bars splitter (5-7) to separate the upwards bars (1) from the downwards ones and reissue a signal of advancement to the bars downwards (4) to discharge them (12) in a packing pocket (6) and afterwards restart the advancement and the counting of the bars upwards, being foreseen that the photoelectric cell devices (8a-8b) issue two successive signals too far apart (2l, 3l, ..., nl), proportional to the advancement (nl) supplied by the pulse devices in such interval if compared to a preset value (1) equal to the shade of a bar that is supplied by dividing the respective number of bars (nl/l=number of bars). <IMAGE>

IPC 1-7

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IPC 8 full level

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CPC (source: EP)

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Citation (search report)

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