

Title (en)

Method and apparatus for making a given number of full cross-wound bobbins on a cross winding machine

Title (de)

Verfahren und Vorrichtung zum Herstellen einer vorgebbaren Anzahl voller Kreuzspulen auf einem Kreuzspulen herstellenden Automaten

Title (fr)

Procédé et dispositif pour la fabrication d'un nombre donné de bobines pleines croisées sur une machine de bobinage à spires croisées

Publication

**EP 0569772 B1 19970122 (DE)**

Application

**EP 93106780 A 19930427**

Priority

DE 4216097 A 19920515

Abstract (en)

[origin: EP0569772A2] The object of the invention is to propose such a method and an apparatus for carrying it out, as a result of which a simplified control of a batch end, with the aim of as many full cross-wound bobbins as possible, is possible. This object is achieved, according to the invention, in that the predeterminable number of full cross-wound bobbins is divided by the number of winding stations of the machine producing cross-wound bobbins. In the event of a non-integral quotient, the latter is rounded up and down to integral values with an upper and a lower limit value, the sum of all the rounded-up and rounded-down values being equal to the predeterminable number. Such a value is predetermined to each winding station. The winding stations are put out of operation after the values have been reached. The machine producing cross-wound bobbins possesses storage locations for storing the acquired number of finished cross-wound bobbins per winding station. An input device for the input of desired values of the number of cross-wound bobbins of individual winding stations is coupled to a circuit for putting the winding stations out of operation when the desired value is reached. A cross-winding machine advantageously possesses a closed transport system for trolleys which carry the cops and tubes.  
<IMAGE>

IPC 1-7

**B65H 67/06**

IPC 8 full level

**D01H 9/18** (2006.01); **B65H 63/08** (2006.01); **B65H 67/06** (2006.01); **D01H 13/00** (2006.01)

CPC (source: EP US)

**B65H 63/08** (2013.01 - EP US); **B65H 67/06** (2013.01 - EP US); **B65H 2701/31** (2013.01 - EP US)

Designated contracting state (EPC)

CH DE IT LI

DOCDB simple family (publication)

**EP 0569772 A2 19931118**; **EP 0569772 A3 19940615**; **EP 0569772 B1 19970122**; DE 4216097 A1 19931118; DE 59305199 D1 19970306; JP H06108325 A 19940419; US 5398878 A 19950321

DOCDB simple family (application)

**EP 93106780 A 19930427**; DE 4216097 A 19920515; DE 59305199 T 19930427; JP 11284093 A 19930514; US 6207393 A 19930514