

Title (en)
METHOD AND DEVICE FOR FOLDING SHEET PILES

Title (de)
VERFAHREN UND VORRICHTUNG ZUM FALZEN VON BLATTSTAPELN

Title (fr)
PROCEDE ET DISPOSITIF DE PLIAGE DE PILES DE FEUILLES

Publication
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Application
EP 98910647 A 19980211

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Abstract (en)
[origin: DE19706517A1] The invention relates to a method for folding sheet piles, which may consist of one or more sheets, in which the sheets may have different folding resistances. This method ensues by means of chronologically successive, cyclic feeding, consisting of movement phases and pauses, of a plurality of sheet piles to the folding equipment. In this method, a pile-folding resistance is first of all determined for a particular sheet pile, from at least the number and/or the folding resistance of the individual sheets constituting the sheet pile. The sheet pile in question is then folded, the folding equipment's speed in folding said sheet pile being guided by the pile-folding resistance determined for this particular sheet pile. In each case, this guiding of the folding speed of the folding equipment ensues during the movement pauses in the cyclic feeding. In the case of a reduction in folding speed, the movement pause is extended for the folding of the next sheet pile that is to be folded, should the necessary folding speed reduction not be achieved during the normal movement pause in the cyclic feeding. Conversely, in the case of an increase in folding speed, depending on the time requisites, either the movement pause is extended for folding the next sheet pile, should the necessary folding speed increase not be achieved during the normal movement pause of the cyclic feeding, or the movement pause is not extended, even though the necessary folding speed increase is not achieved during the normal movement pause.

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