

Title (en)  
METHOD AND ARRANGEMENT FOR THE PRODUCTION OF CROSSED STACKS

Title (de)  
VERFAHREN UND VORRICHTUNG ZUR HERSTELLUNG VON KREUZSTAPELN

Title (fr)  
PROCEDE ET DISPOSITIF DE PRODUCTION DE PILES EN CROIX

Publication  
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Application  
**EP 01957673 A 20010813**

Priority  
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Abstract (en)  
[origin: US2003185663A1] Flat objects (7) to be stacked in a stacking device (2) are supplied serially, individually held and aligned with one another. Cross stacks (12) are produced by subjecting alternating groups (11, 11') of the such supplied objects (7) to one of two step sequences, wherein, in both step sequences, the objects of the groups are released from held conveyance and are, in at least one of the step sequences, brought to the stacking device lying on a conveying surface (10.1, 10.1') in an imbricated formation, and wherein in the two step sequences a rotation difference of 180° around an axis perpendicular to the object surfaces is established between alternating groups (11, 11'). The objects (7) positioned in the stacking device in groups form a cross stack (12), without it being necessary, that the stacking device (2) or parts of it have to be rotated between groups of objects being positioned. This results in shorter cycle times and in a smaller number of moving parts. The stacking system is suitable in particular for producing cross stacks (12) made up of rectangular or square, folded printed products.

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