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(54) **Apparatus to establish a predetermined orientation of a surface of a workpiece**

(57) A reduction to the traveling motion of bottles (B1) along a delivery conveyor (12) in an intermittent motion decorating machine (10) is provided by one (66,68) of a pair of workpiece feed cams (66,68;70,72) rotatably supported in a side-by-side relation to rotate about spaced horizontal axes lying in a common horizontal plane. The workpiece feed cams (66,68;70,72) have feed cam tracks (66A,68A) for receiving cam followers (74,75) of each of plurality of horizontal bottle carriers (76). One of the feed cam tracks (66A,68A) reduces the speed of the bottle carriers (76) from a relatively high entry speed corresponding to the through put speed in the decorating machine (10) to the speed of the deliver conveyor for more

densely populating the delivery conveyor (12) with workpieces (B1). Carrier transfer members (52,53,54,55) at each of opposite ends of the workpiece feed cams (66,68) transfer the bottle carriers (76) from one to the other of the workpiece feed cam (66,68). A drive (14,15,21,38) rotates the workpiece feed cams (66,68), carrier return cams (70,72) and carrier transfer members (52,53,54,55). The decorating machine (10) is provided with a registration station (R) preceding spaced apart decorating stations (P1-PN). The registration station (R) includes a drive to reduce the clamping pressure by chucks (79) on a workpiece (B1) while establishing a predetermined orientation of each workpiece (B1) relative to the decorating stations (P1-PN).

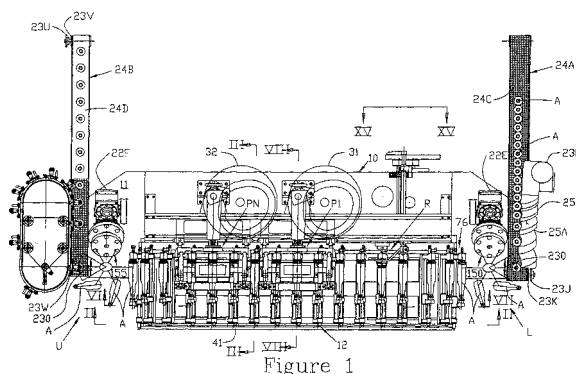


Figure 1



European Patent
Office

EUROPEAN SEARCH REPORT

Application Number
EP 07 12 1293

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Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (IPC)
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The present search report has been drawn up for all claims			
Place of search The Hague		Date of completion of the search 24 April 2008	Examiner Duquénoy, Alain
CATEGORY OF CITED DOCUMENTS X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document			

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**ANNEX TO THE EUROPEAN SEARCH REPORT
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This annex lists the patent family members relating to the patent documents cited in the above-mentioned European search report.
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