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- **FUJIKAWA, Takayuki**
Toyonaka-shi, Osaka 561-0841 (JP)
- **TSUJI, Hidenori**
Toyonaka-shi, Osaka 561-0841 (JP)

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(71) Applicant: **Yuyama Mfg. Co., Ltd.**
Toyonaka-shi,
Osaka 561-0841 (JP)

(74) Representative: **Spaargaren, Jerome et al**
Electronic Intellectual Property,
Fairfax House
15 Fulwood Place
London WC1V 6HU (GB)

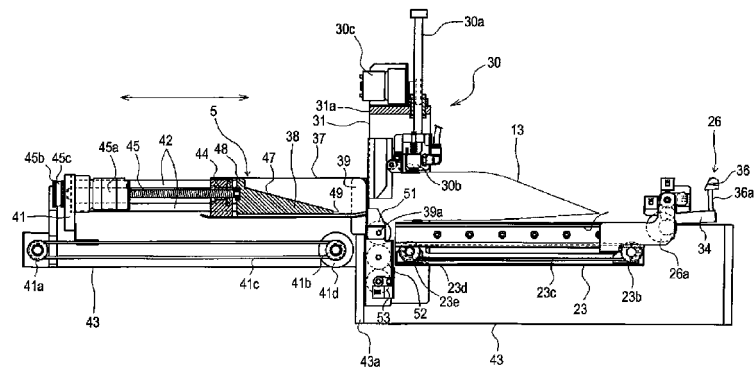
(72) Inventors:
• **YUYAMA, Shoji**
Toyonaka-shi, Osaka 561-0841 (JP)

(54) **MACHINE FOR FILLING BAG WITH MEDICINE**

(57) To quickly fill a bag with medicine without involving a fear of the medicine being damaged, a machine for filling a bag with medicine includes: a medicine bag positioning member (4) for effecting positioning on a machine bag (13), with an opening of the medicine bag (13) being open; and a bottom surface portion on which medicine (11) to be supplied can be placed, and includes: a first moving member (37) which reciprocates relative to the medicine bag (13) on which positioning is effected by the medicine bag positioning member (4) and which allows positioning at a supply position inside the medicine bag (13) and a waiting position outside the medicine bag (13); a second moving member (38) capable of reciprocating relative to the first moving member (37) or the medicine bag (13) and having a guide surface (47) guiding supplied medicine (11) to the bottom surface portion; and a drive-control means (59) which moves the first moving member (37) from the supply position to the waiting position relative to the medicine bag (13) and which maintains a positional relationship of the second moving member (38) with respect to the medicine bag (13), to thereby cause the medicine (11) supplied to the bottom surface portion by the guide surface (47) to remain in the medicine bag (13).

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FIG. 5



Description

Field of the Invention

[0001] The present invention relates to a machine for filling a bag with medicine in containers liable to suffer damage, such as ampoules.

Background of the Invention

[0002] In a conventionally well-known machine for filling a bag with medicine, medicine conveyed by a second belt conveyor is conveyed to a first belt conveyor while being gathered by a guide member, and is temporarily stopped by a shutter member before being charged into a bag (see, for example, Patent Document 1).

[0003] In another well-known machine for filling a bag with medicine, medicine conveyed by a belt conveyor is temporarily stopped by a shutter member while being gathered by a guide member, and is conveyed to a conveyor unit extending into a bag before retracting the conveyor unit from the bag, thereby charging the medicine into the bag (see, for example, Patent Document 2).

Patent Document 1: JP 2004-148033 A

Patent Document 2: JP 2005-153903 A

However, in both of the above-mentioned machines for filling a bag with medicine, medicine is gathered by a guide member, and hence it is necessary to convey the medicine by the belt conveyor slowly so as not to damage the medicine. Accordingly, it is impossible to charge medicine into the bag at high speed. Further, the medicine has to be conveyed by belt conveyors respectively provided at two positions, and it is necessary to provide each of the belt conveyors with a drive means such as a motor. This results in a rather complicated structure, which leads to an increase in cost.

[0004] It is accordingly an object of the present invention to provide a machine for filling a bag with medicine, which can quickly fill a bag with medicine without involving a fear of the medicine being damaged.

Summary of the Invention

[0005] As a means for solving the above-mentioned problem, the present invention provides a machine for filling a bag with medicine including: a medicine bag positioning member for effecting positioning, with a medicine bag being open; and a bottom surface portion on which medicine to be supplied can be placed, including: a first moving member which reciprocates relative to the medicine bag on which positioning is effected by the medicine bag positioning member and which allows positioning at a supply position inside the medicine bag and a waiting position outside the medicine bag; a second moving member capable of reciprocating relative to the first moving member or the medicine bag and having a guide

surface guiding supplied medicine to the bottom surface portion; and a drive-control means which moves the first moving member from the supply position to the waiting position relative to the medicine bag and which maintains a positional relationship of the second moving member with respect to the medicine bag, to thereby cause the medicine supplied to the bottom surface portion by the guide surface to remain in the medicine bag.

[0006] With this construction, when, in a state in which the supplied medicine is placed on the bottom surface of the first moving member, the first moving member and the second moving member are positioned in the bag, and solely the first moving member is retracted from the bag, it is possible to cause the medicine to remain inside the bag by virtue of the guide surface. That is, the first moving member and the second moving member are solely reciprocated relative to the bag. Thus, the drive mechanism is simple and relatively free from failure, and can be operated quickly. Further, it is possible to supply medicine into the bag solely by controlling the positional relationship of the two moving members with respect to the bag. Then, the medicine supplied into the bag together with the two moving members maintains its positional relationship with the bag. Thus, even when there are a plurality of medicines, there is no need to greatly change the positional relationship of the medicines, and it is possible to move the two moving members and the bag at high speed relative to each other. Thus, the medicines do not easily suffer damage, and can be quickly charged into the bag.

[0007] It is preferable that the machine for filling a bag with medicine further include a shutter member which allows positioning at an outflow preventing position where outflow of the medicine placed on the bottom surface portion of the first moving member is prevented, and at a medicine supply position where supply of the medicine placed on the bottom surface portion is allowed and where an opening portion inner edge of the medicine bag is pressed.

[0008] With this construction, the medicine supplied to the bottom surface of the first moving member via the guide surface of the second moving member can be temporarily stored by means of the shutter member. When supplying this medicine into the bag, it is possible to press the inner edge of the opening of the bag with the shutter member, and hence it is possible to secure the supply route for the medicine. Thus, the medicine can be smoothly supplied into the bag.

[0009] It is preferable that the second moving member include a detachment preventing portion which, when causing the medicine to remain in the medicine bag, prevents detachment of the medicine from the guide surface to an exterior of the medicine bag.

[0010] With this construction, the supply of medicine to the bottom surface of the first moving member can be effected smoothly via the guide surface of the second moving member; when the medicine is to remain in the bag, it is possible to reliably prevent detachment of the

medicine from the bag by the detachment preventing portion. Thus, the first moving member can be moved at relatively high speed, making it possible to perform the operation of filling a bag with medicine at still higher speed.

[0011] It is preferable that the second moving member include a climbing suppressing portion which, when causing the medicine to remain in the medicine bag, comes into contact with the medicine to suppress climbing of the medicine onto the guide surface.

[0012] With this construction, when the medicine is to remain in the bag, it is also possible to suppress climbing of medicine onto the guide surface by the climbing suppressing portion, and hence the movement of the medicine is minimized, making it possible to prevent damage still more properly. Further, since the medicine scarcely ever climbs onto the guide surface, it is possible to conduct the operation of filling a bag with medicine at still higher speed.

[0013] It is preferable that the machine for filling a bag with medicine further include a cover member which covers an upper portion of a medicine supply region formed by the first moving member and the second moving member, in which the cover member has a medicine charging port, which is opened to allow supply of the medicine onto the bottom surface portion via the guide surface by moving at least the second moving member to the waiting position, and makes the medicine incapable of being charged or escaping by moving the second moving member to the supply position.

[0014] With this construction, no new medicine can be charged through the charging port. Further, the medicine supplied through the charging port for supply medicine is made incapable of escaping from the charging port by moving the second moving member to the supply position afterwards. Thus, even if the first moving member is moved at high speed for causing the medicine supplied to the supply region to remain in the bag, it is possible to reliably prevent outward detachment.

[0015] It is preferable that the medicine bag positioning member include a medicine bag temporary stop portion for temporarily stopping the opening so that the medicine charged may become incapable of detachment from the medicine bag.

[0016] With this construction, even when the bag containing medicine is transferred to some other place, it is possible to prevent detachment of the medicine from the bag during or after the transfer. When it becomes necessary to extract the medicine from the bag for inspection or the like, the medicine can be easily extracted from the bag solely by cancelling the temporary stopping by the bag temporary stop portion.

[0017] Further, as a means for solving the above-mentioned problem, the present invention provides a machine for filling a bag with medicine including: a medicine bag positioning member for effecting positioning, with a medicine bag being open; a belt conveyor which makes a horizontal reciprocating movement between a supply po-

sition inside the medicine bag, where positioning is effected by the medicine bag positioning member, and a waiting position outside the medicine bag, and which is driven to run to supply medicine placed thereon into the medicine bag; a medicine charging member for charging medicine onto the belt conveyor; and a drive-control means which horizontally moves the belt conveyor to the waiting position, drives the medicine charging member to supply medicine onto the belt conveyor, and moves the belt conveyor to the supply position inside the medicine bag to run the belt conveyor, to thereby supply the medicine placed thereon into the medicine bag.

[0018] It is preferable that the medicine bag positioning member include, in addition to the above-mentioned construction, a medicine bag temporary stop portion for temporarily stopping the opening so that the medicine charged may become incapable of detachment from the medicine bag.

[0019] Still further, as a means for solving the above-mentioned problem, the present invention provides a machine for filling a bag with medicine including: a medicine bag positioning member for effecting positioning, with a medicine bag being open; a belt conveyor which is formed by stretching a belt between a pair of rotatable pulleys and a whole of which makes a horizontal reciprocating movement between a supply position inside the medicine bag, where positioning is effected by the medicine bag positioning member, and a waiting position outside the medicine bag; a medicine charging member for charging medicine onto the belt conveyor; a guide member for guiding the medicine charged by the medicine charging member onto the belt conveyor; and a drive-control means which horizontally moves the belt conveyor to the waiting position, drives the medicine charging member to supply medicine onto the belt conveyor via the guide member, and, after moving the belt conveyor and the guide member to the supply position inside the medicine bag, retracts solely the belt conveyor out of the medicine bag to prevent movement of the medicine by the guide member, to thereby cause the medicine to remain in the medicine bag.

[0020] According to the present invention, it is only necessary to reciprocate the first moving member and the second moving member relative to the bag, and hence the machine is simplified in construction, and can be produced at low cost. Further, since the medicine is caused to remain in the bag by retracting the first moving member from the bag, the medicine itself does not move much and is not easily damaged, and the bag filling operation can be conducted at high speed.

Brief Description of the Drawings

[0021]

Fig. 1 is a schematic front view of a machine for filling a bag with medicine according to an embodiment.
Fig. 2 is a plan view of Fig. 1.

Fig. 3 is a perspective view of a medicine supply portion of Fig. 1.

Fig. 4 is a perspective view of the medicine supply portion of Fig. 3 as seen from a different angle.

Fig. 5 is a front view of the medicine supply portion shown in Fig. 1.

Fig. 6 is a plan view of the medicine supply portion shown in Fig. 1 (waiting position).

Fig. 7 is a front view showing in detail a region including an ascent/descent member.

Fig. 8 is a front view showing in detail the region including the ascent/descent member.

Fig. 9 is a front view showing in detail the region including the ascent/descent member.

Figs. 10 part (a) is a plan view showing a state in which the outer container and the ampoule extruding member are moved to the supply position from the position of Fig. 6, and part (b) is a plan view showing a state in which solely the outer container is retracted from part (a).

Fig. 11 is a schematic explanatory view illustrating how medicine is supplied into the medicine bag.

Fig. 12 is a schematic explanatory view illustrating how medicine is supplied into the medicine bag.

Fig. 13 is a schematic explanatory view illustrating how medicine is supplied into a medicine bag in a machine for filling a bag with medicine according to another embodiment.

Fig. 14 is a perspective view showing an example of a first moving member and a second moving member of a machine for filling a bag with medicine according to another embodiment.

Fig. 15 is a schematic explanatory view illustrating how medicine is supplied into the medicine bag in a machine for filling a bag with medicine according to another embodiment.

Details of the Invention

[0022] In the following, an embodiment of the present invention is described with reference to the accompanying drawings.

General Construction

[0023] Figs. 1 and 2 schematically show a machine for filling a bag with medicine according to the embodiment. This machine for filling a bag with medicine has a machine main body 1, which mainly includes a medicine bag printing portion 2, a medicine bag conveying portion 3, a medicine bag positioning portion 4, a medicine supply portion 5, and a medicine charging portion 6.

Medicine Bag Printing Portion

[0024] The medicine bag printing portion 2 includes two upper and lower medicine bag printers 7, and strip-like medicine bags 9 are successively supplied to each

medicine bag printer 7 from a medicine bag roll 8. The strip-like medicine bags 9 include a plurality of successive bags each previously formed into a bag open in a direction opposite to the conveying direction; they are cut into unit bags by a cutter 10 provided at the outlet portion of the medicine bag printing portion 2. The strip-like medicine bags 9 are formed of a translucent material, allowing medicine 11 accommodated therein to be visually checked. Affixed to the surfaces of the strip-like medicine bags 9 are a plurality of labels for printing. Each medicine bag printer 7 prints patient name, medicine name, information on medicine taking (use, dosage, etc.) and the like on each label based on prescription data or the like input from a host computer 12. A medicine bag 13 obtained by cutting the strip-like medicine bags 9 by the cutter 10 is supplied to a conveyor portion 21 includes three belts 21a that can be driven in synchronism with each other, and are transferred to a predetermined position before undergoing positioning.

Medicine Bag Conveying Portion

[0025] As shown in Figs. 1 and 2, the medicine bag conveying portion 3 is constituted by a horizontal moving member 14, a vertical moving member 15, and a suction member 16.

[0026] The horizontal moving member 14 is formed by stretching a belt 14c between pulleys 14a, 14b respectively arranged on the right-hand and left-hand sides of the machine main body 1. The entire horizontal moving member 14 is retained by a horizontal frame member 17. When one pulley 14a is driven by a motor or the like (not shown) to rotate in normal/reverse rotating direction, the belt makes normal/reverse circulation movement, and the horizontal moving member 14 reciprocates in the X-axis direction.

[0027] The vertical moving member 15 is formed by stretching a belt 15c between pulleys 15a, 15b respectively arranged on the upper and lower sides of the machine main body 1; it is substantially of the same construction as the horizontal moving member 14 except that the reciprocating direction is changed to the vertical one. It should be noted, however, that the horizontal frame member 17 is fixed to the belt 14c of the horizontal moving member 14, and that the whole reciprocates in the vertical direction (Z-direction) as the vertical moving member 15 is driven.

[0028] The suction member 16 is mounted to the belt 15c of the vertical moving member 15 via a support arm 18. The suction member 16 is of a substantially I-shaped configuration and is constituted by a body portion 19 extending along the support arm 18 and suction portions 20 whose both end portions extend in two orthogonal directions. The body portion 19 is hollow, and is connected to a suction device (not shown); it is possible to suck the four corners of the medicine bag 13 through suction cylinders 21 downwardly extending from the distal ends (both ends) of each suction portion 20, thereby retaining

the bag. Further, as in the cases described above, the suction member 16 is reciprocated in the longitudinal direction (Y-axis direction) with respect to the support arm 18 by a longitudinal moving member constituted by pulleys and a belt.

Medicine Bag Positioning Portion

[0029] As shown in Fig. 4, the medicine bag positioning portion 4 includes a rotation plate 23, a medicine bag opening portion 24, a medicine bag temporary stop portion 25 (see Fig. 8), and a medicine bag retaining arm 26.

[0030] As shown in Figs. 5 and 6, the rotation plate 23 is rotated through driving of a motor 23a around a support shaft 23e via pulleys 23b, 23d and a belt 23c, and can be set in a horizontal position and an inclined position in which the distal end thereof is directed obliquely downwards. The rotating position of the rotation plate 23 is judged based on whether or not a shield plate 23b provided at a shaft portion intercepts the light path of a sensor 23c (light emitting element and light receiving element) provided in the machine main body 1. In the horizontal position, the rotation plate 23 allows charging of medicine 11 into the medicine bag 13 placed on the top surface thereof, and allows, in the inclined position, the medicine bag 13 to be supplied to a bucket 27. Guide grooves 28 are formed in both side surfaces of the rotation plate 23, and two elongated holes 29 are formed therein to extend along both side portions.

[0031] As shown in Figs. 5 and 8, the medicine bag opening portion 24 includes an ascent/descent member 30. The ascent/descent member 30 is provided in a gate-shaped support frame 31 fixed to a frame 43 (support portion 43a of rotation plate 23) so as to be capable of ascending and descending. The ascent/descent member 30 includes an ascent/descent plate 30b urged downwardly by a spring 30a. Further, the ascent/descent member 30 includes three rods 30a extending through an arch portion 31a of the support frame 31. Of the three rods 30a, the one situated at the center has a gear portion 30b, which is in mesh with a gear 30d provided on the rotation shaft of a motor 30c. As a result, when the motor 30c is rotated, the ascent/descent plate 30b ascends or descends via the rods 30a. The support portion 43a of the rotation plate 23 and the ascent/descent member 30 have at both ends suction ports 43b and 30f. The suction ports 43b and 30f are connected to a suction device (not shown) via a communication hole (not shown), and suck and retain from the outer side the opening portion of the medicine bag 13 placed on the rotation plate 23 in the horizontal position. When the ascent/descent member 30 is raised in this suction/retention state, the opening portion of the medicine bag 13 is opened. Further, the arch portion 31a of the support frame 31 supports a presser member 32 of a substantially L-shaped configuration so as to allow rotation around a support shaft 32a between an opening position and a retaining position. The presser member 32 is urged toward the opening po-

sition by a spring 32b fitted onto the support shaft 32a. Further, the presser member 32 includes with a roller 32c rolling on an inclined surface 33a and a vertical surface 33b of a guide portion 33 provided in the support frame 31. As a result, when the ascent/descent member 30 is raised, the roller 32c rolls on the inclined surface 33a, and the presser member 32 rotates counterclockwise around the support shaft 32a as shown in Fig. 8. When the roller 32c reaches the vertical surface 33b, the presser member 32 retains the upper inner surface of the opened medicine bag 13.

[0032] As shown in Fig. 4, the medicine bag temporary stop portion 25 is constituted by four heating portions 25a provided on the support portion of the rotation plate 23, and a roller 25b (see Fig. 7) rotatably provided on the ascent/descent member 30 so as to be opposed to each heating portion 25a. With the medicine bag 13 being positioned at a predetermined position on the rotation plate 23, the ascent/descent member 30 is lowered, and the opening portion of the medicine bag 13 is held between the heating portions 25a and the roller 25b to effect heating by supplying electricity to the heating portions 25a. Then, the opening portion of the medicine bag 13 is heat-sealed at four positions arranged at predetermined intervals in the width direction. In this case, the heat-sealed portions are arranged at such intervals as make it impossible or less liable for the medicine accommodated in the medicine bag 13 to be spilled out thereof. The heat sealing is effected to the degree that when the opening portion is pulled to both sides so as to extract the medicine 11 from the medicine bag 13, the heat-sealed portions are separated relatively easily to open the opening portion.

[0033] As shown in Fig. 5, the medicine bag retaining arm 26 is constituted by arm portions 34 that reciprocate along the guide grooves 28 of the rotation plate 23 and rotate around a support shaft 34a, and a connecting portion 35 connecting the two arm portions 34. Pressing portions 36 are provided at the two end portions of the connecting portion 35 through the intermediation of elastic portions 36a. The pressing portions 36 are formed of a material such as rubber which exhibits a large coefficient of friction with respect to the medicine bag 13. By driving the motor 26a, the medicine bag retaining arm 26 is rotated around the support shaft 34a, and the pressing portion 36 is brought into contact with the medicine bag 13 placed on the rotation plate 23. The elongated holes 29 of the rotation plate 23 are situated at the contact position of the pressing portion 36. Thus, when the rotation plate 23 is rotated to the inclined position, and the medicine bag retaining arm 26 is caused to slide, with the pressing portion 36 being at the contact position, it is possible to effectively apply the frictional resistance due to the pressing portion 36 to the medicine bag 13. As a result, the medicine bag 13 moves smoothly and obliquely downwards on the rotation plate 23 to be naturally supplied to the bucket 27.

[0034] As shown in Fig. 1, each bucket 27 is formed as a box open on the top side and has an outwardly ex-

tending flange portion 27a at the upper opening edge thereof. Further, a ridge 27b is formed on the bottom side portion of the outer surface of each bucket 27. Thus, when the buckets 27 are stacked together, the flange portion 27a of each bucket supports the ridge 27b of the upper bucket 27, thereby forming an accommodation space. The buckets 27 are supplied from the outside of the machine main body 1, and are conveyed to a position below the rotation plate 23. After the bags 13 are accommodated therein, the buckets are conveyed to the exterior of the machine main body 1 to be stacked together.

Medicine Supply Portion

[0035] As shown in Figs. 5 and 6, the medicine supply portion 5 includes an outer container 37 serving as a first moving member, an ampoule extruding member 38 serving as a second moving member, a shutter member 39, and a cover member 40.

[0036] The outer container 37 is formed as a box open on the top and front sides, and is fixed to a support member 41 via four slide shafts 42. A buffer member formed of urethane, sponge or the like is attached to the bottom surface of the outer container 37 so that the supplied medicine 11 may not suffer damage. The frictional resistance of the surface of this buffer member is minimized so that the medicine 11 may easily slide when the outer container 37 moves as described below.

[0037] The support member 41 is fixed to a belt 41c stretched between pulleys 41a, 41b. The pulleys 41a, 41b are rotatably supported by the frame 43 of the machine main body 1. One pulley 41b is driven by a motor 41d to rotate in the normal or reverse direction. As a result, the outer container 37 reciprocates in the directions indicated by the arrows in Fig. 5, and is positioned at a waiting position shown in Fig. 5 and a supply position shown in Fig. 10(a). Further, together with the outer container 37, a slider 58 reciprocates along a guide rail 57 provided on the frame 43. The slider 58 is provided for the purpose of effecting accurate positioning on the outer container 37 with respect to the frame 43. In an example of a specific construction for this purpose, a portion to be detected is provided to extend along the guide rail 57, and this portion to be detected is detected by a sensor provided on the slider.

[0038] At the rear of the outer container 37, there is provided a nut portion 44, which is threadedly engaged with a ball screw 45. The ball screw 45 is driven to rotate by the motor 45a via the pulleys 45b, 45d, and the belt 45c. Thus, when the motor 45a is driven to rotate the ball screw 45 in the normal or reverse direction, the position at which the nut portion 44 is threadedly engaged with the ball screw 45 is displaced in the axial direction. As a result, the outer container 37 reciprocates, and its positional relationship with the ampoule extruding member 38 described below varies. The upper edges of the forward ends of both side surfaces of the outer container 37 are formed in an arcuate configuration, thereby pre-

venting damage of the medicine bag 13 when medicine is inserted into the medicine bag 13.

[0039] The ampoule extruding member 38 is formed of a synthetic resin material, and is accommodated in the outer container 37, thereby forming a medicine storage region within the outer container 37. One end portion of the ball screw 45 is rotatably connected to the rear portion of the ampoule extruding member 38 through the inter-mediation of a bearing, and, at the same time, one end portion of each slide shaft 42 is connected thereto. As a result, the ampoule extruding member 38 reciprocates between the waiting position and the supply position together with the outer container 37. When, at the supply position, solely the outer container 37 is caused to retreat through rotation of the ball screw 45, it is possible to allow the medicine 11 in the medicine storage region to remain in the medicine bag 13.

[0040] As shown in Fig. 5, the ampoule extruding member 38 includes a guide surface 47, a detachment preventing portion 48, and a climbing suppressing portion 49.

[0041] The material, the surface roughness, and the inclination angle of the guide surface 47 are set such that the medicine 11, supplied from a tray 50 via a charging port 54, can be smoothly supplied. While in this case the guide surface 47 is formed as a flat surface, it is also possible to adopt some other form, such as a convex surface arcuate in section or a concave surface arcuate in section. When the guide surface 47 is formed as a convex surface, the tangential direction of the arc of its section becomes closer to the vertical direction on the bottom surface side of the outer container 37, and hence it is possible to eliminate the climbing suppressing portion 49.

[0042] The detachment preventing portion 48 is formed by a ridge protruding upwardly from the upper edge portion of the guide surface 47. As described below, by causing the outer container 37 to retreat relative to the ampoule extruding member 38, it is possible to prevent the medicine 11 supplied onto the bottom surface of the outer container 37 from moving in the reverse direction via the guide surface 47 to flow to the exterior.

[0043] The climbing suppressing portion 49 is formed by a vertical surface formed at the lower edge portion of the guide surface 47. When the outer container 37 is caused to retreat relative to the ampoule extruding member 38, the climbing suppressing portion 49 comes into contact with the medicine 11 supplied onto the bottom surface of the outer container 37, thereby preventing it from climbing onto the guide surface 47. When a material such as rubber of large coefficient of friction is used for the vertical surface forming the climbing suppressing portion 49, it is advantageously possible to more effectively prevent the medicine 11 from climbing onto the guide surface.

[0044] As shown in Fig. 5, the shutter member 39 is a plate-like member provided on the support portion of the rotation plate 23 so as to be rotatable around a support

shaft. A support shaft 39a includes a driven gear 51, and power is transmitted from a driving gear 53 provided on the rotation shaft of a motor (not shown) via an intermediate gear 52. As a result, the shutter member 39 rotates between a closing position where it closes front opening of the outer container 37 situated at the waiting position, and a retaining position where it is placed on the rotation plate 23 in the horizontal position and presses the lower inner surface of the medicine bag 13 whose opening is open.

[0045] As shown in Fig. 3, the cover member 40 is provided on the frame 43 of the machine main body 1 so as to cover the entire upper surface of the medicine supply portion 5, and has a charging port 54 to make it possible to supply the medicine 11 from the tray 50 to the medicine storage region. The charging port 54 is opened when the outer container 37 and the ampoule extruding member 38 are situated at the waiting position, making it possible to supply the medicine 11 to the medicine storage region via the guide surface 47 of the ampoule extruding member 38. When the outer container 37 and the ampoule extruding member 38 advance toward the supply position, the charging of medicine 11 into the charging port 54 becomes impossible.

Medicine Charging Portion

[0046] As shown in Fig. 1, the medicine charging portion 6 includes a lifter 55 and a swinging arm 56.

[0047] The lifter 55 causes a support stand 55b to ascend and descend through driving a belt 55a arranged to extend in the vertical direction. The swinging arm 56 rotates the tray 50 conveyed to the upper position by the lifter 55 to place it in an inclined state, thereby charging the accommodated medicine 11 into the medicine supply portion 5 (charging port 54).

[0048] The tray 50 is formed such that the end portion thereof, which is situated on the lower side when it is rotated by the swinging arm 56, is gradually reduced in width and depth toward the forward end. As a result, when the tray 50 is inclined by the swinging arm 56, the medicine 11 accommodated in the tray 50 is gathered and charged smoothly into the charging port 54.

[0049] The medicine bag printing portion 2, the medicine bag conveying portion 3, the medicine bag positioning portion 4, the medicine supply portion 5, and the medicine charging portion 6 are drive-controlled by a control device 59 based on input data from a host computer 12.

[0050] The supply of the medicine 11 to the tray 50 is effected by a conventionally well-known medicine supply device. Here, the medicine 11 includes objects such as ampoules or vials, which are subject to damage by impact.

Operation

[0051] Next, the operation of the machine for filling a bag with medicine, constructed as described above, is

illustrated.

Medicine Supply

[0052] When receiving prescription data from the host computer 12, a medicine supply device (not shown) supplies the corresponding medicine 11 into the tray 50 based on the prescription data. Then, the tray 50 to which the medicine 11 has been supplied is conveyed to the medicine charging portion 6.

[0053] In the medicine charging portion 6, the control device 59 drive-controls the motor 41d based on an input signal from the host computer 12, and moves the outer container 37 and the ampoule extruding member 38 to the waiting position, thereby closing the charging port 54 of the cover member 40. In this state, the guide surface 47 of the ampoule extruding member 38 is continuous with the charging port 54, and the medicine 11 charged from the tray 50 can be smoothly guided to the medicine storage region. Further, the shutter member 39 is rotated to the closing position so that the medicine 11 supplied to the medicine storage region may not be spilled.

[0054] Then, the lifter 55 is driven to move the tray 50 to the upper position, and the swinging arm 56 is swung, whereby the medicine 11 in the tray 50 is supplied to the medicine storage region via the charging port 54. The medicine 11 rolls or slides on the guide surface 47 until it reaches the bottom surface of the outer container (see Fig. 11 (a)). The guide surface 47 exhibits small coefficient of friction, and helps to supply the medicine 11, in particular, the medicine 11 subject to damage such as ampoules to the bottom surface. Even when the supplied medicine 11 is supplied with momentum via the guide surface 47, the bottom surface of the outer container 37 mitigates the impact.

Supply of the Medicine Bag

[0055] In parallel with the supply of the medicine 11, the medicine bag 13 is supplied. That is, the control device 59 drives the medicine bag printer 7 based on the prescription data received from the host computer 12, and effect corresponding printing on each label of the medicine bag strip wound back from the medicine bag roll 8. Then, the medicine bag strip is cut by the cutter 10 to obtain the medicine bag 13, which is supplied to a conveyor portion 22. In the conveyor portion 22, a belt 22a is driven, and positioning is effected on the supplied medicine bag 13 at a predetermined position.

[0056] Then, the medicine bag conveying portion 3 (horizontal moving member 14, vertical moving member 15, etc.) is drive-controlled, and the suction cylinders 21 of the suction member 16 are opposed to the four corners of the medicine bag 13. Then, a suction device (not shown) is driven, and the medicine bag 13 is sucked by the suction cylinders 21, the suction member 16 retaining the medicine bag 13. Subsequently, the medicine bag conveying portion 3 is drive-controlled, and the medicine

bag 13 is conveyed to the rotation plate 23 (see Fig. 11 (a)). The placing position on the rotation plate 23 is specified based on previously registered coordinate data.

Charging of Medicine into the Medicine Bag

[0057] Both sides of the opening of the medicine bag 13 supplied onto the rotation plate 23 are sucked via the suction holes 23a and 30f, and, by upwardly moving the ascent/descent member 30, the medicine bag 13 is opened to allow charging of the medicine 11. As shown in Figs. 7 and 8, at this time, the presser member 32 rotates, and the upper inner surface of the opening portion of the medicine bag 13 is pressed. Further, the shutter member 39 is rotated to press the lower inner surface of the opening portion of the medicine bag 13 (see Fig. 11(b)).

[0058] Next, the motor 46d is driven to cause the outer container 37 and the ampoule extruding member 38 to enter the medicine bag 13 before stopping at the supply position (see Figs. 9, 10(a), and 11(c)). Since it is possible to reliably open the opening of the medicine bag 13 in a predetermined size by the shutter member 39 and the presser member 32, it is possible to allow the outer container 37 and the ampoule extruding member 38 to smoothly enter the medicine bag 13. Since the forward end portion of the side wall of the outer container 37 is formed in an arcuate configuration, there is no fear of the medicine bag 13 being damaged.

[0059] At the supply position, the medicine storage region is situated completely within the medicine bag 13. Then, the motor 45a is driven to retract solely the outer container 37 from the medicine bag 13 (see Figs. 10(b) and 11(d)). As a result, the medicine 11 in the medicine storage region ceases to be supported by the bottom surface of the outer container 37, and is forcibly caused to remain in the medicine bag 13 by the ampoule extruding member 38, more specifically, by the climbing suppressing portion 49 and the guide surface 47. In this case, the medicine 11 simply undergoes regulation in position by the ampoule extruding member 38, and hence its position in the medicine bag 13 is scarcely changed. Thus, there occurs substantially no such problem as medicine damage due to collision of medicines with each other. Even when the medicine 11 slides on the guide surface 47 to move to the upper side, it is prevented from flowing out by the detachment preventing portion 48. Further, the inner surface of the medicine bag 13 is situated in the vicinity of the upper side of the detachment preventing portion, and hence the medicine 11 does not flow out of the medicine bag 13.

[0060] When the supply of the medicine 11 into the medicine bag 13 is completed, the motor is driven to move both the outer container 37 and the ampoule extruding member 38 out of the medicine bag 13 (see Fig. 11(e)). Further, the ascent/descent member 30 is lowered, and the positioning of the medicine bag 13 by the shutter member 39 and the presser member 32 is can-

celled. As a result, the opening portion of the medicine bag 13 is held between the support portion and the ascent/descent member 30. Here, electricity is supplied to the heating portion 25a to effect temporary stopping through heat sealing at four positions of the opening portion of the medicine bag 13. Further, the medicine bag retaining arm 26 is caused to slide along the rotation plate 23, and is rotated to bring the pressing portion 36 into press contact with the portion in the vicinity of the opening (both side portions) of the medicine bag 13 (see Fig. 11 (f)). The elongated holes 29 are situated on the side of the medicine bag 13 opposite to the side where it is held in press contact with the pressing portion 36. Thus, it is possible to effectively apply solely the frictional force of the pressing portion 36 to the medicine bag 13. Then, the rotation plate 23 is rotated to the inclined position (see Fig. 12(a)). Then, the medicine bag retaining arm 26 is moved (see Fig. 12(b)). Finally, the medicine bag retaining arm 26 is rotated to the former position, whereby the retaining state of the medicine bag 13 is cancelled, and the medicine bag 13 is supplied into the bucket 27 (see Fig. 12(c)). In this way, the medicine bag 13 whose opening has already been temporarily stopped can be smoothly conveyed to the bucket 27 supplied to the predetermined position.

[0061] As described above, in the machine for filling a bag with medicine according to the above embodiment, solely inclining the tray 50, the medicine 11 in the tray 50 can be charged into the medicine storage region in the outer container 37 via the charging port 54. In this case, the medicine 11 can be smoothly guided to the medicine storage region by the guide surface 47 continuous with the inclined tray 50. Further, after moving both the outer container 37 and the ampoule extruding member 38 to the medicine bag 13, solely the outer container 37 is retracted, whereby the medicine 11 in the medicine storage region remains in the medicine bag 13. Thus, it is possible to cause medicine 11 to remain in the medicine bag 13 after moving it into the medicine bag 13 while maintaining the positional relationship between medicines. Thus, even if the operation of filling the medicine bag 13 with the medicine 11 is conducted at high speed, there is no fear of the medicine suffering damage from collision of medicines with each other.

Further Embodiment

[0062] While in the above-mentioned embodiment the first moving member is formed by the outer container 37, it may also be formed by a belt conveyor 100 as shown in Fig. 13. The belt conveyor 100 has a simple construction in which a belt 102 is stretched between a pair of rotatable pulleys 101 arranged at a predetermined interval.

[0063] With this construction, in the state shown in Fig. 13(a), the medicine bag 13 is opened by the suction holes 43b and 30f as in the above-mentioned embodiment, and the open state is reliably attained by the shutter member

39 (see Fig. 13(b)). Then, both the belt conveyor 100 and the ampoule extruding member 38 are moved into the medicine bag 13 (see Fig. 13(c)), and solely the belt conveyor 100 is retracted out of the medicine bag 13, whereby the medicine 11 placed on the belt conveyor 100 is pushed back into the medicine bag 13 by the ampoule extruding member 38 (see Fig. 13(d)). The belt 102 of the belt conveyor 100 is simply stretched between the rotatable pulleys 101. Thus, by being pushed by the ampoule extruding member 38, the medicine 11 causes the belt 102 to move. Thus, no excessive load is applied to the medicine 11, which is allowed to smoothly remain in the medicine bag 13. After that, as in the above-mentioned embodiment, the belt conveyor 100 and the ampoule extruding member 38 are retracted out of the medicine bag 13 (see Fig. 13(e)), and the opening of the medicine bag 13 is maintained in the closed state by the medicine bag retaining arm 26 (see Fig. 13(f)) before effecting transfer to the bucket 27.

Further Embodiment

[0064] While in the above-mentioned embodiment the second moving member includes the ampoule extruding member 38 as shown in Figs. 5, 6, etc., it is also possible to adopt a form as shown in Fig. 14.

[0065] In Fig. 14(a), the guide surface 47 (including the climbing suppressing portion 49) of the ampoule extruding member 38 is constituted by first inclined surface 111 and a second inclined surface 112 gradually inclined downwards toward both sides from a ridge 110, and a third inclined surface 113 inclined gradually downwards from the central portion toward the forward end. With this construction, the charged medicines 11 are aligned in the charging direction by the first and second inclined surfaces 111 and 112. Thus, if solely the outer container 37 is retracted out of the medicine bag 13 (operation corresponding to Fig. 10(b) and Fig. 11(d)), the medicines 11 aligned in the charging direction do not easily move toward the ampoule extruding member 38 side. Further, the medicines 11 (mainly ampoules) that tend to move on the third inclined surface 113 are divided into both sides by the ridge 110, and respectively move (roll or slide) on the first inclined surface 111 and the second inclined surface 112, or move as they are on the third inclined surface 113 to remain in the medicine bag 12. In this way, the medicines 11 are caused to remain in the medicine bag 13 in a dispersed state, and hence it is possible to adequately prevent a problem such as medicine damage from collision of the medicines 11 with each other. While the example of Fig. 13 is formed by three inclined surfaces, it is also possible to form it by two or four or more inclined surfaces. In brief, any construction will do as long as it helps to disperse the medicines 11 tending to climb onto the inclined surfaces through retreat of the outer container 37, thereby allowing the medicines 11 to remain in the medicine bag 13.

[0066] In the example shown in Fig. 14(b), the outer

container 37 is formed so as to have a semi-arc-like sectional configuration and as to be gradually reduced in radius of curvature toward the forward end, and the ampoule extruding member 38 is accordingly formed such that its bottom surface swells in an arcuate fashion, with an elliptical inclined surface 115 being provided at the forward end. In this construction, due to the semi-arc-like sectional configuration of the outer container 37, the supplied medicines 11 (mainly ampoules) are aligned in orientation along the longitudinal direction. Thus, when solely the outer container 37 is retracted from the medicine bag 13, the medicines 11 do not climb onto the inclined surface 115 of the ampoule extruding member 38, and are reliably allowed to remain in the medicine bag 13.

[0067] In Fig. 14(c), instead of the construction having the outer container 37 and the ampoule extruding member 38 shown in Fig. 14(b), there is adopted a construction having solely the outer container 37, which is vertically (between the horizontal position and the inclined position) rotatable around the forward end as indicated by the arrows. In the horizontal position, the outer container 37 moves into the medicine bag 13, with the medicines 11 placed thereon, then it is rotated to the inclined position, where the medicines 11 placed thereon are forcibly charged into the medicine bag 13, and thereafter, it moves out of the medicine bag (it may be temporarily restored to the horizontal position).

Further Embodiment

[0068] Fig. 15 is a schematic front view of a machine for filling a bag with medicine according to another embodiment. This machine for filling a bag with medicine is formed, instead of being formed by the first and second moving members, solely by a belt conveyor 120 and guide walls 121 on both sides thereof. In the belt conveyor 120, a belt 123 is stretched between a pair of pulleys 122, and one pulley 122 is capable of normal and reverse rotation through driving of a motor (not shown). The medicine 11 is directly charged from the medicine charging portion 6 and is placed on the belt conveyor 120.

[0069] With the above-mentioned construction, the medicines are charged onto the belt conveyor 120 from the medicine charging portion 6 (see Fig. 15(a)), and the medicine bag 13 is opened by the suction holes 43b and 30f as in the above-mentioned embodiment (see Fig. 15(b)). Then, after the belt conveyor 120 is moved into the medicine bag 13, the belt conveyor 120 is driven, and the medicines 11 placed thereon are forcibly supplied into the medicine bag 13 (see Fig. 15(c)). In this case, the configuration and size of the medicines are stored in a storage means (e.g., a hard disk) (not shown), and the belt conveyor 120 is gradually retracted out of the medicine bag 13 so that the medicines 11 may be properly accommodated in the medicine bag 13 based on the data and the number of medicines to be accommodated in the medicine bag 13. From this onward, the same processes (see Figs. 15(d) through 15(f)) as those of the above

embodiment are conducted.

[0070] While in the above embodiments both the outer container 37 and the ampoule extruding member 38 are moved into the medicine bag 13, it is also possible to adopt a construction in which the medicine bag 13 is moved toward the outer container 37 and the ampoule extruding member 38.

Description of Reference Numerals

[0071] 1 ... machine main body, 2 ... medicine bag printing portion, 3 ... medicine bag conveying portion, 4 ... medicine bag positioning portion, 5 ... medicine supply portion, 6 ... medicine charging portion, 7 ... medicine bag printer, 8 ... medicine bag roll, 9 ... strip-like medicine bag, 10 ... cutter, 11 ... medicine, 12 ... host computer, 13 ... medicine bag, 14 ... horizontal moving member, 15 ... vertical moving member, 16 ... suction member, 17 ... horizontal frame member, 18 ... support arm, 19 ... body portion, 20 ... suction portion, 21 ... suction cylinder, 23 ... rotation plate, 24 ... medicine bag opening portion, 25 ... medicine bag temporary stop portion, 26 ... medicine bag retaining arm, 27 ... bucket, 28 ... guide groove, 29 ... elongated hole, 30 ... ascent/descent member, 31 ... support frame, 32 ... presser member, 33 ... guide portion, 34 ... arm portion, 35 ... connecting portion, 36 ... pressing portion, 37 ... outer container (first moving member), 38 ... ampoule extruding member (second moving member), 39 ... shutter member, 40 ... cover member, 41 ... support member, 42 ... slide shaft, 43 ... frame, 44 ... nut portion, 45 ... ball screw, 47 ... guide surface, 48 ... detachment preventing portion, 49 ... climbing suppressing portion, 50 ... tray, 51 ... driven gear, 52 ... intermediate gear, 53 ... driving gear, 54 ... charging port, 55 ... lifter, 56 ... swinging arm, 57 ... guide rail, 58 ... slider, 59 ... control device (drive control means), 100 ... belt conveyor, 101 ... pulley, 102 ... belt, 110 ... ridge, 111 ... first inclines surface, 112 ... second inclined surface, 113 ... third inclined surface, 115 ... inclined surface, 120 ... belt conveyor, 121 ... guide wall, 122 ... pulley, 123 ... belt

Claims

1. A machine for filling a bag with medicine including: a medicine bag positioning member for effecting positioning, with a medicine bag being open; and a bottom surface portion on which medicine to be supplied can be placed, comprising:

a first moving member which reciprocates relative to the medicine bag on which positioning is effected by the medicine bag positioning member and which allows positioning at a supply position inside the medicine bag and a waiting position outside the medicine bag;
a second moving member capable of reciprocating relative to the first moving member or the medicine bag and having a guide surface guiding supplied medicine to the bottom surface portion; and

a drive-control means which moves the first moving member from the supply position to the waiting position relative to the medicine bag and which maintains a positional relationship of the second moving member with respect to the medicine bag, to thereby cause the medicine supplied to the bottom surface portion by the guide surface to remain in the medicine bag.

2. A machine for filling a bag with medicine according to Claim 1, further comprising a shutter member which allows positioning at an outflow preventing position where outflow of the medicine placed on the bottom surface portion of the first moving member is prevented, and at a medicine supply position where supply of the medicine placed on the bottom surface portion is allowed and where an opening portion inner edge of the medicine bag is pressed.
3. A machine for filling a bag with medicine according to Claim 1 or 2, wherein the second moving member includes a detachment preventing portion which, when causing the medicine to remain in the medicine bag, prevents detachment of the medicine from the guide surface to an exterior of the medicine bag.
4. A machine for filling a bag with medicine according to any one of Claims 1 through 3, wherein the second moving member includes with a climbing suppressing portion which, when causing the medicine to remain in the medicine bag, comes into contact with the medicine to suppress climbing of the medicine onto the guide surface.
5. A machine for filling a bag with medicine according to any one of Claims 1 through 4, further comprising a cover member which covers an upper portion of a medicine supply region formed by the first moving member and the second moving member, wherein the cover member has a medicine charging port, which is opened to allow supply of the medicine onto the bottom surface portion via the guide surface by moving at least the second moving member to the waiting position, and makes the medicine incapable of being charged or escaping by moving the second moving member to the supply position.
6. A machine for filling a bag with medicine according to any one of Claims 1 through 5, wherein the medicine bag positioning member includes a medicine bag temporary stop portion for temporarily stopping the opening so that the medicine charged may become incapable of detachment from the medicine

bag.

7. A machine for filling a bag with medicine comprising:

a medicine bag positioning member for effecting positioning, with a medicine bag being open; 5
 a belt conveyor which makes a horizontal reciprocating movement between a supply position inside the medicine bag, where positioning is effected by the medicine bag positioning member, and a waiting position outside the medicine bag, and which is driven to run to supply medicine placed thereon into the medicine bag; 10
 a medicine charging member for charging medicine onto the belt conveyor; and 15
 a drive-control means which horizontally moves the belt conveyor to the waiting position, drives the medicine charging member to supply medicine onto the belt conveyor, and moves the belt conveyor to the supply position inside the medicine bag to run the belt conveyor, to thereby supply the medicine placed thereon into the medicine bag. 20

8. A machine for filling a bag with medicine according to Claim 7, 25
 wherein the medicine bag positioning member includes a medicine bag temporary stop portion for temporarily stopping the opening so that the medicine charged may become incapable of detachment from the medicine bag. 30

9. A machine for filling a bag with medicine comprising:
 a medicine bag positioning member for effecting positioning, with a medicine bag being open; 35
 a belt conveyor which is formed by stretching a belt between a pair of rotatable pulleys and a whole of which makes a horizontal reciprocating movement between a supply position inside the medicine bag, where positioning is effected by the medicine bag positioning member, and a waiting position outside the medicine bag; 40
 a medicine charging member for charging medicine onto the belt conveyor;
 a guide member for guiding the medicine charged by the medicine charging member onto the belt conveyor; and 45
 a drive-control means which horizontally moves the belt conveyor to the waiting position, drives the medicine charging member to supply medicine onto the belt conveyor via the guide member, and, after moving the belt conveyor and the guide member to the supply position inside the medicine bag, retracts solely the belt conveyor out of the medicine bag to prevent movement of the medicine by the guide member, to thereby cause the medicine to remain in the medicine bag. 50 55

FIG. 1

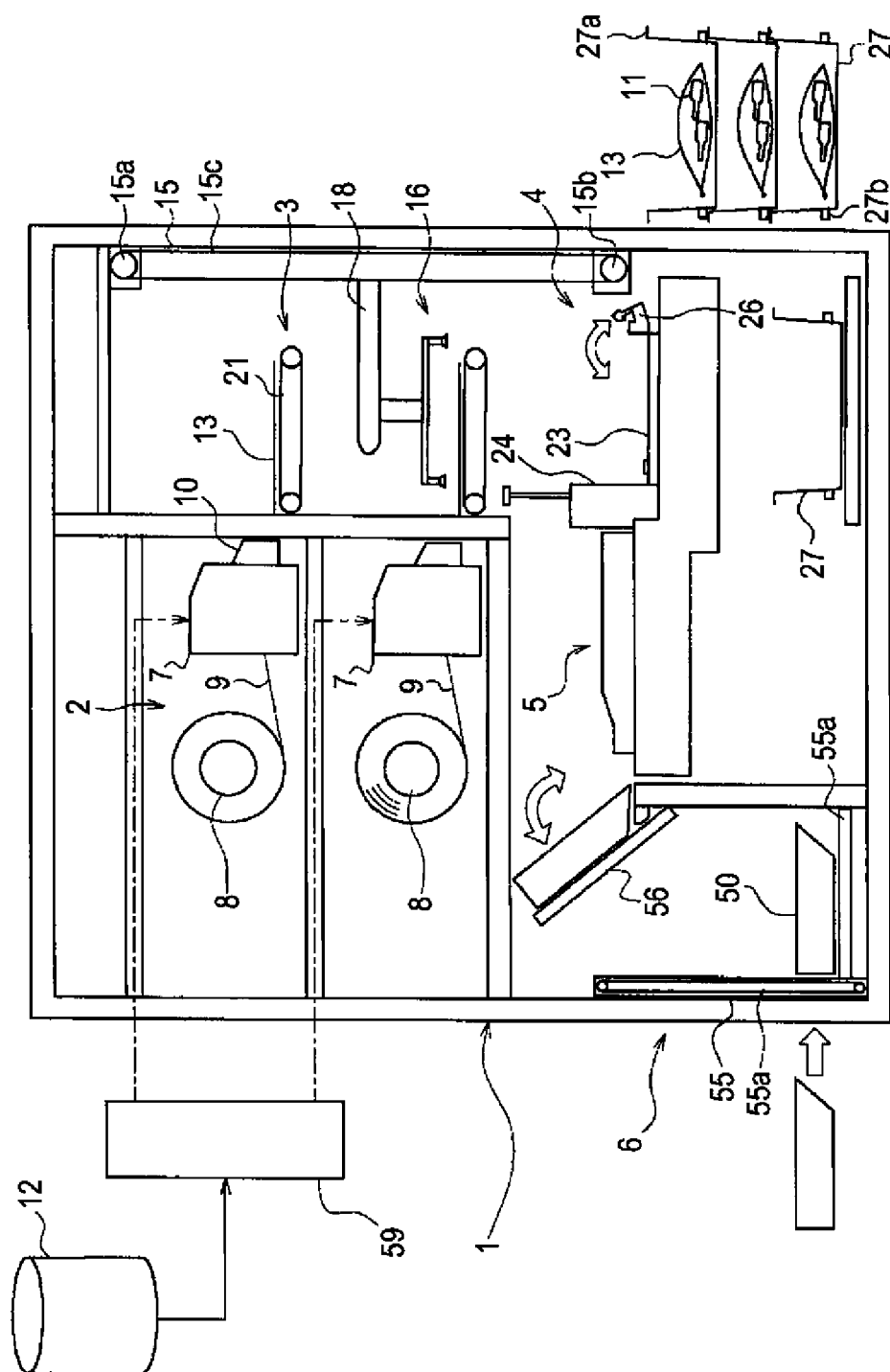


FIG. 2

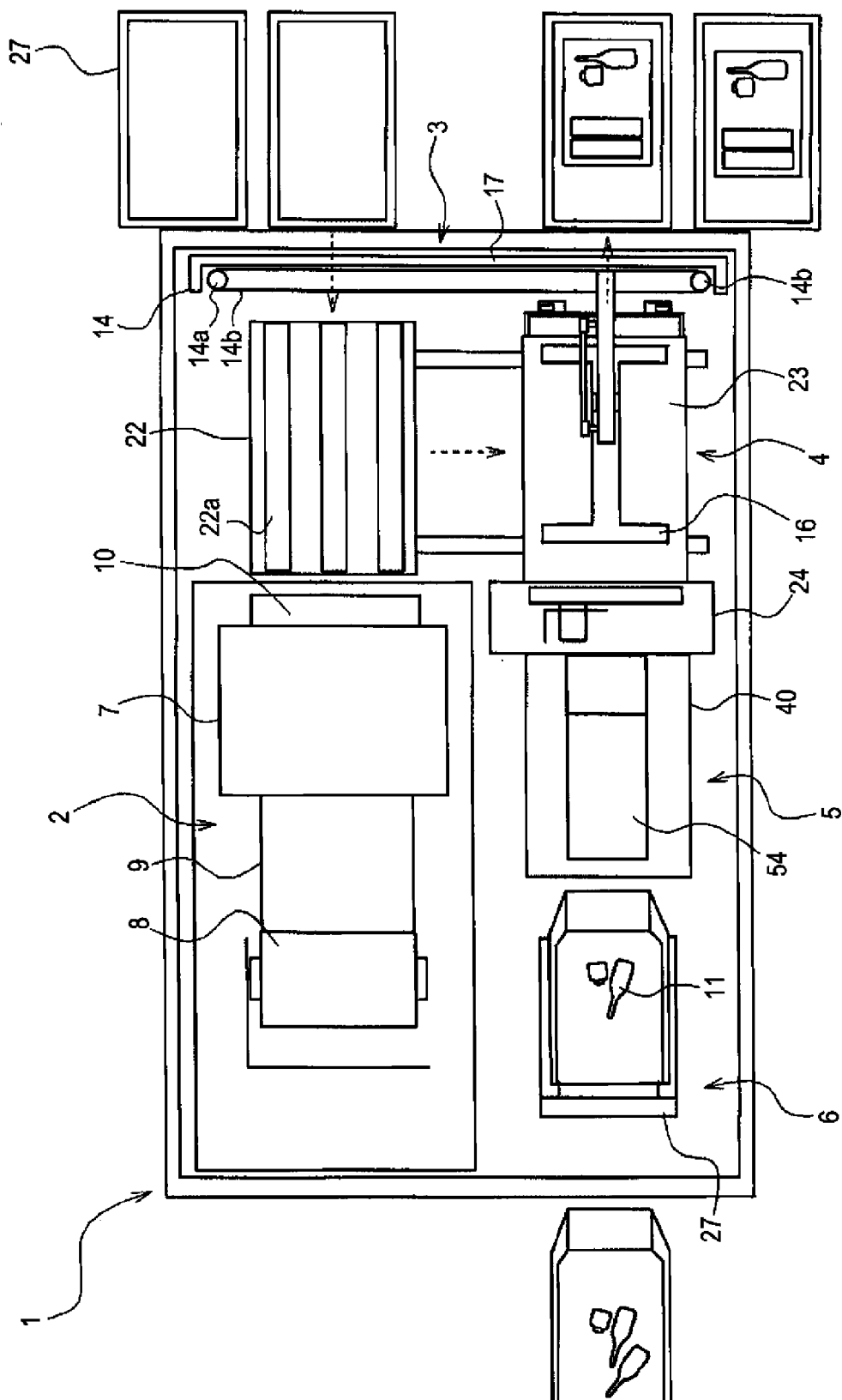


FIG. 3

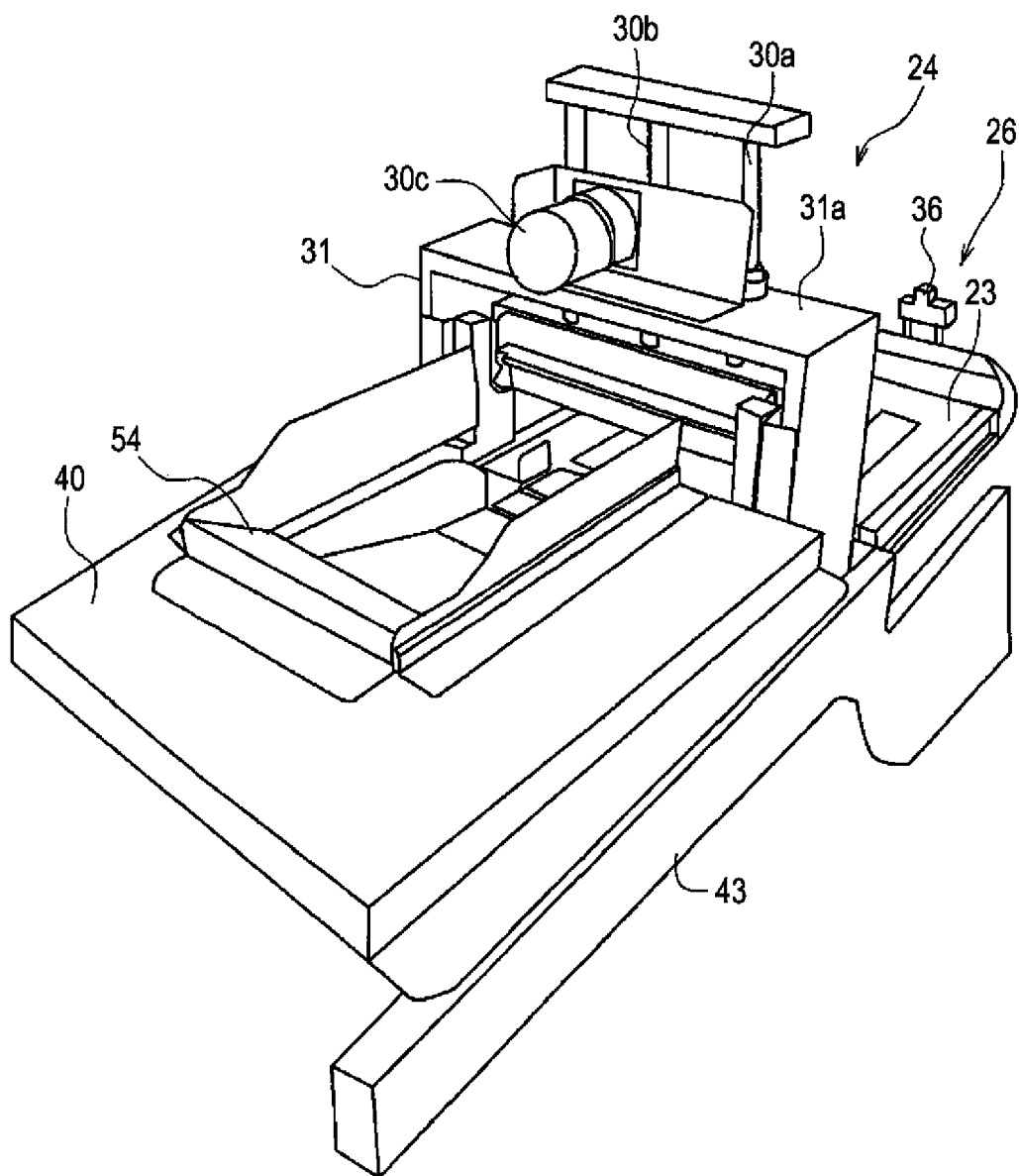


FIG. 4

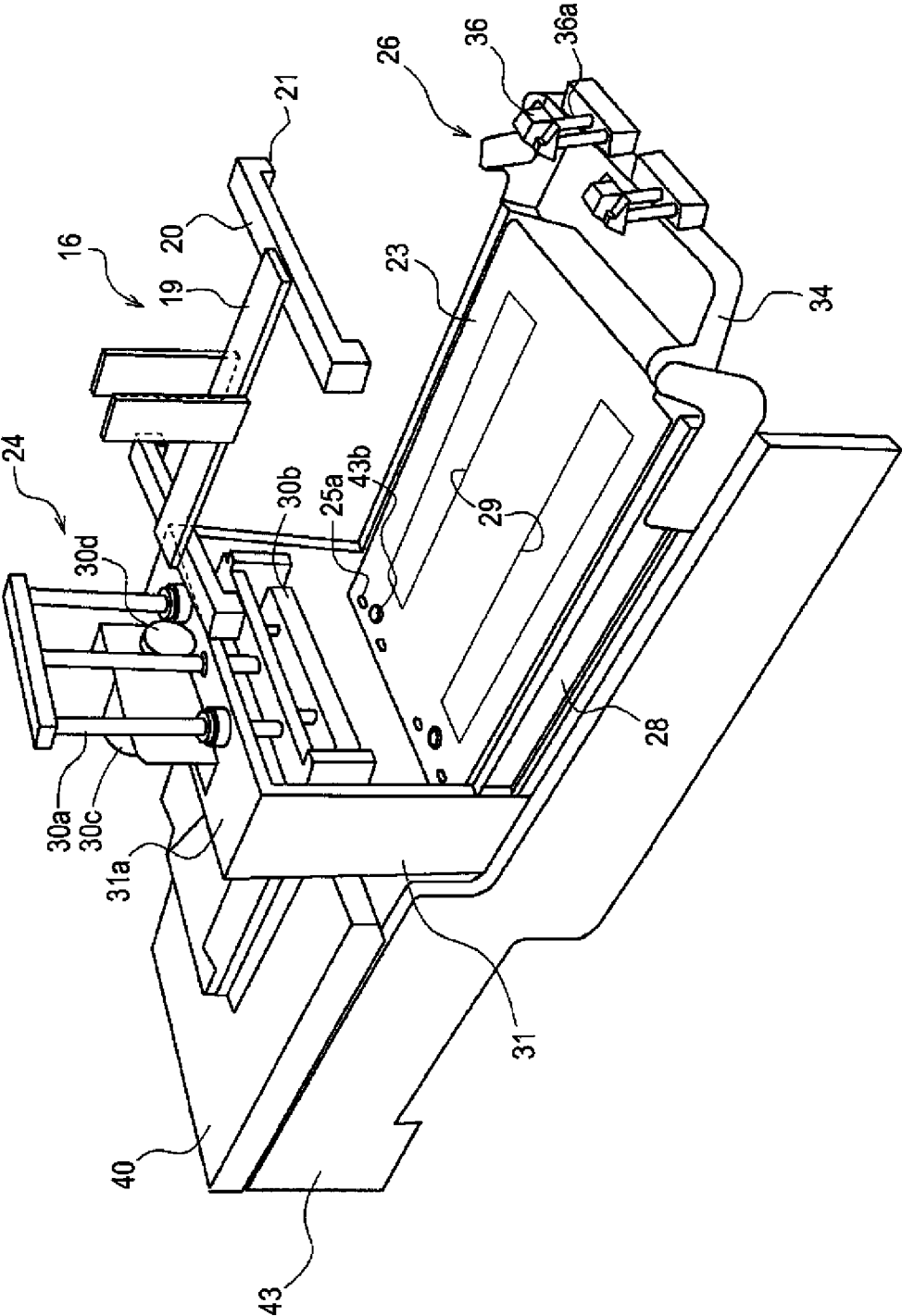


FIG. 5

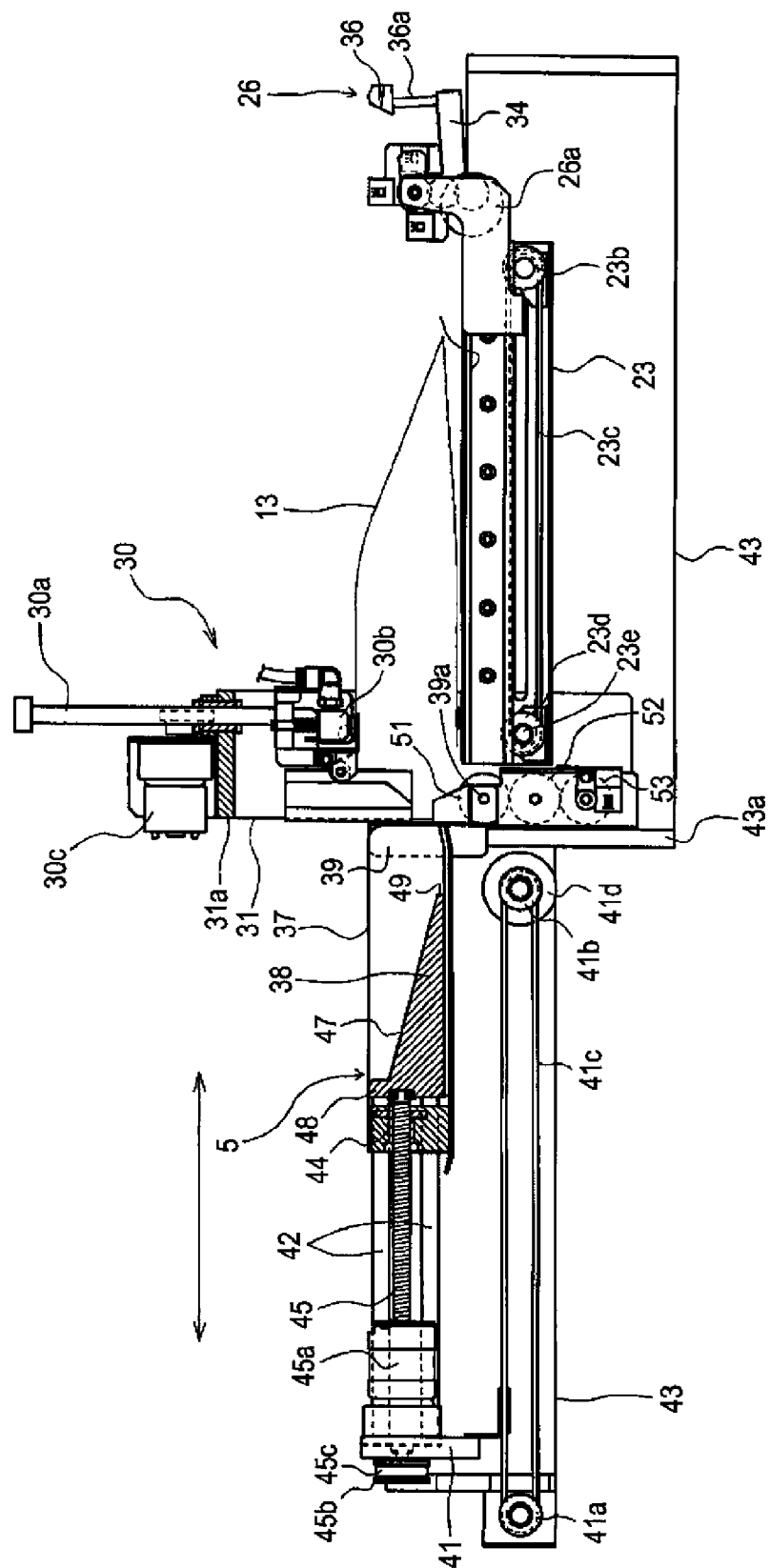


FIG. 6

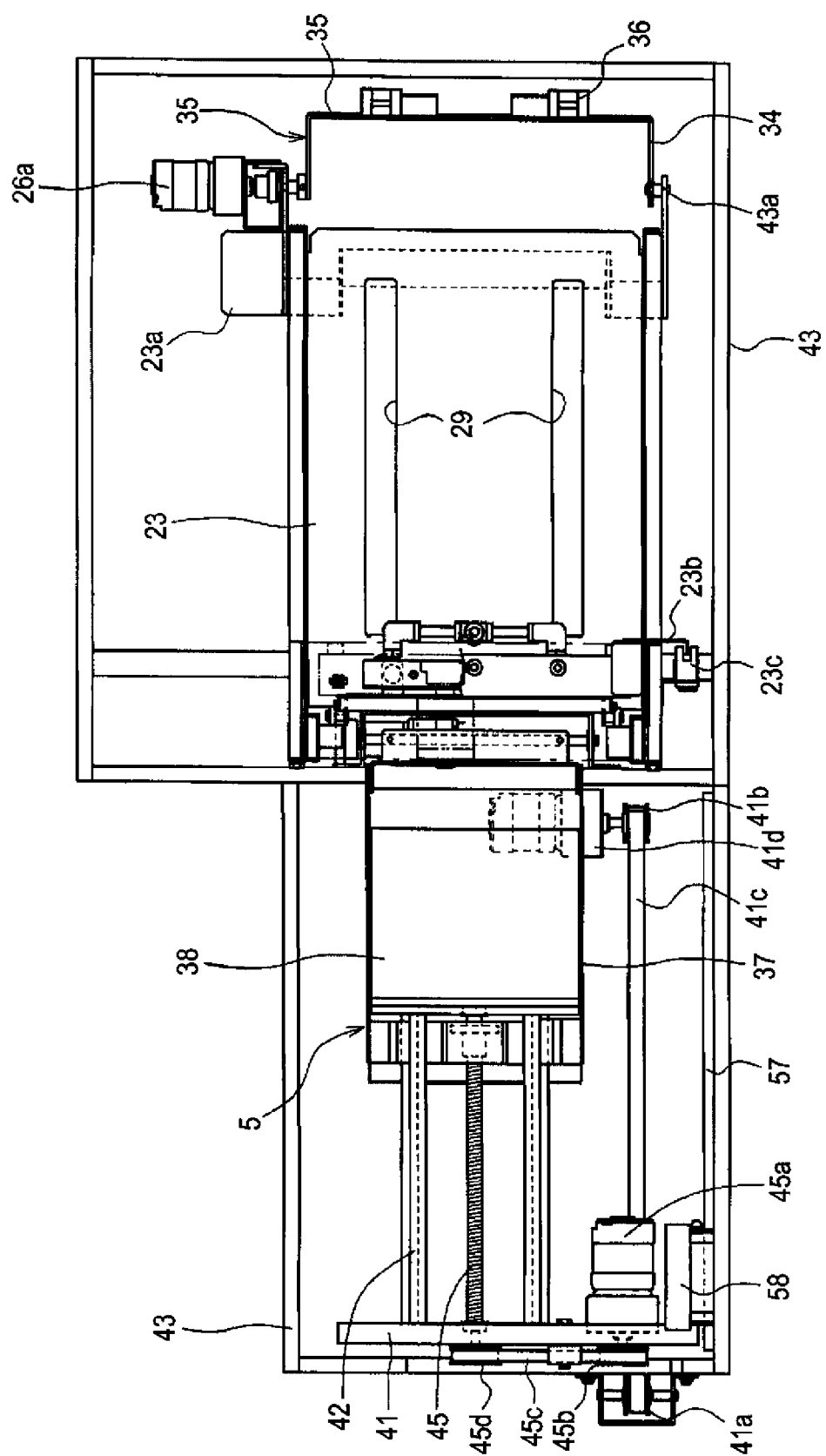


FIG. 7

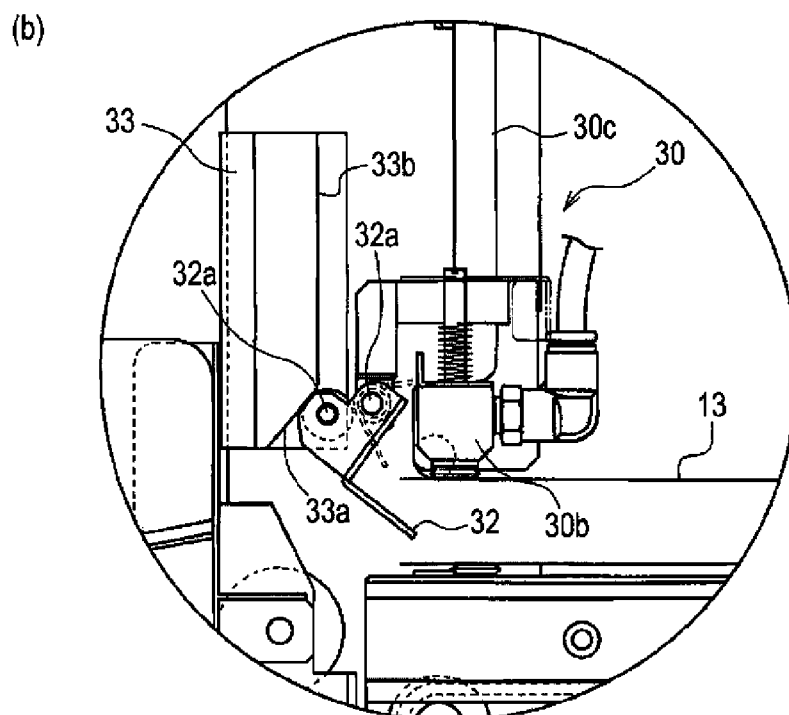
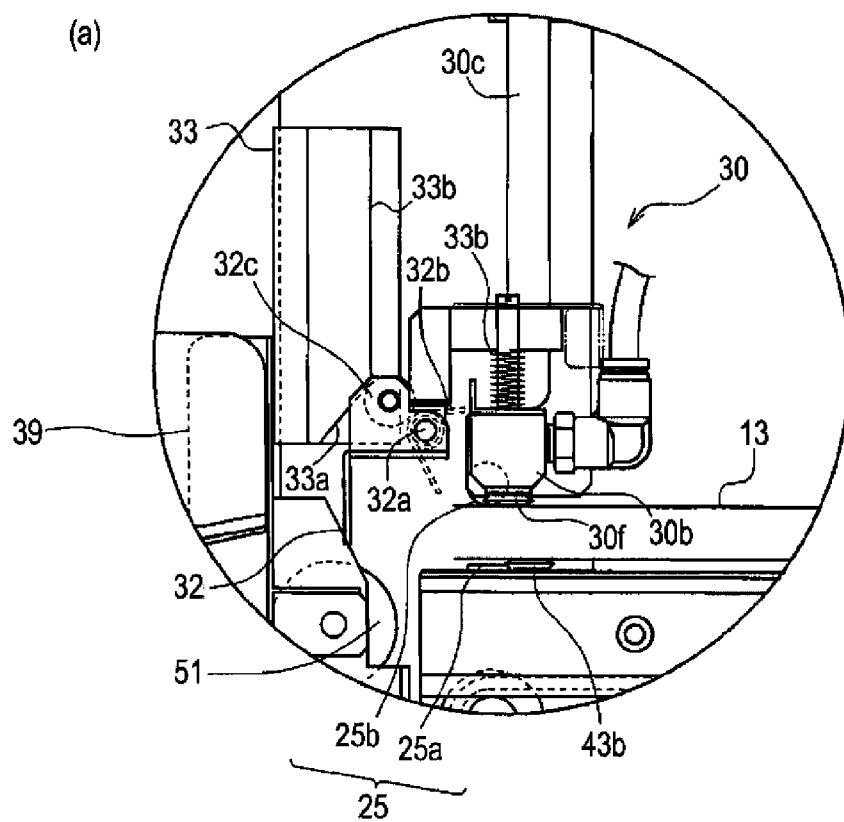
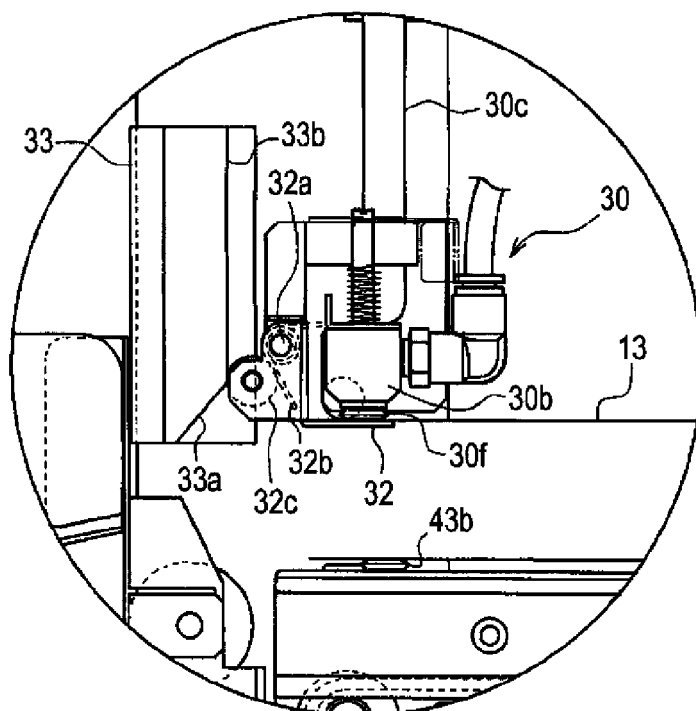


FIG. 8

(a)



(b)

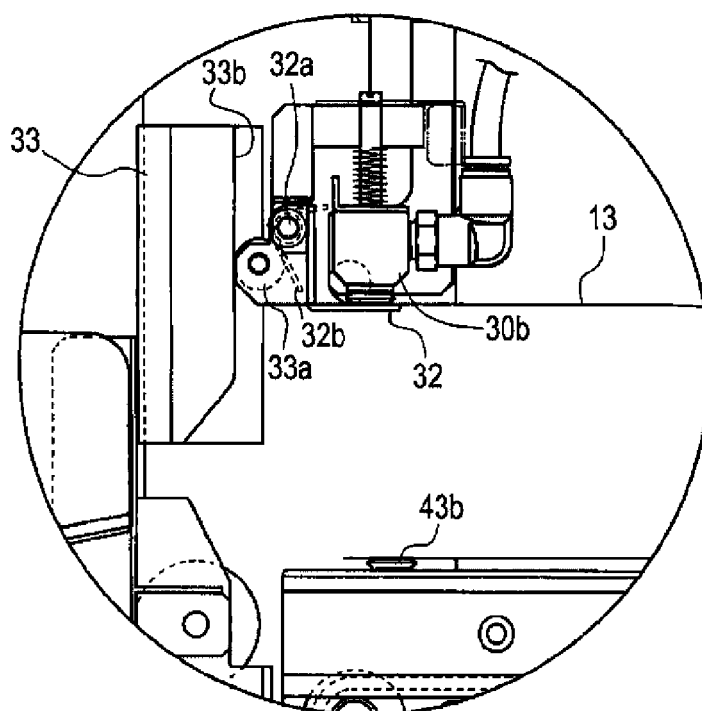


FIG. 9

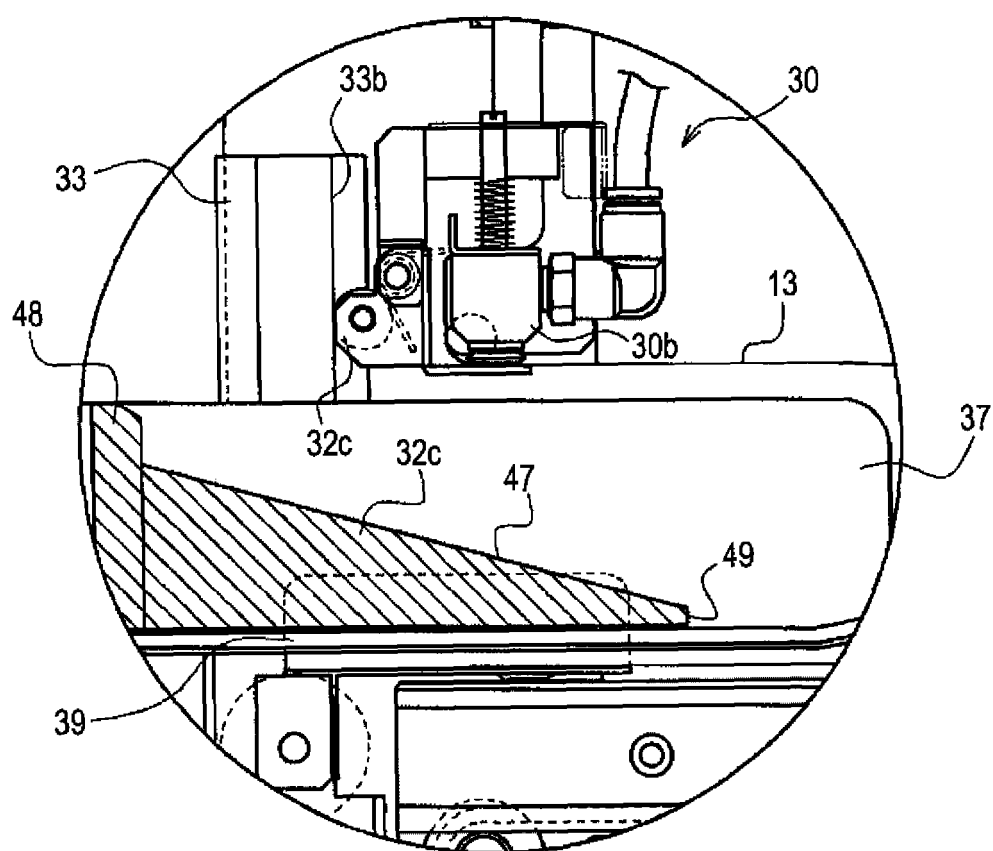


FIG. 10

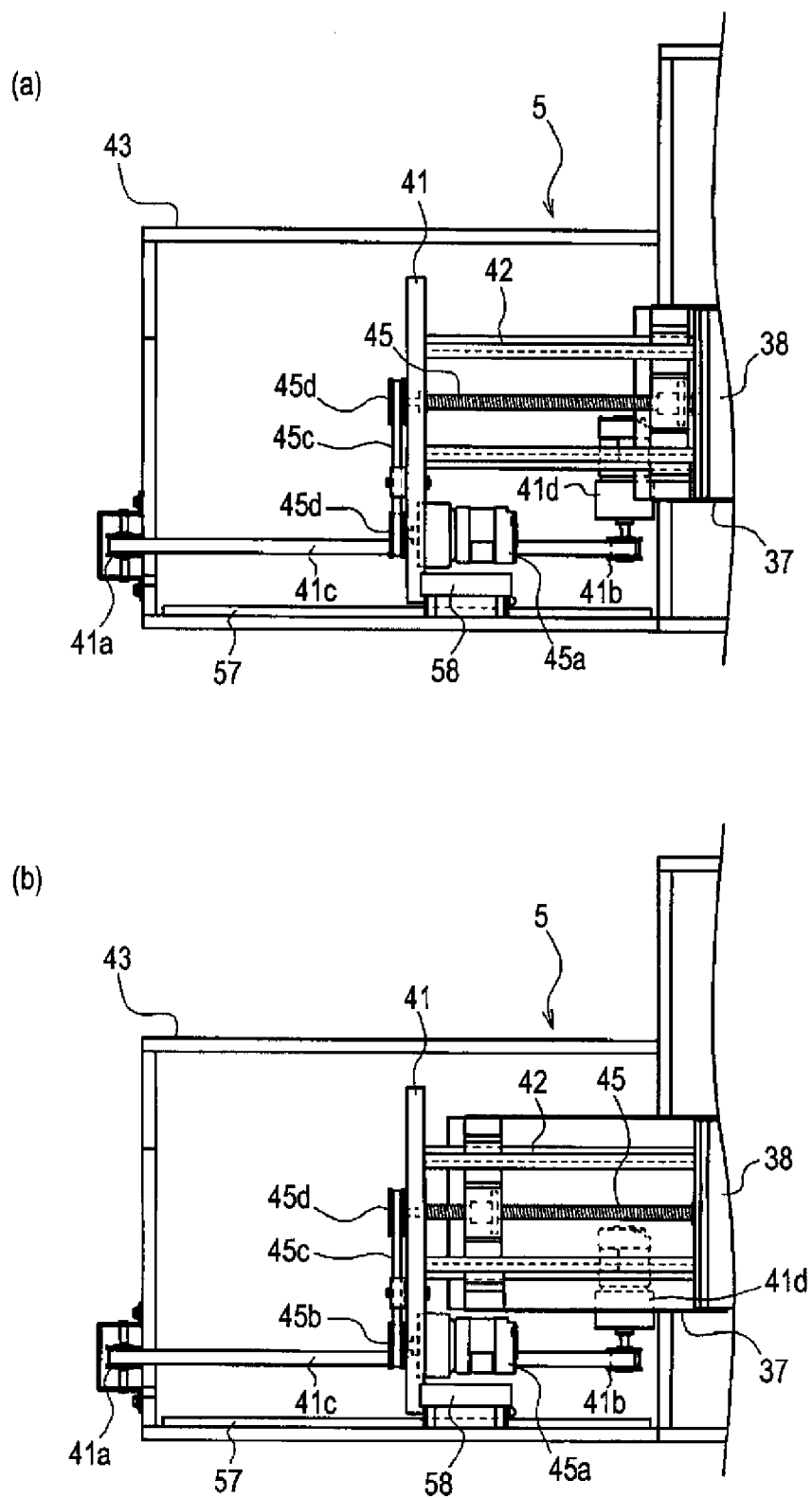


FIG. 11

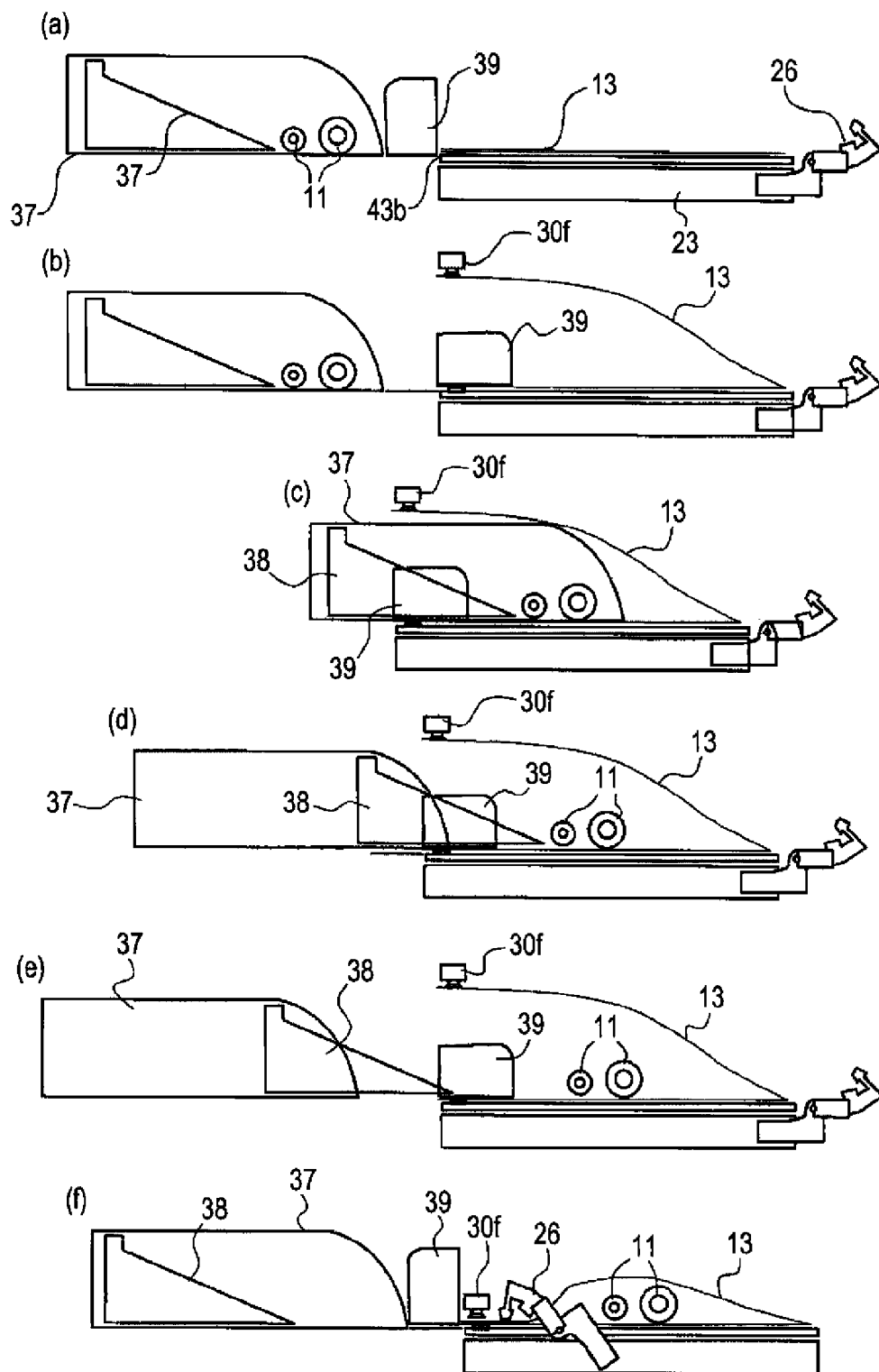


FIG. 12

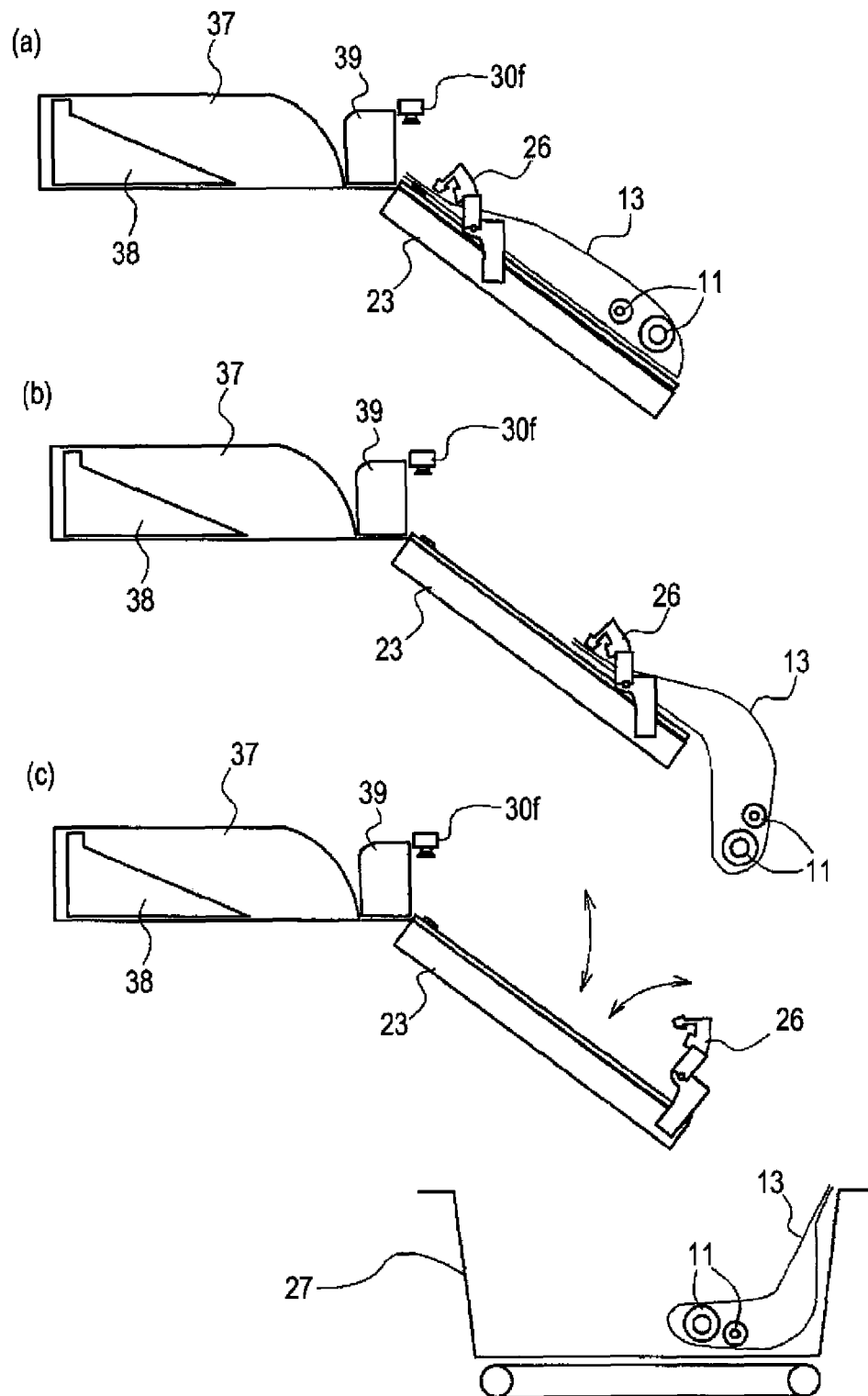


FIG. 13

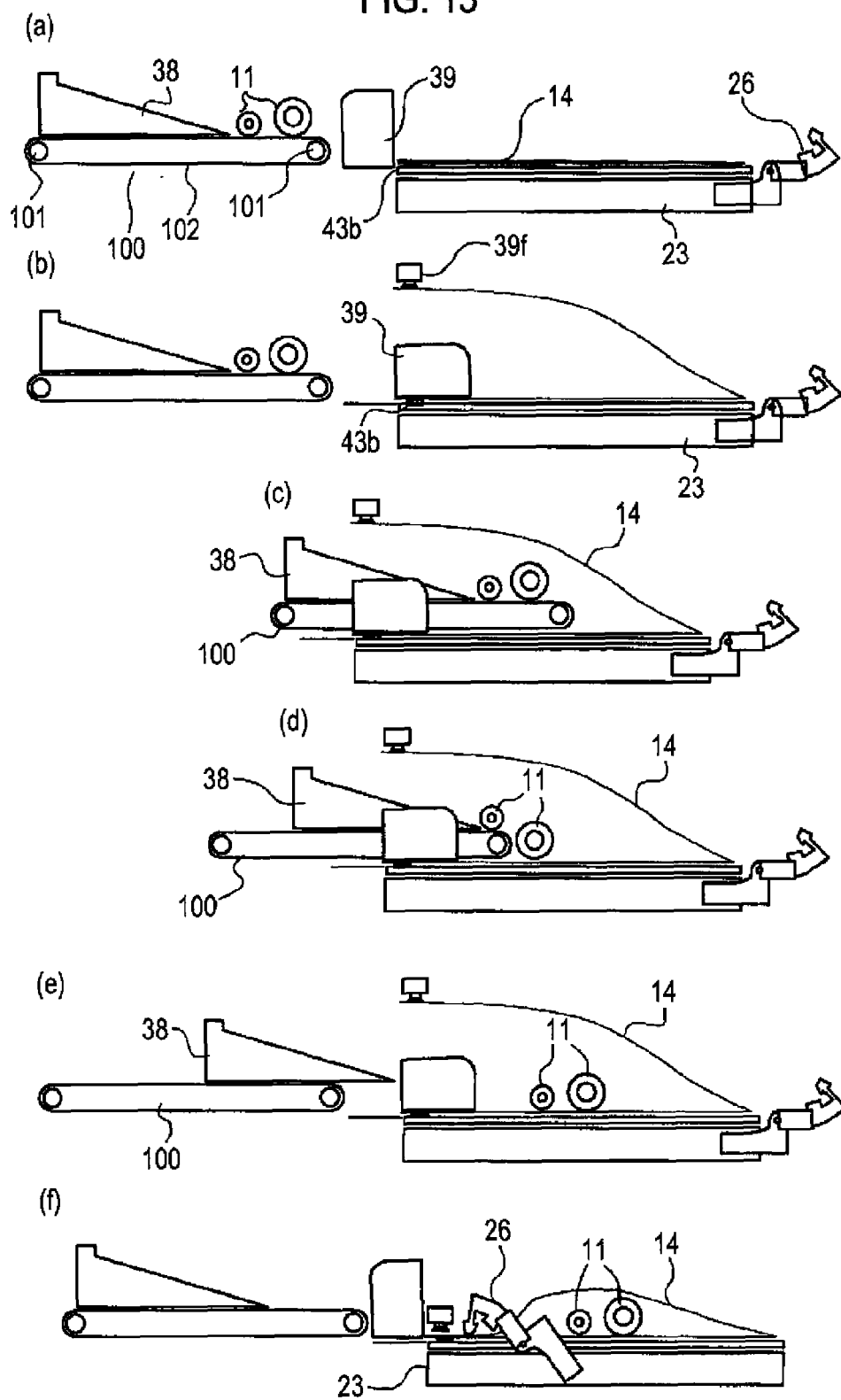


FIG. 14

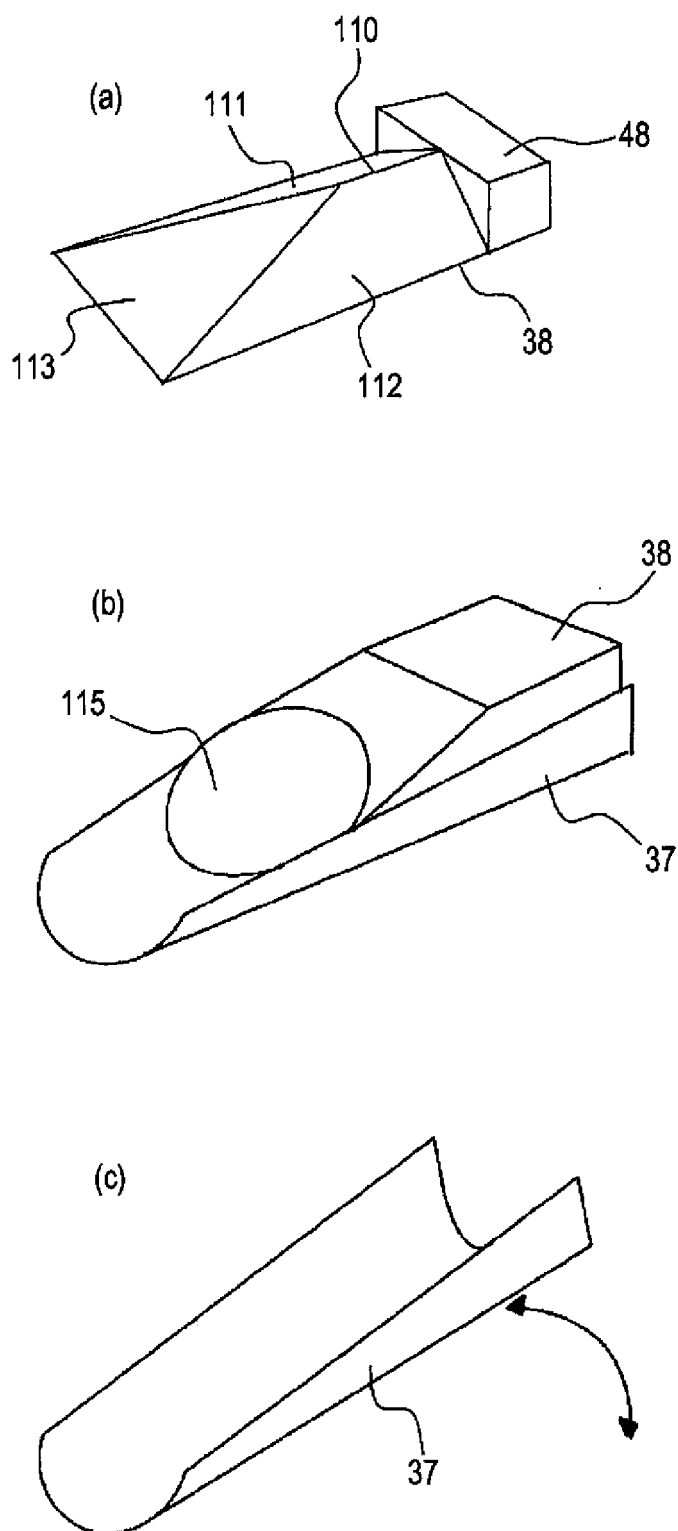
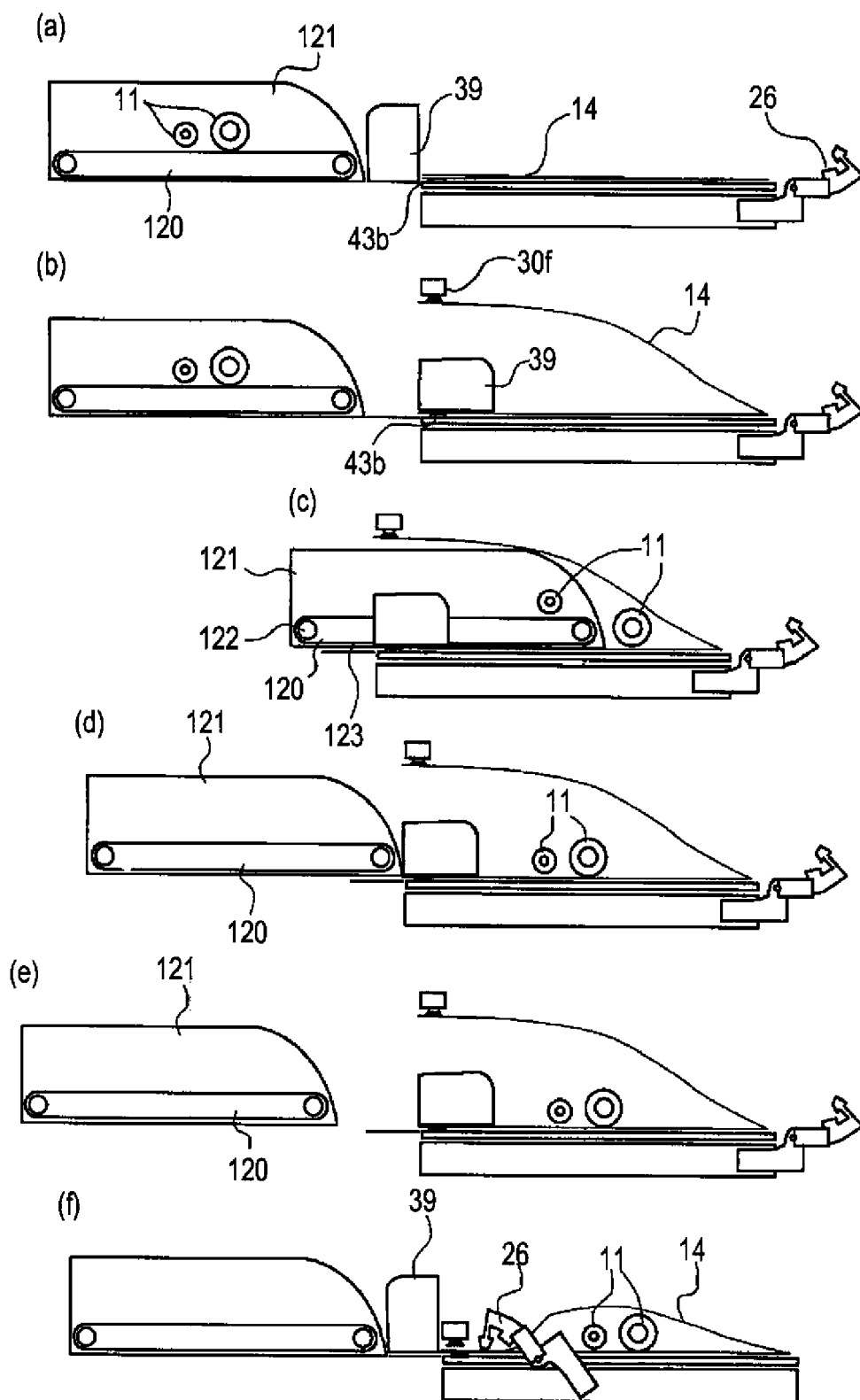


FIG. 15



INTERNATIONAL SEARCH REPORT

International application No.

PCT/JP2007/054446

A. CLASSIFICATION OF SUBJECT MATTER B65B1/30(2006.01)i, A61J3/00(2006.01)i, B65B17/00(2006.01)i		
According to International Patent Classification (IPC) or to both national classification and IPC		
B. FIELDS SEARCHED		
Minimum documentation searched (classification system followed by classification symbols) B65B1/30, A61J3/00, B65B17/00, B65B35/30		
Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched Jitsuyo Shinan Koho 1922-1996 Jitsuyo Shinan Toroku Koho 1996-2007 Kokai Jitsuyo Shinan Koho 1971-2007 Toroku Jitsuyo Shinan Koho 1994-2007		
Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)		
C. DOCUMENTS CONSIDERED TO BE RELEVANT		
Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X A	JP 2005-153903 A (Kabushiki Kaisha Tosho), 16 June, 2005 (16.06.05), Par. Nos. [0022] to [0073]; Figs. 1 to 8 (Family: none)	7, 8 1-6, 9
A	JP 2000-079908 A (Yuyama Mfg. Co., Ltd.), 21 March, 2000 (21.03.00), Par. Nos. [0015] to [0035]; Figs. 1 to 12 & US 6691490 B1 & WO 2004/080809 A1	1-9
A	JP 2000-085707 A (Yuyama Mfg. Co., Ltd.), 28 March, 2000 (28.03.00), Par. Nos. [0010] to [0041]; Figs. 1 to 14 (Family: none)	1-9
<input checked="" type="checkbox"/> Further documents are listed in the continuation of Box C. <input type="checkbox"/> See patent family annex.		
* Special categories of cited documents: "A" document defining the general state of the art which is not considered to be of particular relevance "E" earlier application or patent but published on or after the international filing date "L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified) "O" document referring to an oral disclosure, use, exhibition or other means "P" document published prior to the international filing date but later than the priority date claimed "T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention "X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone "Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art "&" document member of the same patent family		
Date of the actual completion of the international search 22 May, 2007 (22.05.07)		Date of mailing of the international search report 05 June, 2007 (05.06.07)
Name and mailing address of the ISA/ Japanese Patent Office		Authorized officer
Facsimile No.		Telephone No.

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INTERNATIONAL SEARCH REPORT

International application No.

PCT/JP2007/054446

C (Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	JP 08-072813 A (Yamazaki Machinery MFG Co., Ltd.), 19 March, 1996 (19.03.96), Par. Nos. [0019], [0032], [0033]; Fig. 4 (Family: none)	1-6, 9
A	JP 04-128101 A (Kao Corp.), 28 April, 1992 (28.04.92), Page 4, upper left column, line 16 to upper right column, line 6; Fig. 4 (Family: none)	2

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REFERENCES CITED IN THE DESCRIPTION

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