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(54) **Method and system for automatically creeling and uncreeling warping creels**

(57) A method for creeling and uncreeling warping creels supporting, for performing warping sessions, a plurality of full yarn bobbins and empty tubes, said creels comprising at least a creel, preferably at least a pair of cooperating creels, said pair of creels including a first creel and a second creel, operatively cooperating with said first creel, said first creel having a first side defining a working front and a standby front, and a second side, defining a working front and a standby front, said second creel, having said first side, defining a working front and a standby front, and a second side, defining a working front and a standby front, **characterized in that** said method comprises the steps of creeling and uncreeling said first and second creels in an automatized manner from a centralized operating position outside of and separated from said first and second creels, said centralized position defining a respective standby front and a respective working front, and said steps of creeling and uncreeling said first and second working creels including at least a first step of replacing full or partial bobbins with empty tubes or partial bobbins and at least a second step of unloading empty tubes or partial bobbins and loading full or partial bobbins

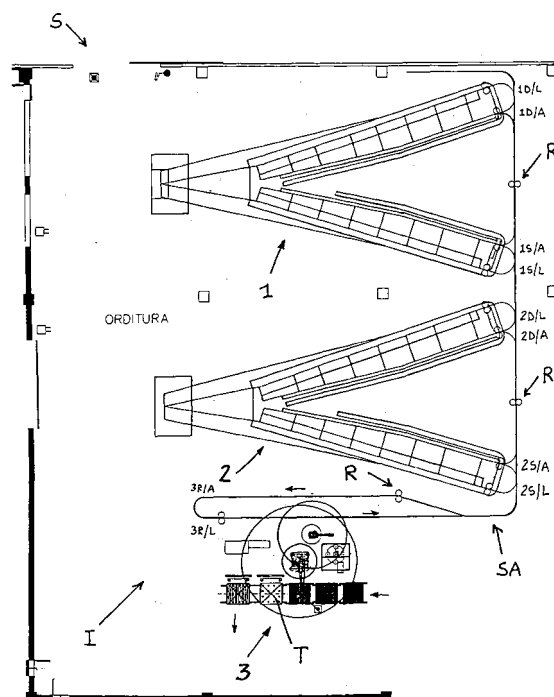


Fig. 1



EUROPEAN SEARCH REPORT

Application Number
EP 08 01 6688

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (IPC)
X	US 4 515 328 A (PAYNE JR WILLIAM M [US]) 7 May 1985 (1985-05-07) * abstract * * column 3, line 66 - column 5, line 5 * * column 8, lines 14-23 * * column 8, line 33 - column 9, line 57 * * figures 1-11 *	1-10	INV. D02H1/00 B65H49/14
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X	----- EP 0 678 469 A2 (SUCKER MUELLER HACоба GMBH [DE] SUCKER MUELLER HACоба GMBH) 25 October 1995 (1995-10-25) * abstract * * column 5, line 15 - column 6, line 39 * * figures 1-5 *	1-6	
			TECHNICAL FIELDS SEARCHED (IPC)
			B65H D02H
The present search report has been drawn up for all claims			
Place of search Munich		Date of completion of the search 8 October 2010	Examiner Louter, Petrus
<p>CATEGORY OF CITED DOCUMENTS</p> <p>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</p> <p>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</p> <p>& : member of the same patent family, corresponding document</p>			

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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.
The members are as contained in the European Patent Office EDP file on
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