



(12) **EUROPEAN PATENT APPLICATION**

(43) Date of publication:
20.04.2011 Bulletin 2011/16

(51) Int Cl.:
B65H 9/10 ^(2006.01) **B65H 23/032** ^(2006.01)
B65H 39/16 ^(2006.01)

(21) Application number: **09013047.7**

(22) Date of filing: **15.10.2009**

(84) Designated Contracting States:
AT BE BG CH CY CZ DE DK EE ES FI FR GB GR HR HU IE IS IT LI LT LU LV MC MK MT NL NO PL PT RO SE SI SK SM TR
 Designated Extension States:
AL BA RS

(72) Inventor: **Tzu-Che, Lin**
Taipei Hsien (TW)

(74) Representative: **Glawe, Delfs, Moll**
Patent- und Rechtsanwälte
Rothenbaumchaussee 58
20148 Hamburg (DE)

(71) Applicant: **Tzu-Che, Lin**
Taipei Hsien (TW)

Remarks:
 Amended claims in accordance with Rule 137(2) EPC.

(54) **Edge alignment control apparatus for sheet material**

(57) An edge alignment control apparatus for correcting vertical alignment of sheet members is disclosed to include two base units each having multiple first power drives controllable to reciprocate a respective horizontal reciprocating member, and adjustment units arranged between the base units, each adjustment unit having two holder blocks connected to the horizontal reciprocating members of the base units at one same elevation and movable by the respective horizontal reciprocating mem-

bers horizontally, sheet-transfer rollers pivotally connected between the holder blocks, a bearing board connected between the holder blocks for receiving a sheet member from the sheet-transfer rollers and a suction hood suspending above the bearing board and defining with the bearing board a passage for the passing of a sheet member and controllable to suck up a sheet member from the bearing board for allowing adjustment of the position of the sheet member horizontally subject to the operation of the first power drive.

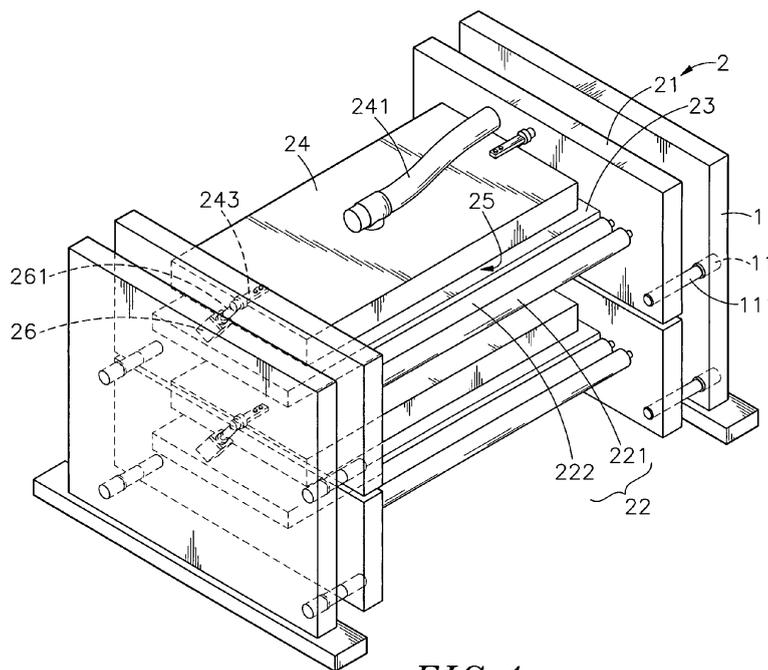


FIG. 1

Description**BACKGROUND OF THE INVENTION****1. Field of the Invention:**

[0001] The present invention relates to corrugated paper board fabrication technology and more particularly, to an edge alignment control apparatus for sheet material that allows quick correction of vertical alignment of sheet members to be glued.

2. Description of the Related Art:

[0002] Following the progress of time and the development of industry and business, product market competition is severe. In addition to cheap cost, quality control is one of the requisite factors to survive in the market. Manufacturers commonly utilize automatic production equipment to fabricate products instead of conventional machines, enhancing the productivity and improving the yield rate.

[0003] Following improvement of people's living standards and the rise of environmental protection consciousness, paper material is intensively used for packing or wrapping commercial products. Corrugated paper boards are intensively used for making cartons and boxes for the advantages of high strength and shock absorbing characteristics. Further, corrugated paper board facilitates printing. Using a carton or a box of a corrugated paper board for packing commercial products for storage and delivery can well protect the products against damage.

[0004] The fabrication of a corrugated paper board requires a series of processes, including paper receiving, pre-heating, corrugated paper forming, gluing, cooling, stamping, trimming, cutting and stacking. Regular corrugated paper boards may have a different number of layers, such as 3 ply, 5 ply, 7 ply or 10 ply. When bonding two paper sheet members with glue, the paper sheet members must be kept in perfect alignment as they are being delivered forwards at different elevations. If one of the paper sheet members is deviated from the course, the glued product will become defective. A defective paper board may be trimmed. However, this extra trimming process complicates the fabrication and increases the labor cost. Further, the reduced size of the trimmed paper board may not meet the requirement.

[0005] Therefore, it is desirable to provide a measure or apparatus that can control the alignment of paper sheet members to be glued.

SUMMARY OF THE INVENTION

[0006] The present invention has been accomplished under the circumstances in view. It is one object of the present invention to provide an edge alignment control apparatus for sheet material, which controls accurate

alignment of sheet members to be glued.

[0007] To achieve this and other objects of the present invention, an edge alignment control apparatus for sheet material comprises two base units, and adjustment units arranged between the base units. Each base unit comprises multiple first power drives controllable to reciprocate a respective horizontal reciprocating member. Each adjustment unit comprises two holder blocks connected to the horizontal reciprocating members of the base units at one same elevation and movable by the respective horizontal reciprocating members horizontally, rollers pivotally connected between the holder blocks for transferring a sheet member, a bearing board connected between the holder blocks for receiving a sheet member from the rollers and a suction hood suspending above the bearing board and defining with the bearing board a passage for the passing of a sheet member and controllable to suck up a sheet member from the bearing board for allowing adjustment of the position of the sheet member horizontally subject to the operation of the first power drive. By means of operating the first power drives to reciprocate the respective reciprocating members, the position of the sheet member that is sucked up by the suction hood is relatively adjusted.

[0008] Further, second power drives are respectively mounted on the holder blocks of each adjustment unit and controllable to reciprocate respective reciprocating members that are respectively vertically connected to respective connectors at the suction hood of the respective adjustment unit. When the sheet member that is fed into the passage between the bearing board and suction hood of one adjustment unit is jammed in the passage, the operator can operate the second power drives to adjust the elevation of the suction hood, thereby eliminating the paper jam problem.

[0009] Further, multiple adjustment units can be arranged in an array between the two base units so that the front-sided adjustment unit and the rear-sided adjustment units can be separately adjusted, doubling the adjustable adjustment range.

BRIEF DESCRIPTION OF THE DRAWINGS**[0010]**

FIG. 1 is a perspective view of an edge alignment control apparatus for sheet material in accordance with the present invention.

FIG. 2 is a schematic front view of the edge alignment control apparatus for sheet material in accordance with the present invention.

FIG. 3 is a schematic drawing of the present invention showing two sheet members fed into the edge alignment control apparatus before alignment adjustment.

FIG. 4 corresponds to FIG. 3, showing the adjustment units adjusted and the sheet members in perfect alignment.

FIG. 5 is a schematic sectional side view of the present invention, showing the suction hood of the upper-sided adjustment unit lifted relative to the respective bearing board.

FIG. 6 is a perspective view of a part of an alternate form of the edge alignment control apparatus for sheet material in accordance with the present invention.

FIG. 7 is a schematic top view of the edge alignment control apparatus shown in FIG. 6, showing the front-sided adjustment unit adjusted.

FIG. 8 corresponds to FIG. 7, showing the rear-sided adjustment unit adjusted.

DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENT

[0011] Referring to FIGS. 1 and 2, an edge alignment control apparatus for sheet material in accordance with the present invention is shown comprising two base units **1** arranged in parallel at two opposite lateral sides and a plurality of adjustment units **2** arranged at different elevations between the two base units **1**.

[0012] Each base unit **1** comprises a plurality of first power drives **11** and controllable to reciprocate a respective horizontal reciprocating member **111**.

[0013] Each adjustment unit **2** comprises two holder blocks **21** respectively connected to the horizontal reciprocating members **111** of the two base units **1** at one same elevation and movable by the respective horizontal reciprocating members **111**, a conveying mechanism **22**, which comprises a first roller **221** and a second roller **222** pivotally connected between the two holder blocks **21**, a bearing board **23** connected between the two holder blocks **21** at one lateral side relative to the second roller **222** and opposite to the first roller **221**, a suction hood **24**, which has a plurality of suction holes **242** arranged at the bottom side thereof and facing the bearing board **23**, an air pipe **241** disposed at the top side thereof and two connectors **243** located on two opposite lateral sides thereof, a passage **25** defined between the bearing board **23** and the suction hood **24** and two second power drives **26** that respectively mounted on the holder blocks **21** and controllable to reciprocate respective reciprocating members **261** that are respectively vertically connected to the connectors **243**.

[0014] Referring to FIGS. 3-5 and FIGS. 1 and 2 again, during operation of the edge alignment control apparatus, a first sheet member **3** is delivered by the first roller **221** and second roller **222** of the conveying mechanism **22** of the upper-sided one of the adjustment units **2** into the passage **25** between the associating bearing board **23** and the associating suction hood **24**, and a second sheet member **4** is delivered by the first roller **221** and second roller **222** of the conveying mechanism **22** of the lower-sided one of the adjustment units **2** into the passage **25** between the associating bearing board **23** and the associating suction hood **24**.

[0015] The aforesaid first sheet member **3** and second sheet member **4** are to be glued together. If the first sheet member **3** and the second sheet member **4** are not kept in perfect alignment during gluing, the glued product will become defective. Sensor means (not shown) is applied to detect the position of the first sheet member **3** and the position of the second sheet member **4**. If one sheet member, for example, the first sheet member **3** is deviated from the position, a suction pump (not shown) is operated to draw air from the passage **25** of the respective adjustment unit **2** into the suction holes **242** of the respective suction hood **24** toward the respective air pipe **241**, thereby sucking up the first sheet member **3**. Thereafter, operate the respective first power drives **11** to extend out or retract the respective horizontal reciprocating member **111**, thereby moving the holder blocks **21** of the respective adjustment unit **2** leftwards or rightwards to the desired position. Because the first sheet member **3** is secured to the suction hook **24** by an air suction force, adjusting the horizontal position of the adjustment unit **2** causes adjustment of the horizontal position of the first sheet member **3**. Adjustment of the horizontal position of the second sheet member **4** can be done in the same manner. Thus, the first sheet member **3** and the second sheet member **4** can be adjusted into perfect alignment conveniently.

[0016] In the embodiment shown in FIGS. 1-5, the edge alignment control apparatus comprises two base units **1** and two adjustment units **2** arranged at different elevations between the two base units **1**. This embodiment is adapted for delivering two sheet members for gluing into a **2** ply paper board. The number of the adjustment units **2** between the two base units **1** may be relatively changed for application to produce **3**, **5**, **7** or **10** ply corrugated paper boards.

[0017] Referring to FIGS. 1-5 again, during corrugated paper board production, the first sheet member **3** or second sheet member **4** may be damaged. If one sheet member, for example, the first sheet member **3** has a damaged part that protrudes upwards, the damaged part may be jammed in the passage **25**, causing interruption of delivery of the first sheet member **3**. In this case, operate the second power drives **26** of the respective adjustment unit **2** to extend out the respective reciprocating members **261** vertically and to further lift the connectors **243** and the respective suction hood **24**, thereby increasing the vertical height of the passage **25**. Thus, the operator can move the first sheet member **3** from the passage **25** and cut off or trim the damaged part. After troubleshooting, the first sheet member **3** can be fed into the production line again. Further, the air pipe **241** of the suction hood **24** of each adjustment unit **2** is a flexible pipe so that adjusting the elevation of the suction hood **24** does not cause the air pipe **241** to break. In case the second sheet member **4** is jammed in the passage **25** of the respective adjustment unit **2** during its delivery, this problem of paper jam can be eliminated in the same manner within a short time. Further, in the aforesaid embodiment, the second

power drives **26** are controlled to extend out or retract the respective reciprocating members **261** in vertical. Alternatively, the second power drives **26** can be arranged to reciprocate the reciprocating members **261** obliquely, moving the respective suction hood **24** upwardly upwards or downwards.

[0018] FIGS. 6–8 show an alternate form of the edge alignment control apparatus for sheet material according to the present invention. According to this embodiment, four adjustment units **2** are arranged in two pairs at two different elevations between the two base units **1**. The adjustment units **2** can simply be adjusted horizontally within a limited range (for example, 2mm or 3mm). If the first sheet member **3** or second sheet member **4** is deviated from the course over the adjustment range of one adjustment unit **2** (for example, 4mm or 6mm from the course), the operator can operate the front-sided adjustment unit **2** to adjust the position of the first sheet member **3** or second sheet member **4**, and then operate the rear-sided adjustment unit **2** to adjust the position of the first sheet member **3** or second sheet member **4** further. Thus, the adjustment range is doubled.

[0019] In conclusion, the invention provides an edge alignment control apparatus for sheet material, which has the following advantages and features:

1. When the suction hood **24** of one adjustment unit **2** is operated to suck up the first sheet member **3** or second sheet member **4**, the corresponding first power drives **11** can be operated to extend out or retract the respective horizontal reciprocating members **111**, thereby moving the holder blocks **21** of the respective adjustment unit **2** leftwards or rightwards to adjust the first sheet member **3** or second sheet member **4** into perfect alignment with the second sheet member **4** or first sheet member **3** for accurate gluing.
2. If the first sheet member **3** or second sheet member **4** is jammed in the passage **25** between the bearing board **23** and the suction hood **24**, the corresponding second power drives **26** can be operated to extend out the respective reciprocating members **261** in lifting the suction hood **25** so that the paper jam problem can be eliminated quickly.
3. Multiple adjustment units **2** can be arranged at front and rear sides at two different elevations between the two base units **1** such that the front-sided adjustment units and the rear-sided adjustment units can be separately adjusted, doubling the adjustment range.

[0020] A prototype of edge alignment control apparatus for sheet material has been constructed with the features of FIGS. 1–8. The edge alignment control apparatus for sheet material functions smoothly to provide all of the features disclosed earlier.

[0021] Although a particular embodiment of the invention has been described in detail for purposes of illustra-

tion, various modifications and enhancements may be made without departing from the spirit and scope of the invention. Accordingly, the invention is not to be limited except as by the appended claims.

Claims

1. An edge alignment control apparatus for correcting vertical alignment of sheet members, comprising:

two base units arranged in parallel at two opposite lateral sides, each said base unit comprising a plurality of first power drives controllable to reciprocate a respective horizontal reciprocating member; and

a plurality of adjustment units arranged between said two base units, each said adjustment unit comprising two holder blocks respectively connected to horizontal reciprocating members of said base units at one same elevation and movable by the respective horizontal reciprocating members horizontally, a conveying mechanism, said conveying mechanism comprising a first roller pivotally connected between said two holder blocks, a bearing board connected between said two holder blocks at one side relative to said first roller, a suction hood suspending above said bearing board and controllable to suck up a sheet member from said bearing board, and a passage defined between said bearing board and said suction hood for the passing of a sheet member.

2. The edge alignment control apparatus as claimed in claim 1, wherein said conveying mechanism further comprises a second roller pivotally connected between said two holder blocks and arranged between said first roller and said bearing board.

3. The edge alignment control apparatus as claimed in claim 1, wherein said suction hood comprises a plurality of suction holes arranged at a bottom side thereof and facing said bearing board and an air pipe disposed at a top side thereof in air communication with said suction holes.

4. The edge alignment control apparatus as claimed in claim 1, wherein each said adjustment unit further comprises two connectors located on two opposite lateral sides of the suction hood thereof, two second power drives respectively mounted on the holder blocks thereof, and two reciprocating members respectively connected to said connectors and movable by said second power drives to adjust the elevation of the suction hood of the respective adjustment unit relative to the bearing board of the respective adjustment unit.

5. The edge alignment control apparatus as claimed in claim 1, wherein said adjustment units are arranged in an array between said two base units.

unit relative to the bearing board of the respective adjustment unit (2).

Amended claims in accordance with Rule 137(2) EPC.

5

4. The edge alignment control apparatus as claimed in claim 1, **characterized in that** said adjustment units (2) are arranged in an array between said two base units (1).

1. An edge alignment control apparatus for correcting alignment of sheet members (3, 4), comprising:

10

two base units (1) arranged in parallel at two opposite lateral sides, each said base unit (1) comprising a plurality of first power drives (11) controllable to reciprocate a respective horizontal reciprocating member (111); and a plurality of adjustment units (2) arranged between said two base units (1), each said adjustment unit (2) comprising two holder blocks (21) respectively connected to horizontal reciprocating members (111) of said base units (1) at one same elevation and movable by the respective horizontal reciprocating members (111) horizontally, **characterized by** a conveying mechanism (22) comprising a first roller (221) pivotally connected between and to said two holder blocks (21), a bearing board (23) connected between and to said two holder blocks (21) at one side relative to said first roller (221), a suction hood (24) suspending above said bearing board (23) and controllable to suck up a sheet member (3, 4) from said bearing board (23), and a passage (25) defined between said bearing board (23) and said suction hood (24) for the passing of a sheet member (3, 4), wherein said suction hood (24) comprises a plurality of suction holes (242) arranged at a bottom side thereof and facing said bearing board (23) and an air pipe (241) disposed at a top side thereof in air communication with said suction holes (242).

15

20

25

30

35

40

2. The edge alignment control apparatus as claimed in claim 1, **characterized in that** said conveying mechanism (22) further comprises a second roller (222) pivotally connected between said two holder blocks (21) and arranged between said first roller (221) and said bearing board (23).

45

3. The edge alignment control apparatus as claimed in claim 1, **characterized in that** each said adjustment unit (2) further comprises two connectors (243) located on two opposite lateral sides of the suction hood (24) thereof, two second power drives (26) respectively mounted on the holder blocks (21) thereof, and two reciprocating members (261) respectively connected to said connectors (243) and movable by said second power drives (26) to adjust the elevation of the suction hood (24) of the respective adjustment

50

55

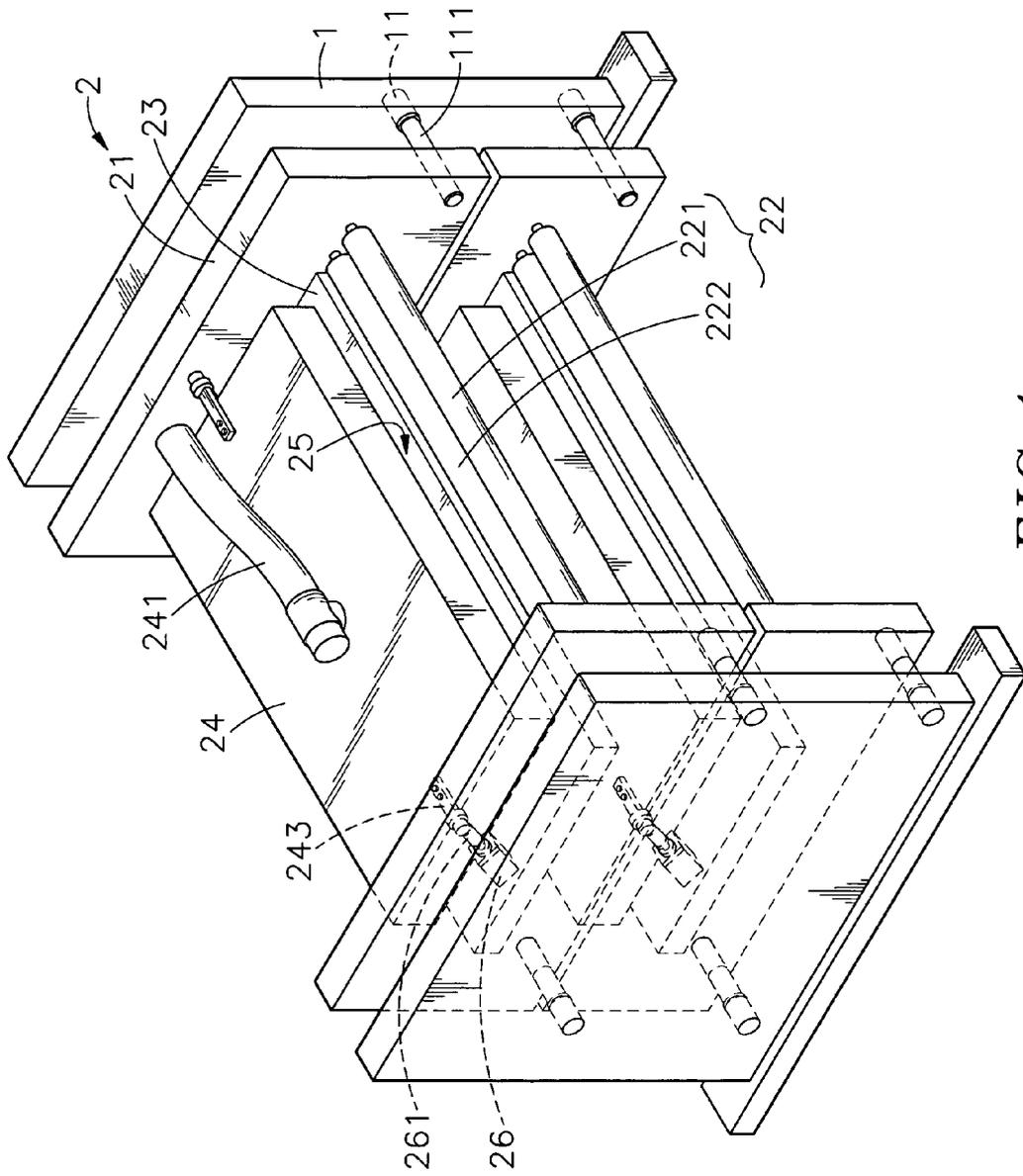


FIG. 1

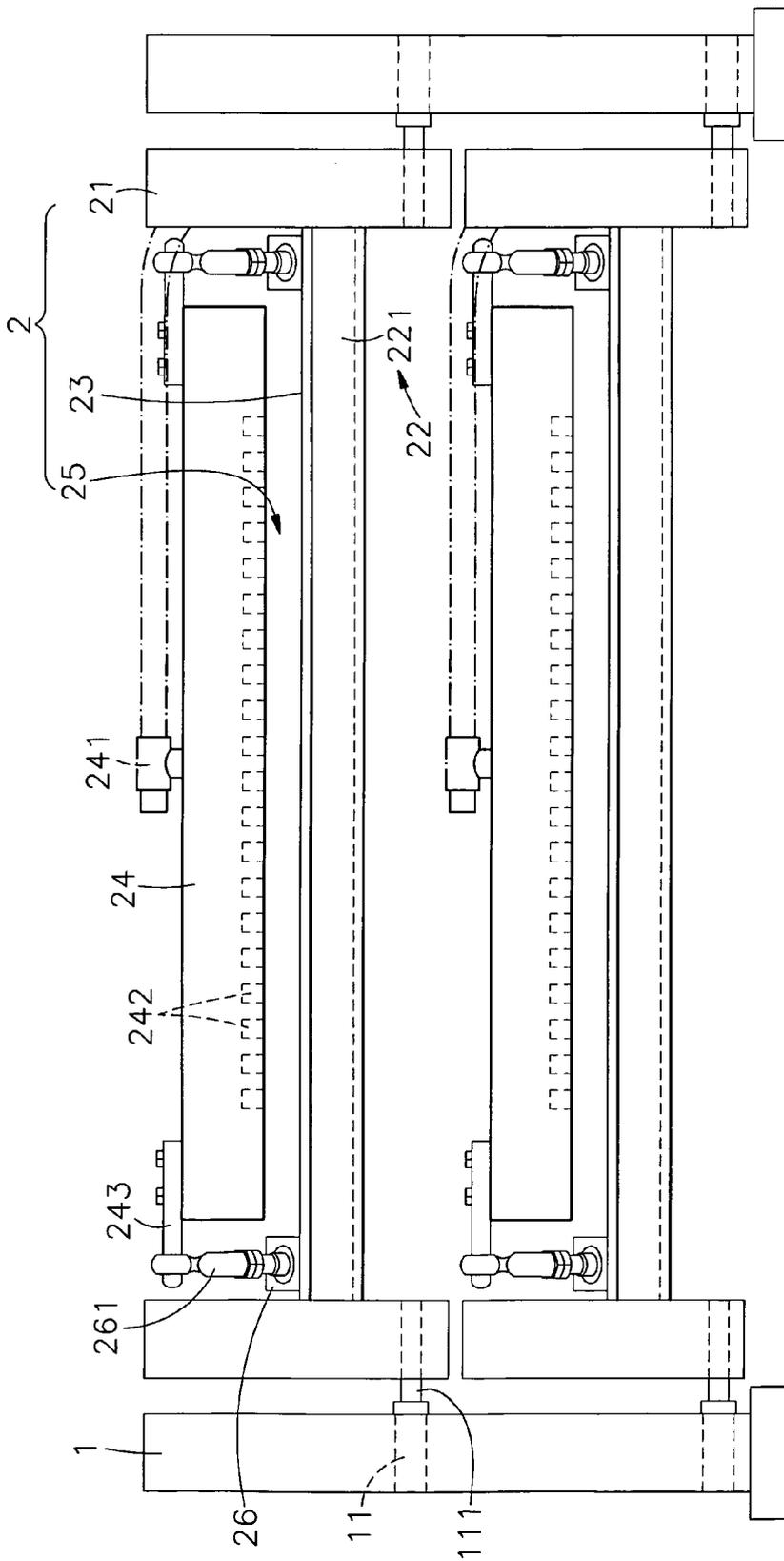


FIG. 2

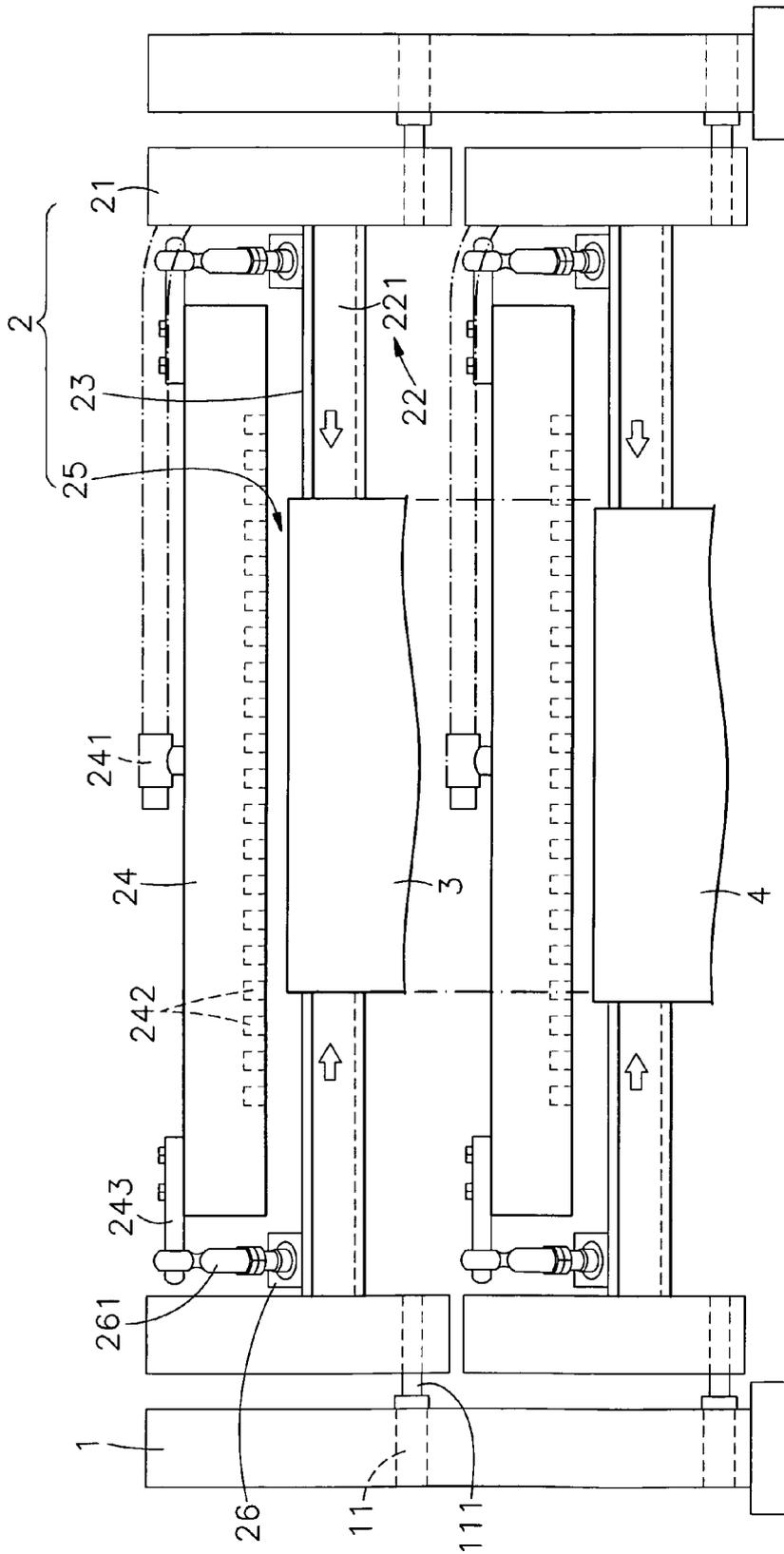


FIG. 3

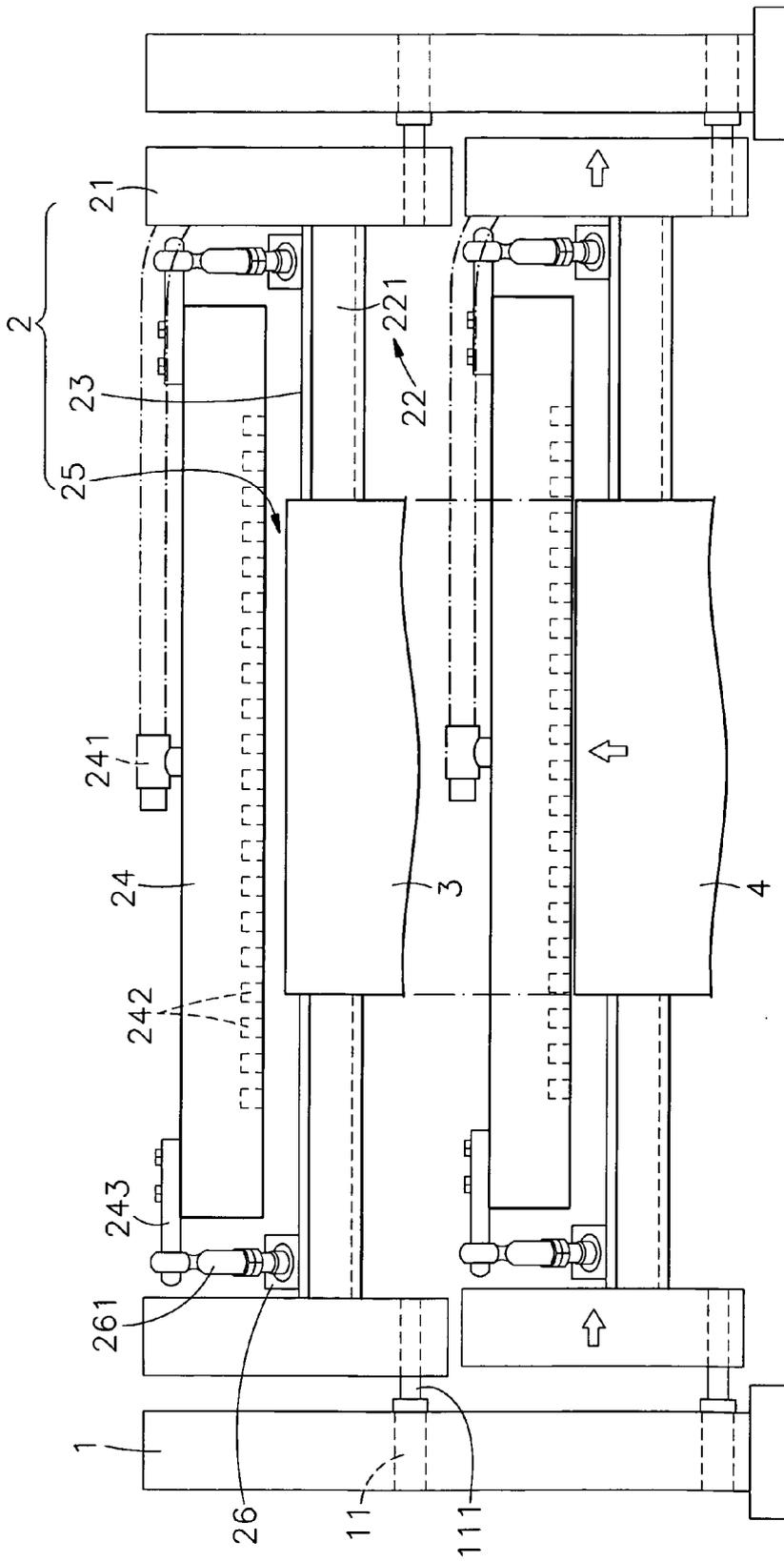


FIG. 4

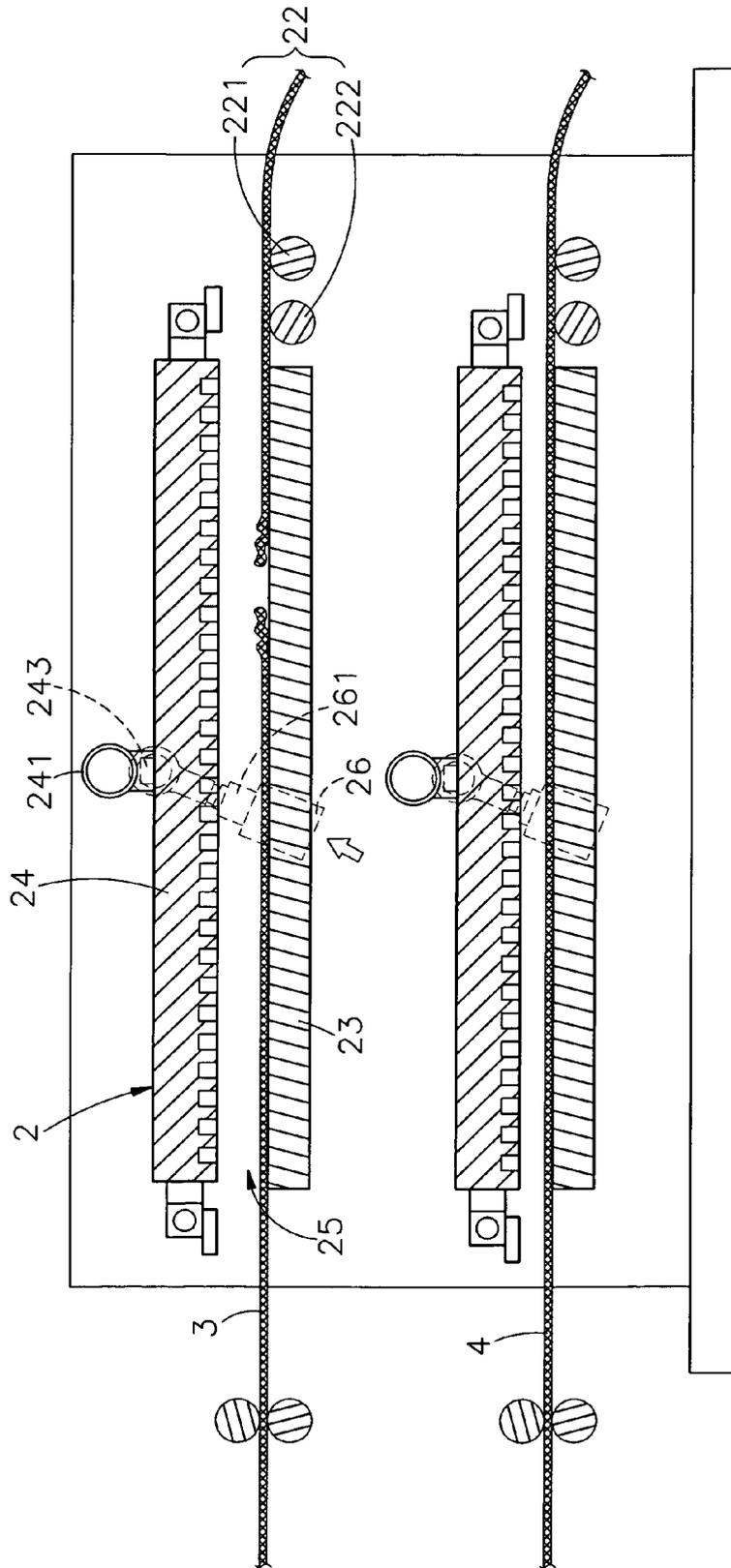


FIG.5

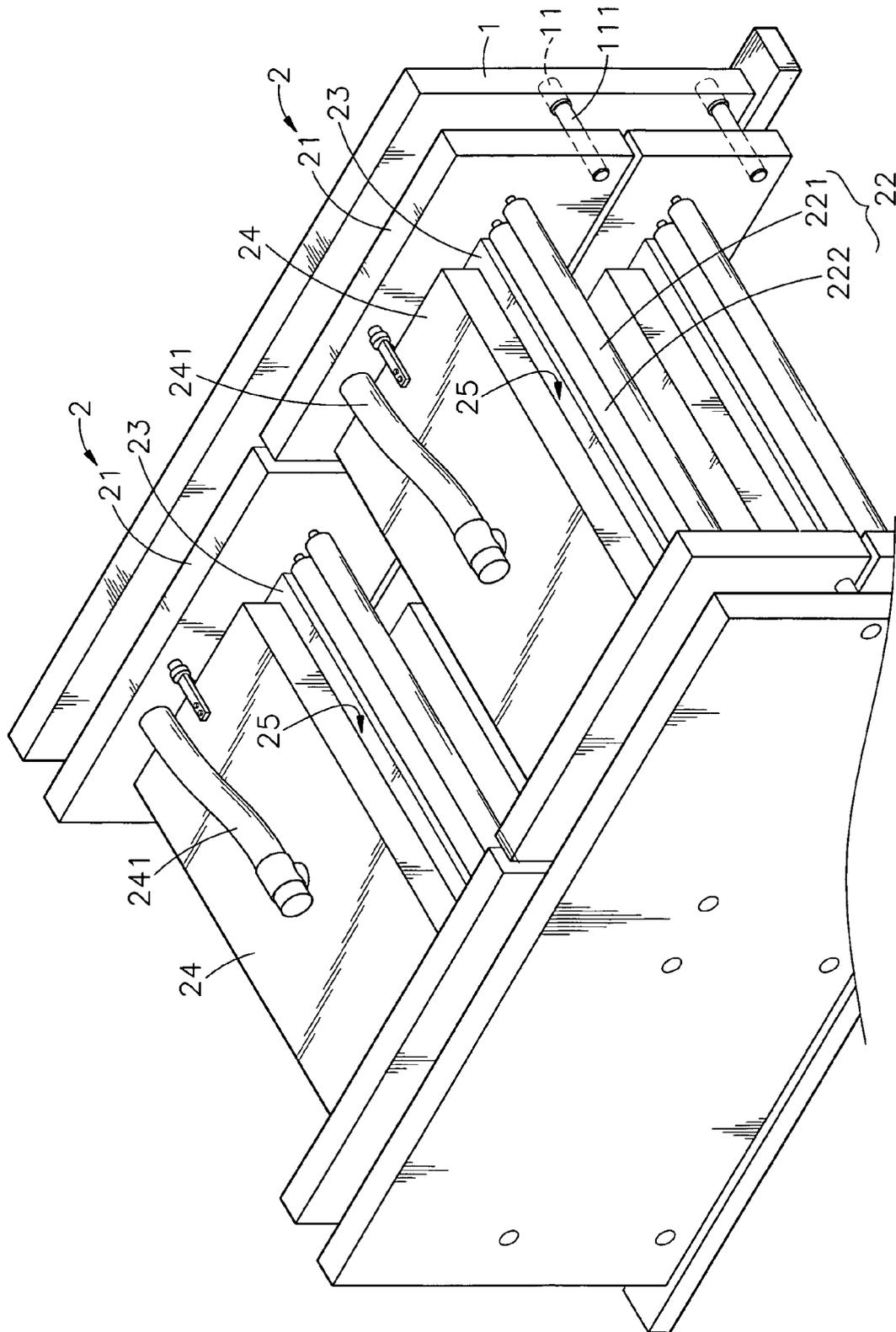


FIG. 6

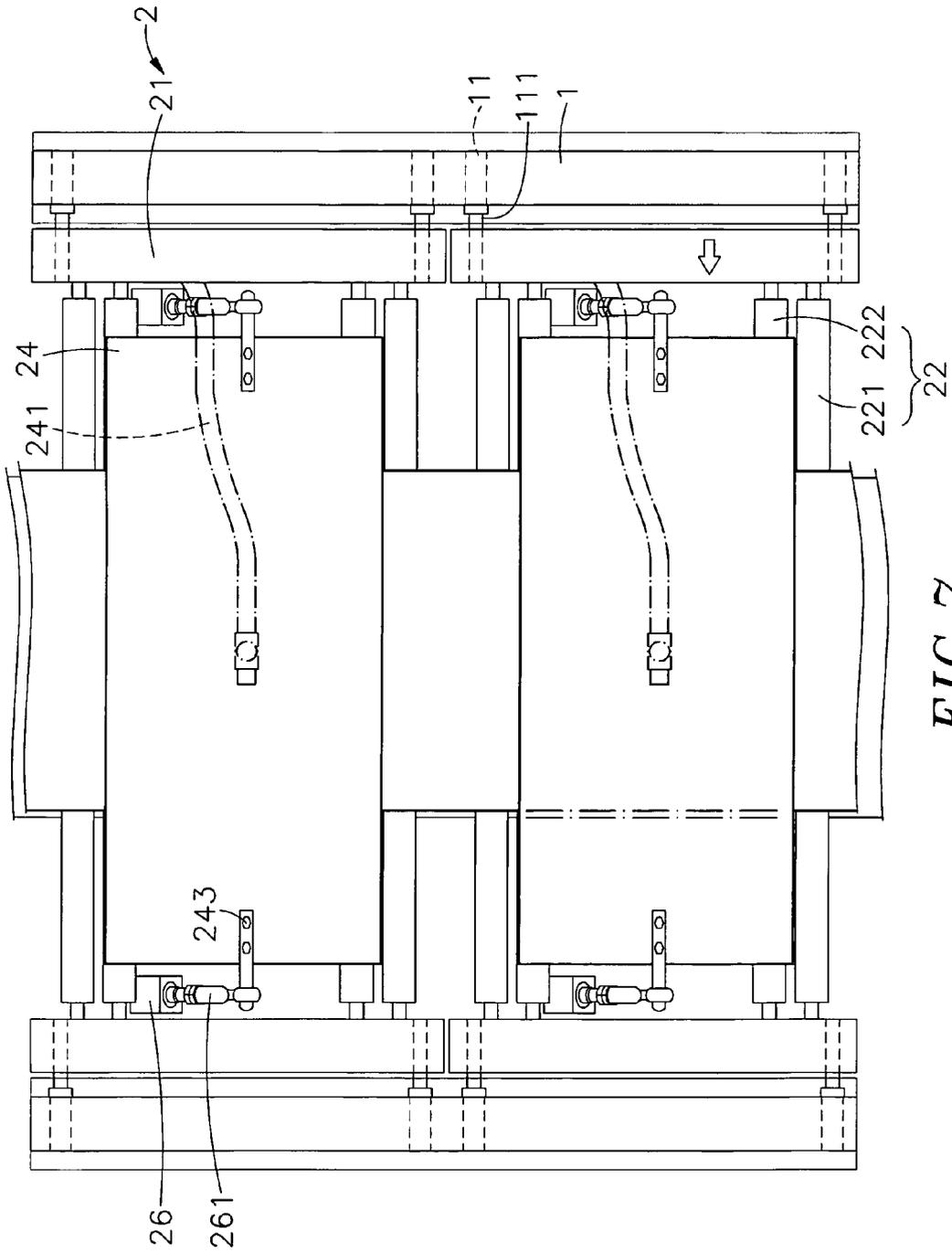


FIG. 7

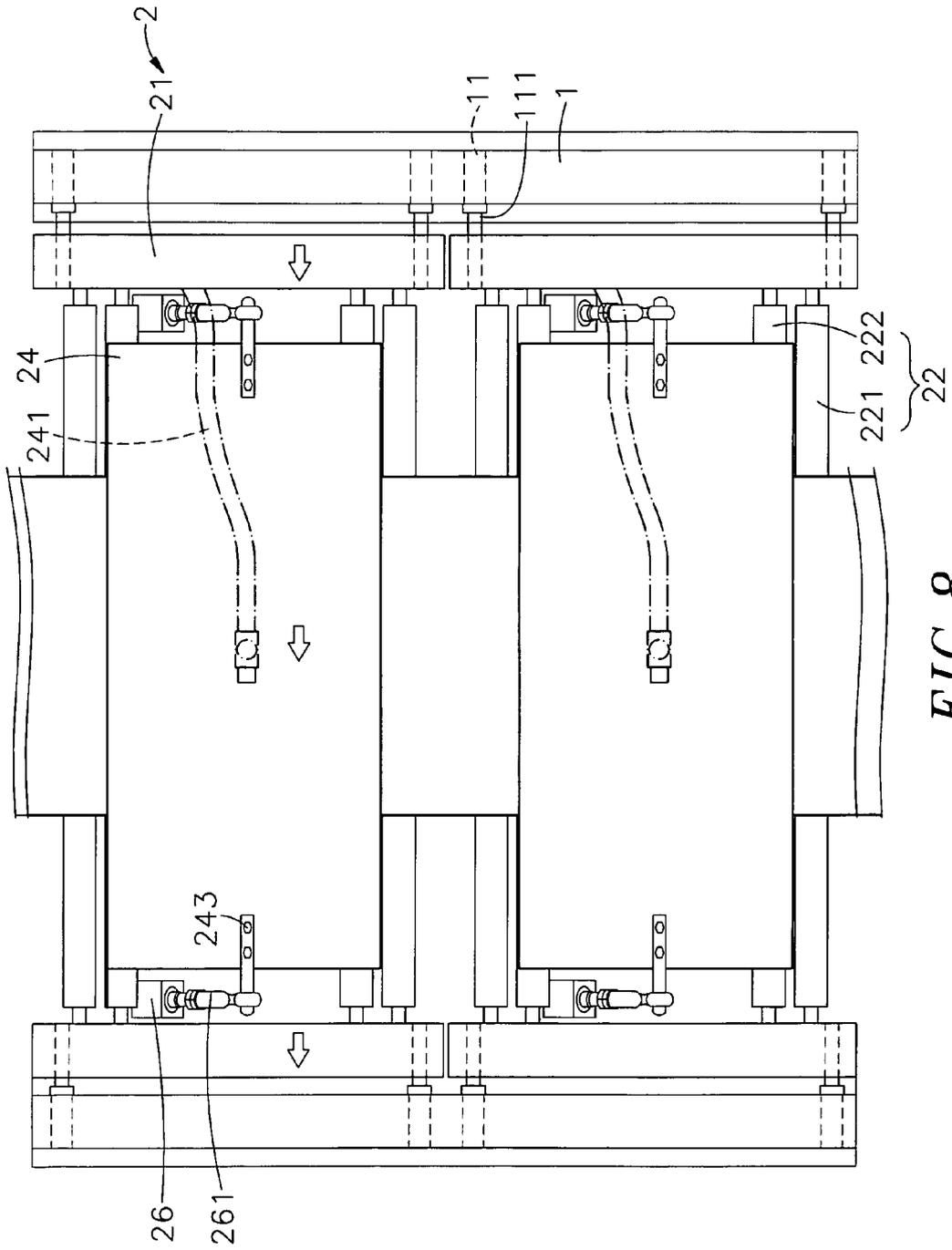


FIG. 8



EUROPEAN SEARCH REPORT

Application Number
EP 09 01 3047

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (IPC)
Y	US 4 369 905 A (TOKUNO MASATERU [JP]) 25 January 1983 (1983-01-25) * abstract; figures 1-9, 13,14 * * column 1, lines 5-23 * * column 2, line 47 - column 3, line 45 * * column 8, lines 3-8 * -----	1-5	INV. B65H9/10 B65H23/032 B65H39/16
Y	DE 33 02 873 A1 (MABEG MASCHINENBAU GMBH NACHF [DE]) 2 August 1984 (1984-08-02) * abstract; figures 1-6 * * the whole document * -----	1-5	
A	DE 10 2004 021213 A1 (ROLAND MAN DRUCKMASCH [DE]) 24 November 2005 (2005-11-24) * the whole document * -----	1-5	
A	US 5 499 806 A (BOURG CHRISTIAN-P [BE]) 19 March 1996 (1996-03-19) * abstract; figures 1-3 * * column 3, line 5 - column 4, line 32 * -----	1-5	
A	US 4 694 181 A (PILLER RICHARD G [US]) 15 September 1987 (1987-09-15) * abstract; figures 1-3 * * column 4, line 50 - column 6, line 6 * -----	1-5	
The present search report has been drawn up for all claims			TECHNICAL FIELDS SEARCHED (IPC)
			B65H
1	Place of search The Hague	Date of completion of the search 12 March 2010	Examiner Piekarski, Adam
CATEGORY OF CITED DOCUMENTS		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	
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			

EPO FORM 1503 03.82 (F04C01)

ANNEX TO THE EUROPEAN SEARCH REPORT
ON EUROPEAN PATENT APPLICATION NO.

EP 09 01 3047

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
The European Patent Office is in no way liable for these particulars which are merely given for the purpose of information.

12-03-2010

Patent document cited in search report		Publication date	Patent family member(s)	Publication date
US 4369905	A	25-01-1983	AT 381473	B 27-10-1986
			AU 537959	B2 19-07-1984
			AU 6503580	A 11-06-1981
			CA 1160322	A1 10-01-1984
			CH 642002	A5 30-03-1984
			DE 3045951	A1 03-09-1981
			FR 2471442	A1 19-06-1981
			GB 2064490	A 17-06-1981
			IT 1134587	B 13-08-1986
			JP 56089541	A 20-07-1981
			MX 149347	A 25-10-1983
			NL 8006652	A 01-07-1981
			NZ 195743	A 30-11-1983
			SE 447986	B 12-01-1987
			SE 8008421	A 06-06-1981
ZA 8007392	A 28-04-1982			

DE 3302873	A1	02-08-1984	NONE	

DE 102004021213	A1	24-11-2005	NONE	

US 5499806	A	19-03-1996	AT 153983	T 15-06-1997
			DE 69403540	D1 10-07-1997
			DE 69403540	T2 13-11-1997
			DK 619259	T3 01-12-1997
			EP 0619259	A1 12-10-1994
			ES 2104216	T3 01-10-1997
			FR 2703670	A1 14-10-1994
			GR 3024175	T3 31-10-1997
			JP 7033272	A 03-02-1995

US 4694181	A	15-09-1987	NONE	

EPO FORM P0459

For more details about this annex : see Official Journal of the European Patent Office, No. 12/82